

Chapter Ag 47

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History: Chapter Ag 47 as it existed on September 30, 1971 was repealed and a new chapter Ag 47 was created, Register, September, 1971, No. 189, effective October 1, 1971.

**Ag 47.01 Scope of rules.** 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.

**Ag 47.02 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, residues accumulations, filth, rubbish, garbage, insects, vermin or other unsightly, offensive or extraneous matter.

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

(5) "Frozen food locker plant" means a locker plant as defined in s. 99.01 (6), 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), Stats., where such products are stored.

(6) "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.

(7) "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.

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

(9) "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.

(10) "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.

(11) "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.

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

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

(14) "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.

(15) "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.

(16) "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.

(17) "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), Stats.

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

(19) "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.

(20) "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.

(21) "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.

(22) "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.

(23) "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.

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. 11-26-86; cr. (23), Register, May, 1986, No. 365, eff. 6-1-86.

Ag 47.03 Facilities, sanitation and records. (1) RESPONSIBILITY. (a) Every establishment shall be maintained and operated in conformity with the requirements of this section.

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

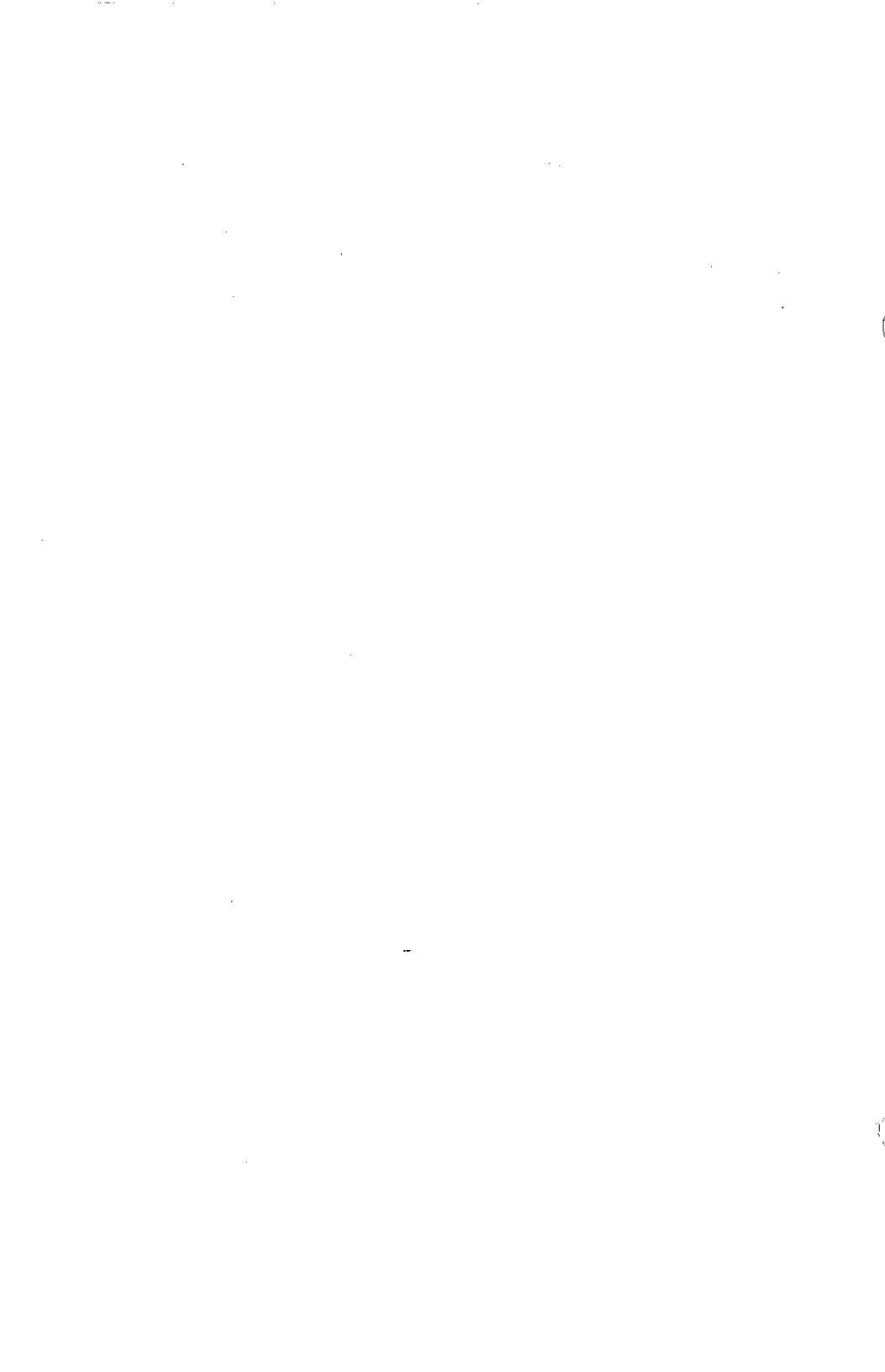
(e) Structures shall be so located that the product does not become contaminated through contact with floors, walls or other structures.

(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

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(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 employes 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

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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.

**Ag 47.04 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.

**Ag 47.06 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 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.

**Ag 47.07 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, re-Register, October, 1983, No. 334



tail 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 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.

**Ag 47.08 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 composited meat or poultry food product sold or offered for sale must bear an appropriate label stating the true name of the product; the product ingredients; the name and address of the processor or distributor; the net weight of the product; the inspection legend; and, if the product is perishable, the words "Keep Refrigerated." This does not apply to a product prepared and sold at a retail market if the product is accompanied by a counter tag showing the name of the product and a listing of ingredients.

(b) All labels and labeling information used in the labeling of products in licensed meat establishments shall be submitted to the department for

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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) Any noncomposited 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, the net weight, and the name and address of the processor.

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.

**Ag 47.09 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) All primal parts and detached organs of animals custom slaughtered or processed shall be plainly marked by the slaughterer, or operator of the establishment where such animals are slaughtered or processed or by his agents or employes, immediately after slaughter, or if not slaughtered at such establishment, at the time of entering the establishment, with the establishment or identification number assigned by the department and the words "NOT FOR SALE." The establishment number or name, and the words "NOT FOR SALE," shall also be marked, at the time of packaging, on all boxes, cartons, packages or containers in which custom processed products are packaged, and on each piece of sausage which is of the ordinary ring variety or a larger variety. The words "NOT FOR SALE" shall be set forth in block letters not less than  $\frac{3}{8}$  inch in height. Stamps, brands and marks for this purpose shall be approved by the department. This paragraph shall apply to all persons engaged in custom slaughtering or processing, including a mobile slaughterer.

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(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 estab-

ishment. 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 regulation 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 employees, and not for sale, shall be slaughtered in establishments where meat inspection is maintained under s. 97.42 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.

Register, May, 1986, No. 365

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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.

**Ag 47.10 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."

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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.



(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

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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.

**Ag 47.11 Prescribed treatment of pork and products containing pork to destroy trichinae.** (1) **PRODUCTS.** Products named in this subsection and products of the character thereof, containing pork muscle tissue (including hearts, pork stomachs, and pork livers), or the pork muscle tissue which forms an ingredient of such products, shall be effectively heated, refrigerated, or cured to destroy any possible live trichinae; bologna; frankfurts; viennas; smoked sausage, knoblauch sausage; mortadella; all forms of summer or dried sausage, including mettwurst; ground meat mixtures containing pork and beef, veal, lamb, mutton or goat meat and prepared in such a manner that they might be eaten rare or without thorough cooking; flavored pork sausage such as those containing wine or similar flavoring materials; cured pork sausage; sausage containing cured and/or smoked pork; cooked loaves; roasted, baked, boiled, or cooked hams; pork shoulders, or pork shoulder picnics; Italian-style hams; Westphalia-style hams; smoked boneless pork shoulder butts; cured meat rolls, capocollo (capicola, capicola); coppa; fresh or cured boneless pork shoulder butts, hams, loins, shoulders, shoulder picnics, and similar pork cuts, in casings or other containers in which ready-to-eat delicatessen articles are customarily enclosed (excepting Scotch-style hams); breaded pork products, cured boneless pork loins; boneless back bacon; smoked pork cuts such as hams, shoulders, loins and pork shoulder picnics (excepting smoked hams and smoked pork shoulder picnics which are specially prepared for distribution in tropical climates or smoked hams delivered to the armed services). Cured boneless pork loins shall be subjected to prescribed treatment for destruction of trichinae prior to being shipped from the establishment where cured.

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

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

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

(b) *Refrigerating.* 1. At any stage of preparation and after preparatory chilling to a temperature of not above 40° F. or preparatory freezing, all parts of the muscle tissue of pork or pork product containing such tissue shall be subjected continuously to a temperature not higher than one of

those specified in Table 1, the duration of such refrigeration at the specified temperature being dependent on the thickness of the meat or inside dimensions of the container.

**TABLE 1—REQUIRED PERIOD OF FREEZING AT TEMPERATURE INDICATED**

°F.	Temperature	
	Group 1 Days	Group 2 Days
5 .....	20	30
—10 .....	10	20
—20 .....	6	12
—30 or below .....	momentary attainment	

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

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

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

(c) *Curing.* Sausage and other pork products may be treated for destruction of trichinae by special curing methods approved by the department.

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

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.

**Ag 47.12 Canning with heat processing and hermetically sealed containers.** Meat and meat food products and poultry and poultry food products may be processed by canning methods approved 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.

**Ag 47.13 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 re-Register, October, 1983, No. 334



quire 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.
8. All other days which are official holidays for state employes.

(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.

**Ag 47.14 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 in-

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spection carried on by the department, a cooperative agreement may be approved.

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

**Ag 47.15 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.

**Ag 47.16 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 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.** (a) 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:

1. Elevated temperature
2. Malignant neoplasms
3. Multiple abscesses
4. Immaturity
5. Emaciation

6. Icterus
7. Polyarthritis
8. Central nervous diseases
9. Edema or anasarca
10. In crippled or downer cattle, the following conditions associated with symptoms of systemic disease:
  - a. Skin conditions or changes, including:
    - i. Extremely pale skin (anemia).
    - ii. Yellowish colored skin (jaundice).
    - iii. Extreme thinness (emaciation).
    - iv. Draining sores or maggots.
    - v. Abscesses.
    - vi. Hot, painful sores (inflammation).
    - vii. Reddish-blue discoloration of membranes in mouth, nose, vagina, or eyes.
    - viii. Pockets of fluid (edema).
  - b. Digestive system conditions or changes, including:
    - i. Diarrhea, especially if bloody or foul smelling.
    - ii. Extreme stomach dilation (bloat).
    - iii. Ketosis (odor of acetone on breath).
  - c. Reproductive system conditions or changes, including:
    - i. Retained placenta.
    - ii. Calving with any symptoms or evidence of metabolic disease or infection.
    - iii. Vaginal discharges, including pus, hemorrhage, or foul odor.
    - iv. Prolapsed uterus.
    - v. Mastitis (septicemic or gangrenous).
  - d. Urinary system conditions or changes, including:
    - i. Bloody urine.
    - ii. Water belly (urinary obstruction).
    - iii. Uremia.
  - e. Nervous system conditions or changes, including:
    - i. Abnormal behavior suggesting brain or major nerve damage (rabies, listeriosis, lead poisoning).
    - ii. Weak response to stimulation with a sharp object or electric shock.

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- iii. Tremors, shaking, or muscle twitching.
- f. Respiratory system conditions or changes, including:
  - i. Rapid or labored breathing (pneumonia).
  - ii. Nasal discharge containing pus, dead tissue, or blood.
- g. Musculoskeletal conditions or changes, including:
  - i. Extreme weakness, including an inability to sit up.
  - ii. Massive injury to two or more legs.
  - iii. Swollen joints.
  - iv. Hip clamp injuries.
- h. Other conditions or changes, including:
  - i. Fever greater than 104° F., or subnormal temperature less than 99° F.
  - ii. Cancer, including enlarged lymph nodes and eye malignancy.
  - iii. Less than complete recovery from major surgery, as evidenced by unhealed wounds or recent scars from hardware, caesarian, or abdominal surgery.

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

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

(d) Animals suspected of having been treated or exposed to any substance in a manner which may impart a biological residue or reaction that may make the edible tissues of the animal unwholesome or otherwise unfit for human food, shall be marked "Suspect." The animals shall be held under custody of department 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.

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

(6) **EMERGENCY SLAUGHTER.** (a) Animals accidentally injured may be slaughtered on an emergency basis if they are submitted for slaughter within 24 hours after the injury was incurred. In all cases of emergency slaughter, the animals shall be inspected immediately before slaughter. When the necessity for emergency slaughter exists, the establishment shall notify the meat inspector so that such inspection may be made. In the absence of a department inspector, a licensed practicing veterinarian

may be called at the establishment's expense, and such veterinarian shall submit a written statement of his findings to the department.

(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. Downer animals which do not qualify for emergency slaughter 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 animals. 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 employes 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.

**Ag 47.17 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.