

CR 90-205

STATE OF WISCONSIN )  
 ) ss.  
DEPARTMENT OF AGRICULTURE )  
TRADE AND CONSUMER PROTECTION )

TO ALL TO WHOM THESE PRESENTS SHALL COME, GREETINGS:

I, Steven B. Steinhoff, Administrator, Food Division, State of Wisconsin Department of Agriculture, Trade and Consumer Protection, and custodian of the official records of said Division, do hereby certify that the annexed order creating and amending rules relating to meat and meat product inspection, processing and labeling requirements for licensed meat establishments, Chapter Ag 47, Wis. Adm. Code, were duly adopted by the Department on August 22, 1991.

I further certify that said copy has been compare by me with the original on file in the Department and that the same is a true copy thereof, and of the whole of such original.

IN TESTIMONY WHEREOF, I have hereunto set my hand and affixed the official seal of the Department at the Department offices in the city of Madison, this 22nd day of August, 1991.



*Steven B. Steinhoff*  
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Steven B. Steinhoff  
Administrator, Food Division

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ORDER  
OF THE STATE OF WISCONSIN DEPARTMENT OF AGRICULTURE,  
TRADE AND CONSUMER PROTECTION  
ADOPTING, AMENDING OR REPEALING RULES

1 The state of Wisconsin department of agriculture, trade and  
2 consumer protection adopts the following order to renumber Ag  
3 47.02(5) through (23); to amend Ag 47.03(1)(a), Ag 47.08(2)(a),  
4 (b) and (d), Ag 47.12, and Ag 47.16(6)(a) and (8)(a); to repeal  
5 and recreate Ag 47.09(1)(b) and Ag 47.11; and to create Ag  
6 47.02(8) and Ag 47.105, relating to meat and meat product  
7 inspection, processing and labeling requirements for licensed  
8 meat establishments.

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Analysis Prepared by the Department of Agriculture,  
Trade and Consumer Protection

Statutory authority: ss. 93.07(1) and 97.42(4), Wis. Stats.

Statutes interpreted: s. 97.42, Wis. Stats.

This rule establishes slaughtering, processing, inspection and labeling requirements for game animals sold for food. Game animals are defined as deer, buffalo or other non-domestic animals used for food. There has been an increased demand by consumers to purchase inspected buffalo and deer meat and meat products. Inspection will be performed on a fee for service basis with the cost of inspection paid by the meat establishment where the inspection is conducted.

The rule revises current requirements for treating pork products to destroy trichinae. The rule includes time and temperature tables which set forth internal temperatures for heating and freezing pork. The tables specify the minimum length of time that the pork must be held at each temperature to destroy trichinae. These changes correspond to recent U. S. Department of Agriculture (USDA) revisions for federally inspected meat establishments.

The rule also makes a number of other changes in current rules related to the processing and labeling of meat. Under the rule, if custom processed sausages are placed in a properly labeled, closed and sealed container intended for a single customer, the sausages need not be individually marked. The rule

incorporates by reference USDA requirements for canning meat and poultry products with heat processing. The rule also makes certain technical and editorial changes to current rules.

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1 SECTION 1. Ag 47.02(5) and (6) are renumbered (6) and (7),  
2 Ag 47.02(23) is renumbered (5), and Ag 47.02(7) to (22) are  
3 renumbered (9) to (24).

4 SECTION 2. Ag 47.02(8) is created to read:

5 Ag 47.02(8) "Game animal" means deer, buffalo or other non-  
6 domestic animals used for food.

7 SECTION 3. Ag 47.03(1)(a) is amended to read:

8 Ag 47.03(1)(a) Every establishment shall be maintained and  
9 operated in conformity with the requirements of this section and  
10 the standards set forth in "U. S. Inspected Meat and Poultry  
11 Packing Plants -- A Guide to Construction and Layout" (Revised  
12 1987), "Federal Facilities Requirements for Small Existing Meat  
13 Plants" (Revised 1985), and "Sanitation Handbook for Meat and  
14 Poultry Inspectors" (Revised 1982) published by the U. S.  
15 Department of Agriculture, Food Safety and Inspection Service.

**Note:** Copies of U. S. Department of Agriculture standards incorporated by reference in sub.(1)(a) may be obtained from the Superintendent of Documents, U. S. Government Printing Office, Washington, D. C. 20402. Copies are on file in the offices of the department, the secretary of state and the revisor of statutes.

16 SECTION 4. Ag 47.08(2)(a), (b) and (d) are amended to read:

17 Ag 47.08(2)(a) Any ~~composed~~ meat or poultry ~~feed~~ product  
18 sold or offered for sale ~~must~~ shall bear an appropriate label  
19 stating the true name of the product; the product ingredients, if  
20 applicable; the name and address of the processor or distributor;

1 the net weight of the product; the inspection legend; and, if the  
2 product is perishable, ~~the words~~ one of the following statements  
3 or a similar perishable warning statement: "Keep Refrigerated",  
4 "Perishable, Keep Under Refrigeration" or "Keep Frozen". This  
5 does not apply to a product prepared and sold at a retail market  
6 and offered for sale at a full service counter if the product is  
7 accompanied by a counter tag showing the name of the product and  
8 a listing of ingredients.

9 (b) All formulas, labels and labeling information used in  
10 the labeling of products in licensed meat establishments shall be  
11 submitted to the department for approval prior to use. The  
12 department may seize and destroy all unauthorized labels.

13 (d) ~~Any non-composited~~ Every meat or poultry product sold  
14 or offered for sale in packaged form as a consumer sized lot in  
15 any self-service sales facility shall bear an appropriate label  
16 showing the true name of the product, an ingredients statement,  
17 the net weight, ~~and~~ the name and address of the processor and, if  
18 the product is perishable, one of the following statements or a  
19 similar perishable warning statement: "Keep Refrigerated",  
20 "Perishable, Keep Under Refrigeration" or "Keep Frozen".

21 SECTION 5. Ag 47.09(1)(b) is repealed and recreated to  
22 read:

23 Ag 47.09(1)(b) Persons engaged in custom slaughtering or  
24 processing, including mobile slaughterers and mobile processors,  
25 shall mark all custom slaughtered and custom processed meat and  
26 meat products in compliance with the following requirements:

1           1. The required mark shall include the name of the slaughter  
2 or processing establishment, or the establishment identification  
3 number assigned by the department, together with the words "NOT  
4 FOR SALE", set forth in block letters not less than 3/8 inch in  
5 height. Stamps, brands and marks for identification of custom  
6 meat and meat products shall be approved by the department. The  
7 required mark shall be in one of the formats shown below:

NOT FOR SALE

NOT FOR SALE

OR

XYZ MARKET

WIS 000

8           2. Each side, quarter, or other part of a carcass, including  
9 detached organs of custom slaughtered or custom processed  
10 animals, shall be legibly marked immediately after slaughter or,  
11 if the animal is not slaughtered at the establishment, at the  
12 time the meat enters the establishment for processing.

13          3. All boxes, cartons, packages or containers of custom  
14 processed meat or meat products shall be marked at the time of  
15 packaging. Ordinary ring variety sausages and large variety  
16 sausage products having a diameter greater than 1½ inches shall  
17 be individually marked if they are individually packaged, or if  
18 they are shipped or stored in unsealed containers. These  
19 sausages need not be individually marked if they are packaged in  
20 a sealed and properly labeled container intended for a single  
21 customer.

22          SECTION 6. Ag 47.105 is created to read:

23          Ag 47.105 VOLUNTARY INSPECTION OF GAME ANIMALS.

24          (1) GENERAL. The operator of a licensed meat establishment

1 may request department inspection of game animals slaughtered at  
2 the licensed establishment. Inspection shall include ante-mortem  
3 and post-mortem inspection as provided in this section. The cost  
4 of inspection will be billed to the meat establishment operator  
5 at the current hourly rate as determined by the department.

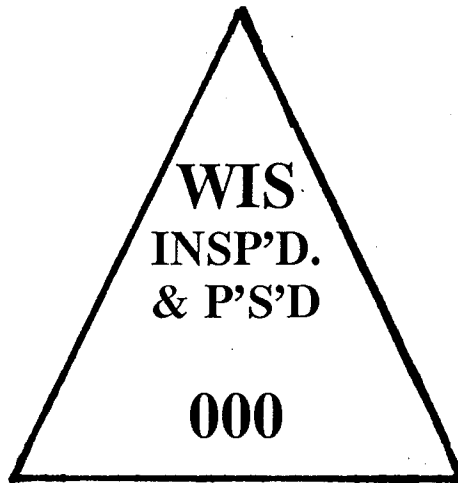
6 (2) ANTE-MORTEM INSPECTION. Ante-mortem inspection of a  
7 game animal shall comply with applicable requirements under  
8 s. Ag 47.16. Ante-mortem inspection may include field  
9 observation of the game animal in motion and at rest. Game  
10 animals shall be bled immediately after stunning. The inspector  
11 shall observe the transportation of each game animal to the  
12 slaughtering establishment to ensure positive identification if  
13 the animal is not otherwise positively identified. Game animals  
14 shall be transported promptly to a slaughtering establishment to  
15 maintain acceptable product condition.

16 (3) POST-MORTEM INSPECTION. Post-mortem inspection of a  
17 game animal shall comply with applicable requirements under  
18 s. Ag 47.17. Post-mortem inspection procedures for buffalo shall  
19 be the same as those used for cattle. Post-mortem inspection  
20 procedures for venison shall be the same as those used for sheep.  
21 The department may prescribe specific post-mortem inspection  
22 procedures for other game animals as appropriate.

23 (4) SANITARY SLAUGHTER AND PROCESSING. Game animals shall  
24 be slaughtered in a sanitary manner. Meat and meat products  
25 obtained from game animals shall be handled and processed in a  
26 sanitary manner. Slaughter and processing shall comply with

1 applicable sanitation requirements under this chapter.

2 (5) INSPECTION MARKS. (a) A department inspector shall  
3 place an inspection mark on each inspected carcass of a game  
4 animal which has passed ante-mortem and post-mortem inspection.  
5 The inspection mark shall be made by an inspection brand approved  
6 under par. (c). The inspection mark shall include the notation  
7 "Wis. Inspected and Passed" and the department-assigned  
8 establishment number of the slaughter establishment at which the  
9 animal was slaughtered. The notation and establishment number  
10 shall be surrounded by a triangle as shown below:



13 (b) Primal parts of buffalo and venison carcasses, buffalo  
14 livers, buffalo hearts and tongues, and venison livers and hearts  
15 which pass post-mortem inspection shall be marked as required  
16 under par. (a).

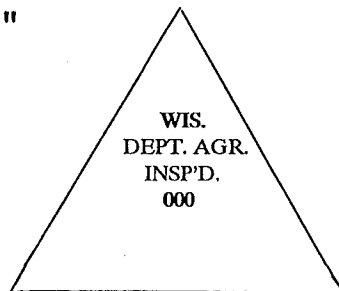
17 (c) Inspection brands shall be approved by the department.  
18 Requests for approval shall be submitted in writing to the  
19 department's Madison office. The department will forward  
20 approved requests to a brand manufacturer who will bill the

1 requesting meat establishment directly. An inspection brand may  
2 only be used under the direct supervision of a department  
3 employee. When not in use for marking, the inspection brand  
4 shall be kept locked in a properly equipped locker or  
5 compartment, the keys to which shall not leave the possession of  
6 a department employee.

7 (6) CONDEMNED CARCASSES OR MEAT PRODUCTS. Carcasses, parts  
8 or meat products from game animals which are inspected and found  
9 unfit for human food shall be slashed and denatured as required  
10 under s. Ag 47.185(1) and marked or branded with the notation  
11 "WIS. INSPECTED AND CONDEMNED" in the format shown below:

WIS. INSP'D. AND  
CONDEMNED

12 (7) LABELING PROCESSED GAME ANIMAL MEAT PRODUCTS. (a) The  
13 label of any processed meat product consisting entirely (100%) of  
14 inspected and passed buffalo, venison or other game animals shall  
15 include an inspection mark consisting of the notation "Wis. Dept.  
16 Agr. Inspected", followed by the establishment number. The  
17 notation and establishment number shall be enclosed within an  
18 equilateral triangle in the format shown below, except that it  
19 need not be of the size illustrated, provided that it is of  
20 sufficient size as to be conspicuously displayed and readily  
21 legible. If space is limited, the word "Inspected" may be  
22 abbreviated as "INSP'D."





1 (b) The label for a processed meat product consisting of  
2 inspected and passed game animal meat and other domestic animal  
3 meat such as pork, beef or poultry shall include the triangular  
4 inspection mark under par. (a) if both of the following  
5 conditions are met:

6 1. Domestic animal meat constitutes less than 3% of the  
7 product by weight.

8 2. Meat fat from domestic animals constitutes less than 30%  
9 of the product by weight.

10 (c) The label for a processed meat product consisting of  
11 inspected and passed game animal meat and other domestic animal  
12 meat such as pork, beef or poultry shall include the inspection  
13 mark under s. Ag 47.10(3), rather than par. (a), if either of the  
14 following conditions exist:

15 1. Domestic animal meat constitutes 3% or more of the  
16 product by weight.

17 2. Meat fat from domestic animals constitutes 30% or more  
18 of the product by weight.

19 SECTION 7. Ag 47.11 is repealed and recreated to read:

20 Ag 47.11 TREATING PORK AND PORK PRODUCTS TO DESTROY  
21 TRICHINAE. (1) TREATMENT REQUIRED. All meat products listed  
22 under sub. (2) and all pork muscle tissue used as an ingredient  
23 of a meat product listed under sub. (2) shall be treated to  
24 destroy any possible live trichinae. Treatment shall consist of  
25 heating, freezing or curing. Heating, freezing and curing shall  
26 comply with applicable requirements under subs. (3) to (7).

1 (2) PRODUCTS REQUIRING TREATMENT. The following meat  
2 products and all products of a similar character are subject to  
3 treatment under sub. (1) if they contain any pork muscle tissue,  
4 pork hearts, pork stomachs or pork livers:

5 (a) Bologna.

6 (b) Frankfurters.

7 (c) Vienna sausage.

8 (d) Smoked sausage and knoblauch sausage.

9 (e) Mortadella.

10 (f) All forms of summer or dried sausage, including  
11 mettwurst.

12 (g) Ground meat mixtures containing pork and beef, veal,  
13 lamb, mutton, goat, or game meat, which may be prepared in such a  
14 manner that the ground meat mixture might be eaten rare or  
15 without thorough cooking.

16 (h) Flavored pork sausages such as those containing wine or  
17 similar flavoring materials.

18 (i) Cured pork sausage.

19 (j) Sausage containing cured pork or smoked pork, or both.

20 (k) Cooked pork loaves.

21 (l) Roasted, baked, boiled or cooked hams.

22 (m) Pork shoulders or pork shoulder picnics.

23 (n) Italian-style hams.

24 (o) Westphalia-style hams.

25 (p) Smoked boneless pork shoulder butts.

26 (q) Cured meat rolls.

1 (r) Capocollo, also known as capicola or capicola.

2 (s) Coppa.

3 (t) Fresh or cured boneless pork shoulder butts, hams,  
4 loins, shoulders, shoulder picnics, and similar pork cuts in  
5 casings or other containers in which ready-to-eat delicatessen  
6 articles are customarily enclosed. Cured boneless pork loins  
7 shall be treated to destroy trichinae before they are shipped  
8 from the establishment where cured.

9 (u) Breaded pork products.

10 (v) Boneless back bacon.

11 (w) Smoked pork cuts such as hams, shoulders, loins and pork  
12 shoulder picnics.

13 (3) HEATING. (a) If a product is treated by heating, all  
14 parts of the product shall be heated to one of the internal  
15 temperatures in the following table for the period of time  
16 corresponding to that temperature:

TABLE 1: HEAT TREATMENT TIME AND TEMPERATURE

| <u>Minimum Internal Temperature</u> |                    | <u>Minimum Time</u> |
|-------------------------------------|--------------------|---------------------|
| Degrees Fahrenheit                  | Degrees Centigrade |                     |
| 120                                 | 49.0               | 21.0 hours          |
| 122                                 | 50.0               | 9.5 hours           |
| 124                                 | 51.1               | 4.5 hours           |
| 126                                 | 52.2               | 2.0 hours           |
| 128                                 | 53.4               | 1.0 hours           |
| 130                                 | 54.5               | 30.0 minutes        |
| 132                                 | 55.6               | 15.0 minutes        |
| 134                                 | 56.7               | 6.0 minutes         |
| 136                                 | 57.8               | 3.0 minutes         |
| 138                                 | 58.9               | 2.0 minutes         |
| 140                                 | 60.0               | 1.0 minute          |
| 142                                 | 61.1               | 1.0 minute          |
| 144                                 | 62.2               | Instant             |

1 (b) If products are treated by heating, the time to raise  
2 the product's temperature from 60° F. to 120° F. shall not exceed  
3 2 hours unless the product is cured or fermented.

4 (c) If a product is heated to a temperature of at least 138°  
5 F. but not greater than 143° F., the time under par. (a) need not  
6 be monitored if the product's minimum thickness exceeds 2 inches  
7 and the product is not refrigerated until at least 5 minutes  
8 after the temperature of 138° F. is attained.

9 (4) FREEZING. (a) 1. A product may, at any stage of  
10 preparation, be treated by freezing after preparatory chilling to  
11 a temperature not above 40°F. or after preparatory freezing. If  
12 a pork product is treated by freezing, all parts of the product  
13 shall be held continuously at a temperature not higher than one  
14 of those specified in Table 2. The product shall be held at or  
15 below that temperature for the corresponding number of days  
16 specified in the table. The required number of days depends on

1 the thickness of the meat and inside dimensions of the container,  
2 as provided in subd. 2 or 3 below.

TABLE 2: FREEZING TIME AND TEMPERATURE

| TEMPERATURE ° F. | Group 1 (Days) | Group 2 (Days) |
|------------------|----------------|----------------|
| 5                | 20             | 30             |
| -10              | 10             | 20             |
| -20              | 6              | 12             |

3 2. Products in Group 1 may be in separate pieces not more  
4 than 6 inches thick, arranged on separate racks with each layer  
5 not more than 6 inches deep, stored in crates or boxes not more  
6 than 6 inches deep, or stored as solidly frozen blocks not more  
7 than 6 inches thick.

8 3. Products in Group 2 may consist of products in pieces,  
9 layers, or within containers, in which the thickness of the  
10 product is more than 6 inches but not greater than 27 inches; or  
11 products in containers, including barrels, kegs or cartons,  
12 having a thickness not greater than 27 inches.

13 (b) Products or containers of products frozen under this  
14 subsection shall be spaced in the freezer to ensure free  
15 circulation of air between the pieces of meat, meat layers, meat  
16 blocks and meat containers, so that the temperature in all parts  
17 of the freezer will be promptly reduced to the appropriate  
18 temperature in Table 2 and maintained at or below that  
19 temperature for the required number of days.

20 (c) During the time periods for freezing a product under  
21 par. (a), the product shall be kept in a separate freezer room or  
22 compartment which is separate from other products not being

1 treated for destruction of trichinae. The separate freezer room  
2 or compartment shall be under department control and be locked or  
3 sealed so that it is accessible only with department approval.

4 (5) FREEZE DRYING. If a product is treated by freeze  
5 drying, all parts of the product shall be freeze dried by a  
6 commercial freeze drying establishment.

7 (6) CONTROLLED FREEZING. (a) A product may be treated for  
8 destruction of trichinae by subjecting all parts of the product  
9 to controlled freezing under department supervision. The center  
10 of the meat product shall be held at one of the temperatures in  
11 the following table for the period of time corresponding to that  
12 temperature.

TABLE 3: CONTROLLED FREEZING TIME AND TEMPERATURE

| <u>Maximum Internal Temperature</u> |            | <u>MINIMUM TIME</u> |
|-------------------------------------|------------|---------------------|
| <u>°F.</u>                          | <u>°C.</u> |                     |
| 0                                   | -17.8      | 106 hours           |
| -5                                  | -20.6      | 82 hours            |
| -10                                 | -23.3      | 63 hours            |
| -15                                 | -26.1      | 48 hours            |
| -20                                 | -28.9      | 35 hours            |
| -25                                 | -31.7      | 22 hours            |
| -30                                 | -34.5      | 8 hours             |
| -35                                 | -37.2      | ½ hour              |

13 (b) During the controlled freezing period under par. (a),  
14 the product shall be kept in a separate freezer room or  
15 compartment which is separate from other products not being  
16 treated for destruction of trichinae. The separate freezer room  
17 or compartment shall be under department control and be locked or  
18 sealed so that it is accessible only with department approval.

19 (c) Each freezer room or compartment used for controlled

1 freezing shall be equipped with an accurate thermometer. The  
2 thermometer shall be placed at or above the highest level at  
3 which the product undergoing treatment is stored, and away from  
4 refrigerating coils.

5 (d) Products treated by controlled freezing shall be  
6 closely supervised by a department inspector until it is prepared  
7 into one of the finished products under sub. (2), or until it is  
8 transferred under department control to another licensed meat  
9 establishment for preparation into one of those finished  
10 products.

11 (e) Products treated by controlled freezing may be  
12 transferred in sealed vehicles or sealed containers to another  
13 licensed meat establishment for use in the preparation of any  
14 product under sub. (2). Transportation shall comply with  
15 applicable requirements under s. Ag 47.06.

16 (6) CURING. If a product is cured to destroy trichinae, the  
17 product shall be cured using an appropriate curing method for  
18 that product as provided in 9 CFR 318.10(c)(3), or by another  
19 method approved in writing by the department.

20 (7) TIME AND TEMPERATURE MONITORING. When necessary to  
21 comply with this section, smokehouses, drying rooms, freezers and  
22 other compartments used in the treatment of pork to destroy  
23 trichinae shall be equipped with accurate automatic recording  
24 thermometers. Alternate methods of monitoring time and  
25 temperature may be approved by the department. An assigned  
26 department inspector may approve an automatic recording

1 thermometer for use in a sausage smokehouse, drying room, freezer  
2 or other compartment if, in the inspector's judgment, the  
3 thermometer is adequate for the purpose used.

4 SECTION 8. Ag 47.12 is amended to read:

5 Ag 47.12 Meat and meat food products and, poultry and  
6 poultry food products, and game meat products may be processed by  
7 canning methods. If heat processing and canning methods are  
8 used, the methods shall comply with requirements under 9 CFR  
9 318.300 to 318.311, or shall be specifically approved in writing  
10 by the department.

11 SECTION 9. Ag 47.16(6)(a) and (8)(a) are amended to read:

12 Ag 47.16(6)(a) ~~Animals~~ An animal which is accidentally  
13 injured may be slaughtered on an emergency basis if ~~they are the~~ the  
14 animal is submitted for slaughter within 24 hours after the  
15 injury ~~was~~ is incurred. In all cases of emergency slaughter, the  
16 ~~animals~~ animal shall be inspected immediately before slaughter.  
17 When the necessity for emergency slaughter exists, the  
18 establishment shall notify the meat inspector so that ~~such~~  
19 department inspection may be made. In the absence of a  
20 department inspector, a licensed practicing veterinarian may be  
21 called at the establishment's expense, ~~and such~~ to perform ante  
22 mortem and postmortem inspection. The inspecting veterinarian  
23 shall submit a written ~~statement of his findings~~ inspection  
24 report to the department in sufficient detail to enable a later  
25 review of the findings by a department veterinarian, who shall  
26 issue an order for final disposition of the carcass.



1 (8)(a) Downer animals are animals which are unable to stand  
2 or walk unassisted due to factors other than accidental injury.  
3 Downer animals which do not qualify for emergency slaughter under  
4 sub. (6) may be slaughtered only during regularly scheduled times  
5 when a veterinarian employed by the department is on duty.

6 SECTION 10. EFFECTIVE DATE. The rules contained in this  
7 order shall take effect on the first day of the month following  
8 publication in the Wisconsin administrative register, as provided  
9 in s. 227.22(2)(intro.), Stats.

Dated this 22<sup>nd</sup> day of August, 1991.

STATE OF WISCONSIN  
DEPARTMENT OF AGRICULTURE,  
TRADE AND CONSUMER PROTECTION

By Steven B. Steinhoff  
Steven B. Steinhoff  
Administrator  
Food Division

KWM/Ag 47/D8  
8.16.91

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