

Chapter ATCP 55

INSPECTION, PROCESSING, MARKETING AND
STORAGE OF MEAT AND POULTRY

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History: Chapter Ag 47 as it existed on September 30, 1971 was repealed and a new ch. ATCP 47 was created, Register, September, 1971, No. 189, effective October 1, 1971; chapter Ag 47 was renumbered ch. ATCP 55 under s. 13.93 (2m) (b) 1, Stats., Register, March, 1993, No. 447.

ATCP 55.01 Scope. The provisions of these rules shall apply to slaughterers, mobile slaughterers, frozen food lockers, processors, mobile processors, distributors, carriers, meat brokers, retail stores and central restaurant commissaries engaged in slaughtering, processing, storing, transporting or marketing of meat and poultry, but shall not be applicable to restaurants and vending machine commissaries, as defined in ch. 160, Stats., or catering establishments, subject to inspection and regulation by the department of health and social services, where only inspected meat and poultry are used in processing operations, where meat or poultry are processed only for use in the preparation or serving of meals and lunches, and processing operations are confined to the premises at which meals or lunches are prepared and served, or in the case of vending machine commissaries or catering establishments, the premises at which meals or lunches are prepared for individual customers or for sale through vending machines. The rules do not apply to establishments under federal inspection, or to establishments under county or municipal inspection approved by the department and conducted pursuant to ordinances and regulations which are substantially equivalent to this chapter and enforced with equal effectiveness.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. Register, April, 1975, No. 232, eff. 5-1-75; am. Register, October, 1983, No. 334, eff. 11-1-83.

ATCP 55.02 Definitions. As used in this chapter; unless the context otherwise requires:

(1) The terms and phrases defined in s. 97.42 (1), Stats., shall have the same meanings for purposes of this chapter.

(2) "Department" means the state of Wisconsin department of agriculture, trade and consumer protection.

(3) "Clean" means the absence of dirt, grease, waste materials, residue accumulations, filth, rubbish, garbage,

insects, vermin or other unsightly, offensive or extraneous matter.

(4) "Consumer" means any household consumer, restaurant, or institution.

(5) "Diseased animal" means an animal which has become sick, ill, or unhealthy in response to environmental factors, specific infective agents, inherent defects, or combinations of these factors, and does not mean an otherwise healthy animal with accidental injuries, such as fractures, cuts, and bruises.

(6) "Frozen food locker plant" means a locker plant as defined in s. 99.01 (6), 1977 Stats., where meat or poultry products or meat food products are frozen and stored as a custom service, but where no other processing is done and includes branch locker plants as defined in s. 99.01 (7), 1977 Stats., where such products are stored.

(7) "Frozen food processing plant" means an establishment where meat or poultry products are processed only by the cutting, wrapping and freezing thereof as a custom service.

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

(9) "Meat" means the edible part of the muscle of animals 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.

(10) "Meat by-products" means any edible part of the carcass of animals other than meat.

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

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(12) "Potentially hazardous food" means any food which by its nature or composition may contain, or is capable of supporting rapid and progressive growth of, infectious or toxigenic microorganisms.

(13) "Premises" means a retail market, slaughter, processing or storage plant or any other building, structure or facility used in the conduct of slaughtering, processing or storage operations, and the land on which it is situated, and includes all other buildings, structures, facilities and land adjacent thereto under the ownership or control of the owner or operator used in connection with the conduct of such operations.

(14) "Process" means to manufacture, compound, intermix, or prepare meat, meat food, poultry or poultry food products for sale or as a custom service.

(15) "Product" means meat, meat products, poultry products, meat food products and meat by-products.

(16) "Retail meat market" means a plant or premises in which meat or meat food products or poultry or poultry food products are prepared, stored, handled, sold or offered for sale at retail with such sales being made primarily to household consumers.

(17) "Retained" or "detained" means that the carcass, viscera, or part of carcass of meat animals or poultry or the meat or poultry food products made therefrom so marked is being held for further examination by an inspector to determine its disposition.

(18) "Sanitize" means effective bactericidal treatment of clean surfaces of equipment and utensils by a process which has been approved by the department as being effective in destroying microorganisms, including pathogens.

(19) "Storage plant" means a plant where products as defined in this section are stored and includes locker plants and branch locker plants as defined in s. 99.01 (6) and (7), 1977 Stats.

(20) "Vehicle" within the meaning of these regulations means any conveyance utilized in the transport of food or food products.

(21) "Wis. inspected and condemned" or "U.S. 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 antemortem, postmortem, or reinspection to be unfit for human food.

(22) "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, trade, and consumer protection and were found to be sound, healthful, wholesome and fit for human food.

(23) "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.

(24) "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.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (25), Register, September, 1972, No. 201, eff. 10-1-72; am. (6), (13), (14), (16), (17), (20), (23), (29) and cr. (30) to (35), Register, April, 1975, No. 232, eff. 5-1-75; r. (2) to (8), (13) to (15), (29), (31) to (33), renum. (1), (9) to (12), (16) to (28), (30), (34) and (35) to be (1), (20), (19), (22), (21), (7), (8), (13), (9), (3), (4), (10) to (12), (14), (16), (18), (15), (17), (5) and (6) and am. (2) and (14), cr. (1), Register, October, 1983, No. 334, eff. 11-1-83; emerg. cr. (23), eff. 11-26-85; cr. (23), Register, May, 1986, No. 365, eff. 6-1-86; renum. (5) to (23) to be (6), (7), (9) to (24) and (5), cr. (8), Register, October, 1991, No. 430, eff. 11-1-91.

ATCP 55.03 Facilities, sanitation and records. (1) RESPONSIBILITY. (a) Every establishment shall be maintained and operated in conformity with the requirements of this section and the standards set forth in "U.S. Inspected Meat and Poultry Packing Plants — A Guide to Construction and Layout" (Revised 1987), "Federal Facilities Requirements for Small Existing Meat Plants" (Revised 1985), and "Sanitation Handbook for Meat and Poultry Inspectors" (Revised 1982) published by the U.S. 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.

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

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

(d) The operator of an establishment shall keep accurate records and submit reports as required by the department.

(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 located in accordance with applicable zoning ordinances and shall be constructed in accordance with all applicable state and local building, plumbing, and waste disposal codes. Plans for construction or alteration shall be submitted to the department for prior approval. Plants shall be constructed according to approved plans.

(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 when necessary to accomplish this.

(b) All dogs, cats, other pets and birds shall be excluded. This shall not serve to exclude seeing eye dogs from retail market areas normally accessible to customers.

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

(f) All portions of buildings used in the conduct of operations shall be fully separated from other portions used for living quarters by means of floors, walls, and ceilings constructed of solid concrete, brick, wood, or other impervious materials, and shall be used only for slaughtering or processing operations, or in the storage of products and for no other purposes.

(g) All newly constructed establishments which slaughter animals or poultry shall have a separate refrigerated room for storage of inedible products.

(4) FACILITIES. (a) *Water supply.* The water supply shall be readily accessible, of sufficient quantity to permit compliance with the requirements of this section, and potable. There shall be no cross connection between the potable water supply and any nonpotable water supply nor with the sewage disposal system. Hot water shall be available in sufficient quantity for all cleaning purposes. Hot water for sanitizing shall be not less than 180° F. at the point of usage. The establishment shall currently have on file in its records evidence that the water supply has been approved by the local health authority within the past calendar year. There shall be effective means to prevent back-siphonage of liquids into the potable water supply or steam lines.

(b) *Ice.* Ice shall be from potable water which meets the requirements of this section. It shall be manufactured, handled, stored, and used in a sanitary manner.

(c) *Cleaning.* A suitable area and facilities shall be provided for the cleansing and sanitizing of equipment such as hand trucks, hooks, gambrels, smokesticks, trays, boxes, and demountable processing equipment.

(d) *Lavatory.* Hand-washing sinks with hot and cold running water, soap in dispensers, and single-service towels or approved hand dryers shall be provided in slaughter rooms and in processing areas. Faucet valves on the sinks shall be other than hand operated. In newly constructed or remodeled facilities, sink drainpipes shall be tightly connected to a sewer line. Lavatories shall not be used for storage of utensils or hand tools. Hands shall be washed only in a hand-washing lavatory and not by other methods.

(e) *Lighting.* Each room shall have sufficient natural or artificial lighting for the purpose for which it is to be used. Sufficient lighting shall be present in all areas to permit adequate visibility for cleaning and sanitary inspection operations. Lights in the processing areas shall be equipped with protective shields or shatterproof bulbs. Minimum acceptable light intensities for various operations are:

1. Not less than 20 foot candles on working surfaces, except in areas where grinding, stuffing and packaging or other processing operations are carried on where the intensity shall be not less than 50 foot candles.

2. Not less than 10 foot candles intensity in coolers at a point 3 feet from the floor.

3. Not less than 5 foot candles in storage areas.

(f) *Ventilation and heating.* Ventilation shall be sufficient to control vapors, mold, objectionable odors and accumulation of condensates. Adequate heating shall be provided for comfortable working conditions in all work areas except those areas or rooms requiring refrigeration.

(g) *Pest control.* Effective measures for the control of insects and rodents shall be maintained at all times. Insecticides and rodenticides, if used, shall be only those which are approved by the department. They shall be employed by approved methods and shall be handled and stored in a safe manner, apart from food items or ingredients.

(h) *Storage facilities.* Storage facilities shall be provided for storing raw materials, packing and packaging materials, and finished products. They shall be clean, sanitary, and in good repair. Off floor storage methods which minimize deterioration and prevent contamination or other adulteration and facilitate cleaning shall be used. Shelves, cabinets, and dunnage shall be used to protect materials from contamination. Single-service articles, including cans, bottles, lids, pouches, and paper containers shall be free of contamination and maintained in sanitary boxes, cartons, or tubes or otherwise protected and handled in a sanitary manner.

(i) *Cooling and refrigeration facilities.* 1. Refrigerated space adequate for the prevention of spoilage shall be provided to chill and hold carcasses, parts and products at all slaughter facilities unless there is immediate transportation to another premises where suitable refrigeration is provided.

2. Suitable refrigerated facilities shall be provided for the storage and/or display of food products of fresh, frozen, or potentially hazardous type. The maximum temperature for storage of fresh meats or poultry products shall be +40° F. The maximum permissible temperature for storage of frozen meat or poultry products shall be +10° F. at the warmest point at which product is exposed.

(j) *Disposal of wastes.* Liquid wastes shall be conveyed to a public sewer or other approved waste disposal system through enclosed piping by methods or systems which will not create insanitary conditions. Floor drains shall be functional and properly trapped. Trash and rubbish shall be placed in suitable receptacles conveniently located throughout the plant. Product wastes, such as trimmings, shall be collected in suitable containers which shall be kept covered when not continuously receiving wastes. All

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wastes not disposed of into a sewer or other approved liquid waste disposal system shall be collected and removed from food processing area at least daily, and shall be disposed of in a sanitary and acceptable manner. Paunch contents, manure and inedible offal shall be placed in tight containers, vehicles or separate rooms so as not to create a nuisance, cause odors or attract flies.

(k) *Toilet, dressing room, and hand-washing facilities.* A sufficient number of sanitary toilets to accommodate all personnel in accordance with plumbing codes shall be provided. Toilet rooms shall be conveniently located, constructed of materials which can be easily and satisfactorily cleaned, adequately lighted and shall be separately vented to the outside. They shall be maintained in a sanitary condition and shall be constructed with tight fitting and self-closing doors and provided with a suitable exhaust fan that is vented to the outside and so installed as to assure its operation and the creation of a negative pressure within at any time the toilet facility may be used. A sign directing employes to wash their hands before returning to work shall be posted in all toilet rooms. Hand-washing facilities, including hot and cold running water, soap with dispenser and an effective, sanitary single-service means of drying the hands, shall be conveniently located in the toilet rooms and throughout the area where products are prepared.

(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 non-toxic, 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.

(6) **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, meat, and poultry products, shall be thoroughly cleaned immediately after each day's use, and more frequently if necessary to maintain proper sanitary condition.

(b) Floors in slaughtering and processing areas shall be cleaned immediately following each day's operation and more frequently if necessary to maintain proper sanitary condition. The cleaning of floors and walls shall be conducted in such manner and at such time as to avoid contamination of product.

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

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

(e) Properly located sanitizing facilities for cleaning and disinfecting equipment and utensils shall be provided at places in an establishment where operations are likely to result in contamination of equipment and utensils. Equipment and utensils shall be sanitized and disinfected by applying water heated to a temperature of at least 180° F., or by using other sanitizing procedures approved by the department.

(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, are correctly labeled, and are thoroughly cleaned and lined with moisture resistant paper or plastic before being reused.

(j) Utensils and equipment that have been used in the preparation or handling of raw meat or raw poultry shall not be used for the preparation of cooked foods or foods that are likely to be eaten without cooking, unless such utensils and equipment have been thoroughly cleaned and sanitized.

(k) Grinders, mixers, stuffers and like items that have been used in the preparation and handling of raw pork items, unless such pork has been treated or certified to destroy trichinae, shall be thoroughly cleaned and sanitized before use in the preparation of any other meat or food items.

(7) 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 products, except that the washing of offal in the slaughtering room may be permitted. The rendering or otherwise treating of inedible products shall be completely segregated in separate rooms, apart from any edible food operation. There shall be no intermingling of inedible and edible food operations or any connection between areas used for such operations, except that:

1. There may be one self-closing connecting doorway between the slaughtering or viscera separating department and the inedible rendering department.

2. Pipes, conveyors or chutes may be installed in a manner approved by the department to convey inedible or condemned materials from edible product departments to the inedible rendering areas.

(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.

(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 subjected to any substance or drug which might cause a chemical or biological residue to be present in the tissues.

(d) No person shall conduct an inedible rendering operation on the premises of an establishment, except to render by-products of his or her own slaughtering operation.

(e) Inedible products which closely resemble an edible product, or which are capable of use as human food, shall be placed in containers plainly marked "Inedible" and segregated from edible products. Such containers while in the work processing area shall be reasonably clean, free from odors, accumulated residues, rust and not constitute a health hazard or nuisance. Inedible products shall be denatured before being placed in storage or removed from the establishment. Denaturing shall effectively alter the normal character or appearance of carcasses or products so as to render them incapable of being sold or used as human food.

(f) Inedible products, described in par. (e), held at the establishment for further sale or disposition for rendering or use as animal feed, shall be plainly marked or identified "INEDIBLE (SPECIES) NOT FOR HUMAN CONSUMPTION". Transportation or removal of such products from the establishment shall be in conformity with ch. Ag 48.

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

(h) The slaughter room shall not be used for other operations such as processing or packaging at the same time that slaughter operations are being conducted, nor shall it be used as a storage area.

(i) Manure, offal or other inedible by-product shall not be permitted to accumulate in or around any establishment or retail meat market.

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

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

(l) No person afflicted with a communicable disease or who has a discharging or infected wound, sore or lesion on hands, arms or other exposed portion of the body shall be permitted to handle foods or food processing equipment.

(m) Persons engaged in handling or processing food products shall wear clean and washable outer clothing, and shall wear head covering or hair nets. Clothing, head covering or hair nets shall be of such types as to prevent accidental contamination of product by body or facial hair, cosmetics, medications or similar substances.

(n) Washing of floors, hands, aprons, or equipment is prohibited in areas while products are present that may be contaminated by splash.

(o) Meals or snacks shall not be consumed in product processing areas. If needed, a separate room or area shall be provided in an establishment for the consumption of meals or snacks by employees or other persons.

(8) REJECTION OF FACILITIES OR EQUIPMENT. The department may attach a reject tag to utensils, rooms, containers or any other equipment or facilities constructed or maintained in violation of these rules, or which because of their insanitary or unclean condition could lead to the contamination of product. Equipment or facilities so tagged may not be used until brought into compliance with these rules and the reject tag is removed by a department representative.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; cr. (8), Register, September, 1972, No. 201, eff. 10-1-72; am. (4) (d), (7) (a), (e) and (f), cr. (3) (f), Register, April, 1975, No. 232, eff. 5-1-75; cr. (1) (d), (3) (g), (7) (n) and (o), am. (2) (b), (4) (d), (6) (e) and (7) (e), Register, October, 1983, No. 334, eff. 11-1-83; am. (1) (a), Register, October, 1991, No. 430, eff. 11-1-91; correction in (7) (d) made under s. 13.93 (2m) (b) 5, Stats.

ATCP 55.04 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.

History: Cr. Register, September 1971, No. 189, eff. 10-1-71.

ATCP 55.06 Transportation of meat and poultry. (1) TRANSPORTATION AND STORAGE. No person shall sell, transport, store, or offer for sale, transportation or storage, or receive for transportation or storage, any carcass or

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product capable of use as human food unless such carcass or product and its container, if any, is plainly labeled, marked or identified as required under this chapter.

(2) **FACILITIES AND HANDLING.** (a) Vehicles and transportation facilities used in transporting meats, meat foods, poultry or poultry food products shall be constructed and maintained so as to assure that product arrives at its destination in a wholesome and unadulterated condition.

(b) Unwrapped product shall be transported in enclosed vehicles equipped with tight fitting doors, and shall be protected from contamination from walls or floors.

(c) Transportation facilities shall be such that will assure delivery of chilled product at destination with an internal temperature of not more than +40° F.

(3) **EXEMPTIONS.** (a) The provisions of sub. (2) relating to transportation shall not apply to custom or farm slaughtered carcasses or product, transported by the owner thereof, except that any such product determined to be unwholesome or adulterated shall be excluded from any retail market, processing plant, or storage facility engaged in providing meat or poultry processing services to the public, and if found therein shall be subject to seizure, retention and/or condemnation.

(b) The provisions of sub. (1) do not apply to the transportation, by individuals, of carcasses or products resulting from the slaughter or processing by them of animals of their own raising exclusively for their own use and members of their household and non-paying guests and employees.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; r. and recr. Register, April, 1975, No. 232, eff. 5-1-75.

ATCP 55.07 Seizure, retention, condemnation and disposition of unwholesome, adulterated or misbranded products. (1) The department may seize, retain or apply holding orders to any products in any establishment, retail market, frozen locker plant, frozen food processing plant, storage facility and warehouse, or any other premises or establishment where such products are processed, stored or held for sale or distribution, or which are in the channels of transportation, that are, or are suspected of being, unwholesome, adulterated, or misbranded for further examination, analysis or disposition. If the situation requires, products in transportation may be placed in commercial storage facilities, under retention or holding order, in the account of the consignor.

(2) Products determined to be unwholesome shall be condemned wherever located.

(3) Products determined to be adulterated or misbranded may be retained to be reworked or further processed to correct deficiencies, or condemned if such deficiencies cannot be corrected.

(4) Products processed at any establishment on a custom basis shall be subject to the same rules of seizure, retention and condemnation as prescribed herein as any other products with respect to conditions of disease, parasitic infection, unwholesomeness, presence of harmful chemical, biological or antibiotic residues, or any other condition which would render it potentially harmful to

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human health or cause it to be a potentially hazardous food.

(5) It shall be the responsibility of the owner or operator of any establishment to examine all products, including products processed on a custom basis, prior to their entry into processing or storage areas, and to exclude any product found to be unwholesome or otherwise contaminated with any objectionable matter or filth, or to require immediate isolation of such products or their cleaning or trimming as necessary to remove such condition. Department inspectors shall require the immediate removal of such unwholesome or contaminated product if found in edible processing or storage areas. If such product is not promptly removed as required, it may be seized or condemned by the inspector.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; r. and recr. Register, April, 1975, No. 232, eff. 5-1-75.

ATCP 55.08 Composition, formulation and labeling of meat, meat food products, poultry and poultry food products. (1) **COMPOSITION.** The composition of any meat, meat food, poultry, or poultry food product, whether or not in naturally occurring, processed, or composited and processed form, that is prepared, stored, handled, sold or offered for sale in any establishment or retail market shall comply with the definitions and standards of identity for such products as provided in ch. 97, Stats., and rules issued by the department.

(2) **LABELING.** (a) Any meat or poultry product sold or offered for sale shall bear an appropriate label stating the true name of the product; the product ingredients, if applicable; the name and address of the processor or distributor; the net weight of the product; the inspection legend; and, if the product is perishable, one of the following statements or a similar perishable warning statement: "Keep Refrigerated", "Perishable, Keep Under Refrigeration" or "Keep Frozen". This does not apply to a product prepared and sold at a retail market and offered for sale at a full service counter if the product is accompanied by a counter tag showing the name of the product and a listing of ingredients.

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

(c) Labels accompanying bulk shipment of products to be repackaged shall not bear the inspection legend, unless the product is shipped to an official establishment for repackaging under inspection supervision.

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

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; renum. (2) (b) to be (2) (d) and cr. (2) (b) and (c), Register, April, 1975, No. 232, eff. 5-

1-75; am. (2) (a), Register, October, 1983, No. 334, eff. 11-1-83; am. (2) (a), (c) and (d), Register, October, 1991, No. 430, eff. 11-1-91.

ATCP 55.09 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 apart from the regular inspection schedule.

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

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

NOT FOR SALE	OR	NOT FOR SALE
XYZ MARKET		WIS 000

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

3. All boxes, cartons, packages or containers of custom processed meat or meat products shall be marked at the time of packaging. Ordinary ring variety sausages and large variety sausage products having a diameter greater than 1 1/2 inches shall be individually marked if they are individually packaged, or if they are shipped or stored in unsealed containers. These sausages need not be individually marked if they are packaged in a sealed and properly labeled container intended for a single customer.

(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.

(d) There shall be effective segregation in all facilities and operations at all times to prevent the commingling of inspected and non-inspected product.

(2) 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.

(3) REQUEST FOR INSPECTION. When inspection is requested for custom slaughter, a request 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.

(4) HORSE SLAUGHTER. The slaughter of horses, mules and other equines and the preparation and handling of the products thereof shall be conducted in establishments separate from those used for the slaughter and preparation of other products. All carcasses, parts, meat, meat food products, or other products thereof shall be conspicuously labeled, marked, branded, or tagged "Horse Meat" or "Horse Meat Product" by a method approved by the department.

(5) EMERGENCY SLAUGHTER. (a) Accidentally injured animals with fractures, cuts, or bruises, but which are otherwise healthy, may be slaughtered on an emergency basis if slaughtered within 24 hours after the injury was incurred. No antemortem or postmortem inspection shall be required for the emergency slaughter of such accidentally injured animals if done on a custom basis and the meat is not intended for sale.

(b) All animals submitted for emergency slaughter on a custom basis shall be accompanied by a certificate signed by the owner or custodian of the animal at the time of injury providing the following information:

1. Name and address of the owner or custodian.
2. Type of injury.
3. Time and date the injury was incurred.
4. All drugs administered to the animal within 30 days prior to its submission for emergency slaughter.
5. The last date drugs were administered to the animal.

(c) Establishments shall furnish the owners of uninspected emergency slaughtered animals with a signed, written statement of the actual gross weight of the carcass prior to processing and the actual net weight of the meat after processing. The owners of such meat shall sign a receipt, and establishments shall maintain these receipts for inspection and review by the department.

(d) Animals with accidental injuries sustained more than 24 hours before submission for slaughter, whose meat is intended for private consumption by the animal's owner, the owner's household and nonpaying guests and employes, and not for sale, shall be slaughtered in establishments where meat inspection is maintained under s. 97.42, Stats., or the federal meat inspection act, or where the animal is kept. Meat from such animals may be received and processed, on a custom basis and not for sale, in establishments only if:

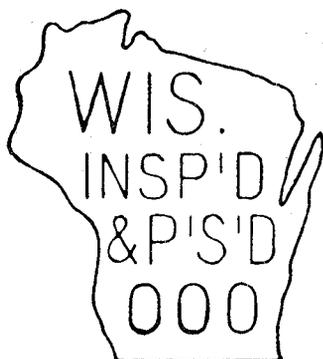
1. A licensed practicing veterinarian performs both antemortem and postmortem inspections on the animal;
2. The veterinarian certifies, in writing, that the meat from such animal is wholesome and free of disease;
3. The veterinarian furnishes the department with such certification.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (1) (b) and (5), Register, September, 1972, No. 201, eff. 10-1-72; am. (1) (b) and (5), Register, April, 1975, No. 232, eff. 5-1-75; am. (1) (b), r. (2), renum. (3) to (5) to be (2) to (4), Register, October, 1983, No. 334, eff. 11-1-83; emerg. cr. (5), eff. 11-26-85; cr. (5), Register, May, 1986, No. 365, eff. 6-1-86; r. and recr. (1) (b), Register, October, 1991, No. 430, eff. 11-1-91.

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ATCP 55.10 Inspection marks and establishment numbers. (1) **ESTABLISHMENT NUMBER.** An official number shall be assigned to each establishment where continuous 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 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) 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) 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) 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) Carcasses, parts, viscera or meat products held for further examination by an inspector to determine its disposal shall be tagged, "Wis. Retained," or placed under department holding order.

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

(3) **INSPECTED PROCESSED PRODUCTS.** All meat food products processed for sale under department inspection shall plainly bear a legible official inspection mark on the label reading "WIS. DEPT. AGR. INSPECTED" and the establishment number. Where limitations of space apply, the word "INSPECTED" may be abbreviated as "INSP'D." Labels within the meaning of this subsection means a display of any printing, lithographing, embossing, sticker, seals, or other written, printed or graphic matter upon the immediate package or container of any product, not including package liners.

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(4) **CONTROL AND USE OF BRANDS AND MARKING DEVICES.** All brands and devices, except custom processed brands, for marking articles with the inspection legend shall be used only under the supervision of a department employe, 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 employe.

(5) **INSPECTION MARKS; FORGING, COUNTERFEITING, IMPROPER USE AND HANDLING.** (a) 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.

(b) Any additional brands required shall be furnished by the establishment.

(c) No person or establishment shall, without the express written approval of the department, create, or order the manufacture of any brands, stamps, or devices which incorporate the official Wisconsin inspection legend, or facsimile thereof.

(d) The control and title of any brands, whether furnished by the department, or manufactured for the establishment with the approval of the department, shall in the event of discontinuance of inspection in the establishment, remain with the department.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (1), (2)(a) and (3), Register, April, 1975, No. 232, eff. 5-1-75.

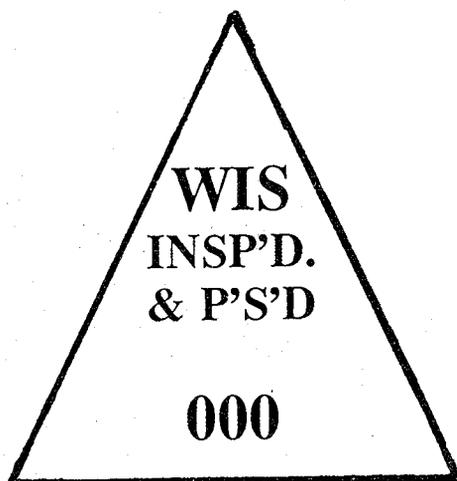
ATCP 55.105 Voluntary inspection of game animals. (1) **GENERAL.** The operator of a licensed meat establishment may request department inspection of game animals slaughtered at the licensed establishment. Inspection shall include ante-mortem and post-mortem inspection as provided in this section. The cost of inspection will be billed to the meat establishment operator at the current hourly rate as determined by the department.

(2) **ANTE-MORTEM INSPECTION.** Ante-mortem inspection of a game animal shall comply with applicable requirements under s. ATCP 55.16. Ante-mortem inspection may include field observation of the game animal in motion and at rest. Game animals shall be bled immediately after stunning. The inspector shall observe the transportation of each game animal to a slaughtering establishment to ensure positive identification if the animal is not otherwise positively identified. Game animals shall be transported promptly to a slaughtering establishment to maintain acceptable product condition.

(3) POST-MORTEM INSPECTION. Post-mortem inspection of a game animal shall comply with applicable requirements under s. ATCP 55.17. Post-mortem inspection procedures for buffalo shall be the same as those used for cattle. Post-mortem inspection procedures for venison shall be the same as those used for sheep. The department may prescribe specific post-mortem inspection procedures for other game animals as appropriate.

(4) SANITARY SLAUGHTER AND PROCESSING. Game animals shall be slaughtered in a sanitary manner. Meat and meat products obtained from game animals shall be handled and processed in a sanitary manner. Slaughter and processing shall comply with applicable sanitation requirements under this chapter.

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



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

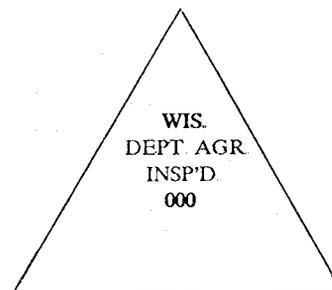
(c) Inspection brands shall be approved by the department. Requests for approval shall be submitted in writing to the department's Madison office. The department will forward approved requests to a brand manufacturer who will bill the requesting meat establishment directly. An inspection brand may only be used under the direct supervision of a department employee. When not in use for marking, the inspection brand shall be kept locked in a properly equipped locker or compartment, the keys to which shall not leave the possession of a department employee.

(6) CONDEMNED CARCASSES OR MEAT PRODUCTS. Carcasses, parts or meat products from game animals which are inspected and found unfit for human food shall be

slashed and denatured as required under s. ATCP 55.185 (1) and marked or branded with the notation "WIS. INSPECTED AND CONDEMNED" in the format show below:

WIS. INSP'D. AND
CONDEMNED

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



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

1. Domestic animal meat constitutes less than 3% of the product by weight.
2. Meat fat from domestic animals constitutes less than 30% of the product by weight.

(c) The label for a processed meat product consisting of inspected and passed game animal meat and other domestic animal meat such as pork, beef or poultry shall include the inspection mark under s. ATCP 55.10 (3), rather than par. (a), if either of the following conditions exist:

1. Domestic animal meat constitutes 3% or more of the product by weight.
2. Meat fat from domestic animals constitutes 30% or more of the product by weight.

History: Cr. Register, October, 1991, No. 430, eff. 11-1-91.

ATCP 55.11 Treating pork and pork products to destroy trichinae. (1) TREATMENT REQUIRED. All meat products listed under sub. (2) and all pork muscle tissue used as an ingredient of a meat product listed under sub. (2) shall be treated to destroy any possible live trichinae. Treatment shall consist of heating, freezing or curing. Heating, freezing and curing shall comply with applicable requirements under subs. (3) to (7).

(2) PRODUCTS REQUIRING TREATMENT. The following meat products and all products of a similar character are

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subject to treatment under sub. (1) if they contain any pork muscle tissue, pork hearts, pork stomachs or pork livers:

- (a) Bologna.
- (b) Frankfurters.
- (c) Vienna sausage.
- (d) Smoked sausage and knoblauch sausage.
- (e) Mortadella.
- (f) All forms of summer or dried sausage, including mettwurst.
- (g) Ground meat mixtures containing pork and beef, veal, lamb, mutton, goat, or game meat, which may be prepared in such a manner that the ground meat mixture might be eaten rare or without thorough cooking.
- (h) Flavored pork sausages such as those containing wine or similar flavoring materials.
- (i) Cured pork sausage.
- (j) Sausage containing cured pork or smoked pork, or both.
- (k) Cooked pork loaves.
- (l) Roasted, baked, boiled or cooked hams.
- (m) Pork shoulders or pork shoulder picnics.
- (n) Italian-style hams.
- (o) Westphalia-style hams.
- (p) Smoked boneless pork shoulder butts.
- (q) Cured meat rolls.
- (r) Capocollo, also known as capicola or capacola.
- (s) Coppa.
- (t) 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. Cured boneless pork loins shall be treated to destroy trichinae before they are shipped from the establishment where cured.
- (u) Breaded pork products.
- (v) Boneless back bacon.
- (w) Smoked pork cuts such as hams, shoulders, loins and pork shoulder picnics.

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

TABLE 1: HEAT TREATMENT TIME AND TEMPERATURE

Minimum Internal Temperature		Minimum Time
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

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

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

(4) FREEZING. (a) 1. A product may, at any stage of preparation, be treated by freezing after preparatory chilling to a temperature not above 40° F. or after preparatory freezing. If a pork product is treated by freezing, all parts of the product shall be held continuously at a temperature not higher than one of those specified in Table 2. The product shall be held at or below that temperature for the corresponding number of days specified in the table. The required number of days depends on the thickness of the meat and inside dimensions of the container, as provided in subd. 2 or 3.

TABLE 2: FREEZING TIME AND TEMPERATURE

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

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

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

(b) Products or containers of products frozen under this subsection shall be spaced in the freezer to ensure free circulation of air between the pieces of meat, meat layers,

meat blocks and meat containers, so that the temperature in all parts of the freezer will be promptly reduced to the appropriate temperature in Table 2 and maintained at or below that temperature for the required number of days.

(c) During the time periods for freezing a product under par. (a), the product shall be kept in a separate freezer room or compartment which is separate from other products not being treated for destruction of trichinae. The separate freezer room or compartment shall be under department control and be locked or sealed so that it is accessible only with department approval.

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

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

TABLE 3: CONTROLLED FREEZING TIME AND TEMPERATURE

Maximum Internal Temperature		Minimum Time
°F.	°C.	
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

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

(c) Each freezer room or compartment used for controlled freezing shall be equipped with an accurate thermometer. The thermometer shall be placed at or above the highest level at which the product undergoing treatment is stored, and away from refrigerating coils.

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

(e) Products treated by controlled freezing may be transferred in sealed vehicles or sealed containers to another licensed meat establishment for use in the preparation of any product under sub. (2). Transportation shall comply with applicable requirements under s. ATCP 55.06.

(6) **CURING.** If a product is cured to destroy trichinae, the product shall be cured using an appropriate curing

method for that product as provided in 9 CFR 318.10 (c) (3), or by another method approved in writing by the department.

(7) **TIME AND TEMPERATURE MONITORING.** When necessary to comply with this section, smokehouses, drying rooms, freezers and other compartments used in the treatment of pork to destroy trichinae shall be equipped with accurate automatic recording thermometers. Alternate methods of monitoring time and temperature may be approved by the department. An assigned department inspector may approve an automatic recording thermometer for use in a sausage smokehouse, drying room, freezer or other compartment if, in the inspector's judgment, the thermometer is adequate for the purpose used.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; r. (4) Register, April, 1975, No. 232, eff. 5-1-75; r. and recr. (2) (c), Register, October, 1983, No. 334, eff. 11-1-83; r. and recr. Register, October, 1991, No. 430, eff. 11-1-91.

ATCP 55.12 Canning with heat processing and hermetically sealed containers. Meat and meat food products, poultry and poultry food products, and game meat products may be processed by canning methods. If heat processing and canning methods are used, the methods shall comply with requirements under 9 CFR 318.300 to 318.311, or shall be specifically approved in writing by the department.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; r. and recr. Register, October, 1983, No. 334, eff. 11-1-83; am. Register, October, 1991, No. 430, eff. 11-1-91.

ATCP 55.13 Time of inspection. (1) **DAYS AND HOURS.** Each establishment shall notify the department in writing of the hours or days of the week in which slaughtering or processing is conducted. The department, for the most efficient and economic utilization of inspector personnel, may require that all slaughtering and processing operations be confined to certain hours or days and establish inspection schedules designating the hours or days in which slaughtering or processing operations may be conducted.

(2) (a) **OVERTIME INSPECTION.** Establishments requiring overtime inspections shall reimburse the department at uniform rates commensurate with actual costs as determined by the department.

(b) "Overtime" for the purposes of this chapter 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 days before Christmas and New Year's Day.
4. Good Friday — afternoon.
5. Before 6 a.m. or after 6 p.m.
6. In excess of 40 hours of "straight time" in any calendar week.
7. At any time other than a regularly scheduled slaughter period.

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8. All other days which are official holidays for state employees.

(3) **ABSENCE OF INSPECTOR.** Whenever the inspector assigned by the department or any cooperating agency is not present at the commencement of slaughtering operations for which inspection is required, no person shall slaughter any animals or poultry for the purpose of selling the products thereof for human food without notifying and receiving instructions from the department concerning procedures to be followed or action to be taken with respect to slaughtering operations. The department shall take all steps possible to provide alternative inspection to facilitate continuation of operations without the imposition of any undue burden on such slaughtering operations.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (2) (a), Register, September, 1972, No. 201, eff. 10-1-72; am. (1) and cr. (3), Register, April, 1975, No. 232, eff. 5-1-75; am. (2) (b)3. and 4., cr. (2) (b)8., Register, October, 1983, No. 334, eff. 11-1-83.

ATCP 55.14 County and municipal inspection. Counties and municipalities desiring to enter into a cooperative agreement pursuant to s. 97.20 (5), 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, September, 1971, No. 189, eff. 10-1-71.

ATCP 55.15 Appeals. Appeals from the decision of any department inspector may be made to the department by the operator of any establishment.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71.

ATCP 55.16 Antemortem inspection. (1) SCOPE OF INSPECTION. All animals shall receive an antemortem 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.

(d) Pens required under this subsection shall be sufficiently clean to prevent animals from becoming soiled.

(3) **SUSPECT ANIMALS.** (a) All animals that, on antemortem 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 postmortem inspection, shall be tagged "Suspect" so as to retain their identity until final postmortem inspection has been made. No animal tagged "Suspect" shall have 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 the release

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shall be submitted in writing and signed by the owner of the animal.

(4) **ANTEMORTEM CONDEMNATION.** All animals plainly showing on antemortem 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.** Animals received in a dead or dying condition shall be condemned. Causes for condemnation on antemortem inspection may include, but is not limited to, severe manifestations of the following conditions:

(a) Elevated temperature

(b) Malignant neoplasms

(c) Multiple abscesses

(d) Immaturity

(e) Emaciation

(f) Icterus

(g) Polyarthritis

(h) Central nervous diseases

(i) Edema or anasarca

(j) In crippled or downer cattle, the following conditions associated with symptoms of systemic disease:

1. Skin conditions or changes, including:

a. Extremely pale skin (anemia).

b. Yellowish colored skin (jaundice).

c. Extreme thinness (emaciation).

d. Draining sores or maggots.

e. Abscesses.

f. Hot, painful sores (inflammation).

g. Reddish-blue discoloration of membranes in mouth, nose, vagina, or eyes.

h. Pockets of fluid (edema).

2. Digestive system conditions or changes, including:

a. Diarrhea, especially if bloody or foul smelling.

b. Extreme stomach dilation (bloat).

c. Ketosis (odor of acetone on breath).

3. Reproductive system conditions or changes, including:

a. Retained placenta.

b. Calving with any symptoms or evidence of metabolic disease or infection.

c. Vaginal discharges, including pus, hemorrhage, or foul odor.

- d. Prolapsed uterus.
- e. Mastitis (septicemic or gangrenous).
- 4. Urinary system conditions or changes, including:
 - a. Bloody urine.
 - b. Water belly (urinary obstruction).
 - c. Uremia.
- 5. Nervous system conditions or changes, including:
 - a. Abnormal behavior suggesting brain or major nerve damage (rabies, listeriosis, lead poisoning).
 - b. Weak response to stimulation with a sharp object or electric shock.
 - c. Tremors, shaking, or muscle twitching.
- 6. Respiratory system conditions or changes, including:
 - a. Rapid or labored breathing (pneumonia).
 - b. Nasal discharge containing pus, dead tissue, or blood.
- 7. Musculoskeletal conditions or changes, including:
 - a. Extreme weakness, including an inability to sit up.
 - b. Massive injury to two or more legs.
 - c. Swollen joints.
 - d. Hip clamp injuries.
- 8. Other conditions or changes, including:
 - a. Fever greater than 104° F., or subnormal temperature less than 99° F.
 - b. Cancer, including enlarged lymph nodes and eye malignancy.
 - c. Less than complete recovery from major surgery, as evidenced by unhealed wounds or recent scars from hardware, caesarian, or abdominal surgery.

(5f) ELEVATED TEMPERATURES. 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.

(5k) TUBERCULIN REACTORS. Animals that are known reactors to the tuberculin test shall be marked and treated as suspects.

(5p) BIOLOGICAL RESIDUE OR REACTION. 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 employe 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 animal fit for human food.

(5t) REPORTING CONDITIONS. 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. (a) An animal which is accidentally injured may be slaughtered on an emergency basis if the animal is submitted for slaughter within 24 hours after the injury is incurred. In all cases of emergency slaughter, the animal shall be inspected immediately before slaughter. When the necessity for emergency slaughter exists, the establishment shall notify the meat inspector so that department inspection may be made. In the absence of a department inspector, a licensed practicing veterinarian may be called at the establishment's expense to perform antemortem and postmortem inspection. The inspecting veterinarian shall submit a written inspection report to the department in sufficient detail to enable a later review of the findings by a department veterinarian, who shall issue an order for final disposition of the carcass.

(b) All animals submitted for emergency slaughter shall be accompanied by a certificate signed by the owner or custodian of the animal at the time of injury providing the following information:

1. Name and address of owner or custodian.
2. Type of injury, including time and date the injury was incurred.
3. Any drugs administered to the animal within 30 days prior to its submission for emergency slaughter, either as a feed additive, or in treatment of the injury, and the last date such drugs were administered.

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

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

(b) Any downer animal submitted for slaughter shall be accompanied by a certificate signed by the owner or custodian of the animal providing the following information:

1. Name and address of owner or custodian.
2. Date that the animal became a downer and the cause of the animal's condition, if known.
3. Any drugs administered to the animal within 30 days prior to its submission for slaughter, either as a feed additive, or in treatment for any condition, and the last date such drugs were administered.

(c) Downer animals may be received for slaughter and processing only at plants maintaining adequate facilities for the humane unloading, transport, and holding of such animals. Facilities shall include separate holding pens and skids, mats, or trucks for the movement of downer ani-

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mals. Downer animals shall not be dragged before stunning, or subjected to any other unnecessary mistreatment or abuse. All downer animals shall be unloaded from the truck directly onto a skid, mat or other approved conveyance if they are to be moved closer to the slaughter floor. Antemortem inspections may not be performed on the truck.

(d) Downer animals shall be held for 24 hours for further observation where the cause of the animal's condition cannot be readily determined. Animals which have been treated with drugs for which the prescribed withdrawal time has not been observed shall be condemned or held until the withdrawal times have been met.

(e) Downer animals condemned on antemortem inspection shall be killed and injected with a 10% solution of carbolic or cresylic acid, or other denaturant approved by the department, and be sent to rendering. At least 40 ml. of the denaturant solution shall be injected into the heavy musculature of each carcass quarter and into each of the abdominal and thoracic cavities. The denaturant and denaturing equipment shall be supplied by the establishment and the denaturant injected by establishment employees under direct supervision of a department employe. Under no circumstances may any animal condemned on antemortem inspection be dressed out on the premises.

(f) Any trimming of carcasses on postmortem inspection shall be done before the carcass enters the chill cooler.

(g) Facilities or equipment coming in contact with any condemned animal or part thereof shall be thoroughly cleaned and sanitized before further slaughtering or processing operations are resumed.

(h) Downer animals purchased or acquired by livestock dealers or other persons and held for treatment prior to slaughter shall, when submitted for slaughter, be accompanied by a certificate, conforming to the requirements under par. (b), both from the prior owner or custodian of such animals and the livestock dealer or other person treating such animals with respect to any drugs or antibiotics administered by them within 30 days prior to the submission of such animals for slaughter.

(9) FALSE CERTIFICATES. It shall be unlawful for any person or his agent, in the sale or shipment of animals to a slaughtering establishment, to make or submit any false or misleading statement, representation or certificate concerning the ownership, identity, origin or health status of such animals, or of any drugs, biologics or antibiotics administered to such animals.

(10) SLAUGHTER OF ANIMALS SHOWING SYMPTOMS OF DISEASE. Any animal showing symptoms of disease, if not condemned on antemortem inspection, shall be slaughtered separately from all other animals. If cross-contamination between animals cannot be prevented by other means, only one suspect animal or carcass shall be in the slaughter room at any one time.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (6) and cr. (8), Register, September, 1972, No. 201, eff. 10-1-72; am. (6) (b) 3, (7), (8) (b) 3, (8) (d) and cr. (8) (b) and (9), Register, April, 1975, No. 232, eff. 5-1-75; cr. (2) (d), (5) (a)10. and (10), am. (8) (a), (c) and (e), r. (5) (a)2., renum. (5) (a)3. to 10. to be 2. to 9., Register, October, 1983, No. 334, eff. 11-1-83; am. (6) (a) and (8) (a), Register, October, 1991, No. 430, eff. 11-1-91; corrections in (5) made under s. 13.93 (2m) (b) 1, Stats., Register, April, 1993, No. 448.

Register, April, 1993, No. 448

ATCP 55.17 Postmortem inspection. (1) SCOPE OF INSPECTION. A careful postmortem 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 of animals shall be identified in such manner that the identity of all parts is maintained until after postmortem inspection has been completed. When whole carcasses are condemned, all parts are condemned.

(2) FACILITIES FOR CONDUCTING POSTMORTEM 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) Hand-washing and carcass washing facilities shall be provided to prevent cross-contamination of other products.

(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 edibles 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 postmortem 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. In

order to prevent cross-contamination, carcasses shall be adequately separated or spaced after bleeding and head removal until they have passed inspection and are washed. Carcasses shall be dressed and eviscerated in a manner that will avert contamination of the meat and organs. The head skin shall be tied over the neck stub to prevent contamination of the neck stub if it will contact the dressing bed. The digestive tracts of cattle shall be removed from the carcass in one continuous piece to avoid contamination of the carcass.

(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 employe.

(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 employe 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 employes' 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 and Passed" until the bruised portion has been removed.

(n) Lungs affected with disease, or pathology, or chemical or biological residue shall be condemned and denatured, and shall not be used for animal feed.

(o) 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 by trimming with a clean knife 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) 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.

(u) After stunning, cattle hides or carcasses shall not be washed or sprayed with water until after inspection has been completed.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (3) (n) and (r), Register, September, 1972, No. 201, eff. 10-1-72; r. and recr. (2) (b), am. (3) (a) and (p), cr. (3) (u), Register, October, 1983, No. 334, eff. 11-1-83.

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ATCP 55.18 Disposition of diseased carcasses and parts.
(1) GENERAL. (a) Cause for condemnation on postmortem inspection may include but is not limited to the following conditions:

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

(b) Parts of carcasses may be condemned for:

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

(2) TUBERCULOSIS. The following procedures shall apply to the disposition of carcasses of livestock, based on the difference in the pathogenesis of tuberculosis in swine, cattle, sheep, goats, and equines:

(a) *Carcasses condemned.* The entire carcass of swine, cattle, sheep, goats, and equines 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 on antemortem inspection the animal is observed to have a fever found to be associated with an active tuberculosis lesion on postmortem inspection.

3. When there is an associated cachexia.

4. When a tuberculosis lesion is found in any muscle or intermuscular tissue, or bone, or joint, or abdominal organ (excluding the gastro-intestinal tract) or in any lymph node as a result of draining a muscle, bone, joint, or abdominal organ (excluding the gastro-intestinal tract).

5. When the lesions are extensive in tissues of either the thoracic or abdominal cavity.

6. When the lesions are multiple, acute, and actively progressive.

7. When the character or extent of the lesions otherwise is not indicative of a localized condition.

(b) *Organs or other parts condemned.* An organ or other part of a swine, cattle, sheep, goat, or equine 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) *Carcasses of cattle passed without restriction for human food.* Carcasses of cattle may be passed without restriction for human food only when the carcass of an animal not identified as a reactor to a tuberculin test administered by federal or state animal officials or an accredited veterinarian is found free of tuberculosis lesions during postmortem inspection.

(d) *Portions of carcasses and carcasses of cattle passed for cooking.* 1. When a cattle carcass reveals a tuberculosis lesion or lesions not so severe or so numerous as the lesions described in par. (a), the unaffected portion of the carcass may be passed for cooking if the character and extent of the lesions indicate a localized condition, and if the lesions are calcified or encapsulated, and provided the affected organ or other part is condemned.

2. When the carcass of a cattle identified as a reactor to a tuberculin test administered by federal or state animal health officials or an accredited veterinarian is found free of lesions of tuberculosis, the carcass may be passed for cooking.

(e) *Portions of carcasses and carcasses of swine passed without restriction for human food.* Swine carcasses found free of tuberculosis lesions during postmortem inspection may be passed for human food without restriction. When tuberculosis lesions in any swine carcass are localized and confined to one primary seat of infection, such as the cervical lymph nodes, the mesenteric lymph nodes, or the mediastinal lymph nodes, the unaffected portion of the carcass may be passed for human food without restriction after the affected organ or other part is condemned.

(f) *Portions of carcasses of swine passed for cooking.* When the carcass of any swine reveals lesions more severe or more numerous than those described in par. (e), but not so severe or so numerous as the lesions described in par.

(a), the unaffected portions of such carcass may be passed for cooking if the character and extent of the lesions indicate a localized condition, and if the lesions are calcified or encapsulated, and provided the affected organ or other part is condemned.

(g) *Carcasses of sheep, goats, and equines passed without restriction for human food.* Carcasses of sheep, goats, and equines may be passed without restriction for human food only if found free of tuberculosis lesions during post-mortem inspection.

(h) *Portions of carcasses of sheep, goats, and equines passed for cooking.* If a carcass of any sheep, goat, or equine reveals a tuberculosis lesion or lesions that are not so severe or so numerous as the lesions described in par. (a), the unaffected portion of the carcass may be passed for cooking if the character and extent of the lesions indicate a localized condition, and if the lesions are calcified or encapsulated, and provided the affected organ or other part is condemned.

(i) *Carcasses and parts passed for cooking; utilization for food purposes after cooking.* Carcasses and parts passed for cooking may be used for the preparation of meat food products, provided all such carcasses or parts are heated to a temperature not lower than 170° F. for a period of not less than 30 minutes either before being used in or during the preparation of the finished product.

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

(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 postmortem 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 postmortem inspection to be affected with anasarca to a lesser extent than in par. (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 sub.

(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 pars. (c) and (d).

(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 animals has been adversely affected by the size, position or nature of the neoplasm, the entire carcass shall be condemned.

(12) **EPITHELIOMA OF THE EYE.** (a) Carcasses of animals affected with epithelioma of the eye, or the orbital region 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 metastasis from the eye, or the orbital region, to any lymph node including the parotid lymph node, 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, or the orbital region, to a lesser extent than as described in par. (a) may be passed for human food after removal and condemnation of the head, including the tongue, provided the carcass is otherwise normal.

(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, ABSCESSSES, PUS.** All slight, well-limited abrasions, when without lymph node involvement, shall be carefully excised, leaving only sound, nor-

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mal 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 infection at its onset, 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 infection, 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 the 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 (CYSTICERCUS BOVIS) IN CATTLE. Carcasses of cattle affected with tapeworm cysts shall be disposed of as follows:

(a) Infested carcasses shall be condemned if infestation is extensive or if the musculature is edematous or discolored. Infestation shall be considered extensive if cysts are found in 2 or more of the usual inspection sites plus 2 or more muscle tissue locations exposed by incision.

(b) Carcasses showing a lesser degree of infestation than described above may be passed for food after lesions have been excised, provided that such carcasses are appropriately identified and retained under department control at

a temperature of not higher than 15° F. for not less than 10 days, or in the case of boned meat in properly identified and retained containers for a period of not less than 20 days at temperatures not higher than 15° F. Alternatively, such carcasses or meat therefrom may be heated throughout to a temperature of not less than 140° F., under positive control of a program inspector.

(c) Edible viscera and offal shall be disposed of in the same manner as the rest of the carcass from which derived unless any lesions of *Cysticercus bovis* is found in their by-products, in which case they shall be condemned. 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 HUMANS; TAPEWORM 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 humans, 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 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 impracticable, 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.

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(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 pars. (a) and (b) 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.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (2), Register, September, 1972, No. 201, eff. 10-1-72; r.(4), Register, April, 1975, No. 232, eff. 5-1-75; am. (17), Register, October, 1983, No. 334, eff. 11-1-83.

ATCP 55.185 Denaturing and handling condemned carcasses and parts. (1) Carcasses, parts and organs condemned on postmortem inspection shall be thoroughly slashed and denatured on all surfaces with a 2% solution of carbolic acid, cresylic acid or other denaturant approved by the department, and be sent to rendering.

(2) Carcasses, parts and organs which are condemned on postmortem inspection, but which are not septic or toxic, may leave the slaughter plant for use as animal food, provided that all surfaces have been thoroughly slashed and denatured with powdered charcoal or other denaturant approved by the department. This includes carcasses, parts and organs which are condemned solely because of anasarca, ocular squamous cell carcinoma (after removal of neoplastic tissue), emaciation, eosinophilic myositis, immaturity, nonseptic bruises or injuries, or sarcosporidiosis.

(3) All denaturing materials and equipment shall be supplied by the plant and be readily available at all times. Denaturing materials shall be applied in the inedible room by plant employes under the supervision of the inspector.

(4) Plant employes shall not trim or cut into any carcass to remove or expose abnormal tissues unless directed to do so by the inspector. When so directed, portions of a carcass which are unfit shall be removed in one piece without trimming. Unfit portions shall be removed in a manner so as not to contaminate the remainder of the carcass. Unfit portions shall be condemned and denatured.

(5) Condemned carcasses, parts and hides shall not be dragged on the floor into the inedible room.

(6) Product condemned on postmortem examination shall be under visual control of the inspector until slashed and denatured.

(7) Carcasses, parts and organs saved for animal food shall not contact material condemned for pathological reasons and shall be stored separately to avoid cross-contamination. Carcasses, parts and organs saved for animal food which are not separately stored and transported shall be denatured with carbolic or cresylic acid and sent to rendering.

History: Cr. Register, October, 1983, No. 334, eff. 11-1-83.

ATCP 55.19 Humane slaughter. (1) All slaughtering of livestock shall be accomplished by humane methods as defined by s. 95.80, Stats.

(2) Methods of slaughter recognized as being humane include:

- (a) Captive bolt devices.
- (b) Electrical stunning.
- (c) CO₂ gas chamber.
- (d) Gun shot.
- (e) Rabbinical slaughter procedure (koshering).

(3) Any method which involves penetration of the skull cavity by projectile (bullet) or bolt, thereby carrying hair, bone fragments, skin, dirt or lead fragments into the brain, renders the brain of such animal unsuitable for food.

(4) Heads, head meat and cheek meat, the tongue excluded, from animals killed by gunshot shall not be saved for food purposes.

(5) In no instance shall animals be shackled and hoisted, stuck, or cut before being rendered insensible to pain, except as accomplished in Rabbinical Slaughter Procedures.

(6) Livestock pens, driveways and ramps shall be constructed and maintained to prevent the accidental injury of animals.

(7) Driving of animals shall be done with a minimum of excitement and discomfort to the animals. Implements employed to drive animals shall be used as little as possible in order to minimize excitement and injury. Sharp or pointed objects or items which would cause injury or unnecessary pain to the animal shall not be used to drive livestock.

(8) Animals shall have access to drinking water in all holding pens, and access to feed if held longer than 24 hours. Animals shall have sufficient room to lie down in the holding pen if held overnight.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; cr. (6), (7) and (8), Register, October, 1983, No. 334, eff. 11-1-83.

ATCP 55.20 Obstruction of department employes. (1) The obstruction of any department employe in the performance of his or her duties, by the owner or operator of any establishment or associates or employes, shall be cause for license revocation or denial. Obstruction or denial of access for inspection purposes in establishments where inspection is required as a condition to the sale of meat or meat food products shall further be grounds for the immediate suspension or withdrawal of inspection services on notice or order of the department.

(2) The term "obstruction" includes verbal or physical abuse, the making of threats, the use of offensive language, the use of physical restraint or any other act which impedes, interferes with or impairs the capacity of a depart-

ment inspector or employe to perform an orderly and full inspection as required by law.

(3) When inspection services are withdrawn under sub. (1), the owner or operator of the establishment concerned may upon written request demand a hearing thereon within 10 days after suspension or withdrawal of inspection services. Such request shall not serve to stay the suspension or withdrawal of inspection services.

History: Cr. Register, September, 1972, No. 201, eff. 10-1-72.

ATCP 55.30 Frozen food lockers and processor. Frozen food locker and frozen food processing plants, subject to licensing under ss. 97.27 and 97.29, Stats., shall be constructed, maintained and operated in conformity with this chapter.

(1) **RESTRICTIONS.** (a) The processing of any food not intended for human consumption is prohibited in a frozen food locker or frozen food processing establishment.

(b) No food products, materials or other substances having any strong or characteristic odor which would adversely affect the quality of meat products, poultry products, or meat food products shall be processed or stored at any frozen food locker or processing plant, or in any way commingled with such meat products, poultry products, or meat food products.

(c) No unwrapped food product shall be placed in any storage locker.

(d) The storage of food not intended for human consumption is prohibited unless such foods are contained in non-permeable, sealed packages and containers and are stored separate and apart from any food for human consumption.

(2) **PRODUCT IDENTIFICATION.** (a) All packages of foods placed or stored in any frozen food locker by the owner or operator of the plant for individual customers shall be clearly marked so as to identify the product and the owner thereof. Products cut, wrapped and frozen by the operator of a food processing plant and placed in a frozen food locker by such operator, shall be further marked to include the date of processing.

(b) Products cut, wrapped or frozen by the operator of a frozen food processing plant shall, prior to storage or delivery to the customer, be marked "NOT FOR SALE" in block letters not less than 3/8 inch in height.

(c) Any food not intended for human consumption held at any food locker or processing plant shall be plainly and conspicuously marked or labeled by the plant operator "NOT FOR HUMAN CONSUMPTION" in block lettering not less than 3/8 of an inch in height.

History: Cr. Register, April, 1975, No. 232, eff. 5-1-75; correction in (intro.) made under s. 13.93 (2m) (b) 7, Stats., Register, April, 1993, No. 448.

ATCP 55.45 Mobile slaughterers and mobile processors.

(1) **REGISTRATION; IDENTIFICATION NUMBER.** No person shall engage in business as a mobile slaughterer or mobile processor, without registering with the department his or her name and address, including the business name and address. Each person registered as a mobile slaughterer or mobile processor shall be assigned an official identification number.

(2) **PRODUCT IDENTIFICATION.** (a) *Brands.* Each mobile slaughterer shall provide an approved metal stamp or brand incorporating the assigned identification number and bearing the words "NOT FOR SALE", of a design which conforms with the stamp or brand as prescribed under s. ATCP 55.09 (1) (b), for use in the marking and identification of carcasses and products.

(b) *Identification and marking of product.* All carcasses of animals slaughtered by a mobile slaughterer shall immediately after slaughter and prior to their removal from the premises at which slaughtered, be legibly stamped or branded on each side, quarter, or other part thereof with the stamp or brand as prescribed under par. (a).

(3) **FACILITIES AND SANITATION.** (a) *Facilities and equipment.* The inside surfaces of trucks, vans or trailers used in the processing or transportation of carcasses or other products, shall be so designed and constructed as to be capable of being readily and thoroughly cleaned and be maintained in a sanitary condition.

(b) *Utensils and tools.* Utensils and tools used for mobile slaughter or mobile processor operations shall be cleaned after each use, and more frequently as necessary to keep them in a clean and sanitary condition. Facilities shall be available for the thorough cleaning and sanitizing of equipment and utensils. Sanitizing of equipment and utensils may be accomplished either by the use of hot water or a sanitizing solution. Where a sanitizing solution is used, it shall be followed by a thorough rinsing with clean water.

(c) *Personnel.* Personnel engaged in the slaughtering, processing and handling of carcasses and products shall wear clean and washable outer clothing, and shall wash and rinse their hands sufficiently during the operations to prevent contamination of carcasses and products.

(d) *Water supply.* Potable water in sufficient quantity for the thorough washing and cleaning of carcasses and equipment shall be available during slaughtering or processing operations.

(4) **TRANSPORTATION OF CARCASSES.** Transportation of carcasses or products shall be in accordance with the provisions of s. ATCP 55.06. If inedible product generated in the slaughtering or processing operation is to be transported on the same vehicle with edible product, such inedible product shall be transported in waterproof and tightly covered containers, or in separate waterproof compartments, so as to prevent spillage or leakage of liquid wastes, or the contamination of edible product. Carcasses which are not processed on the farm shall be delivered only to licensed meat establishments for processing.

(5) **DISPOSITION OF UNWHOLESOME, ADULTERATED OR MISBRANDED PRODUCTS.** Any carcasses or products resulting from a mobile slaughtering operation shall be fully subject to the provisions of s. ATCP 55.07 relating to the seizure, retention, condemnation and disposition of unwholesome, adulterated or misbranded products.

(6) **RECORD KEEPING; REPORTS.** Mobile slaughterers and mobile processors shall maintain monthly records of all animals slaughtered or processed by them, including the name and address of the owners of animals slaughtered or processed, a description of the animals slaughtered, and the disposition of carcasses or product derived from such

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slaughtering or processing operation transported by the mobile slaughterer or processor. Monthly reports shall be submitted to the department for those months slaughtering or processing operations were conducted on forms prescribed for this purpose not later than the 10th day of each ensuing month.

History: Cr. Register, April, 1975, No. 232, eff. 5-1-75; am. (1) (3)(b),(c) and (d), (4) and (6), Register, October, 1983, No. 334, eff. 11-1-83