



Meat Messenger

North Dakota State Meat and Poultry Inspection Program

2018 Quarter 2

A Message from the Commissioner

Greetings,

The North Dakota Meat and Poultry Inspection Program (NDMPIP) currently inspects 13 North Dakota companies and 77 custom exempt facilities in the state.

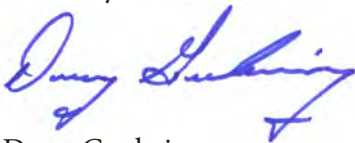
We know that some regulations affecting your industry can be updated or made more workable, and there is a push for federal agencies to reduce the regulatory burden on business. This federal administration has been accessible, accommodating, and encourages us to assist in this process.

Please let us know about regulations that are outdated or overly burdensome by visiting with your local inspector; by contacting Dr. Andrea Grondahl, livestock industries division director, at 701-328-4762 or agrondah@nd.gov; or by contacting Shaun Quissell, government affairs division director, at 701-328-4761 or squissell@nd.gov. We will ensure your concerns are heard by providing comment to federal agencies and discussing them when we meet with regulatory officials.



As we go forward with the budget for the next legislative session, we will continue to fully support the program. Please let us know where we can assist you or the industry in continuing to ensure a safe and economical meat supply for consumers.

Sincerely,



Doug Goehring

What would you like to read in the next issue?

The Meat Messenger is your newsletter. If you like the content, please feel free to share this issue with your employees, your livestock producers and customers. We welcome any questions, comments, or suggestions for future topics. Please contact **Nathan Kroh** at nkroh@nd.gov or 701-328-4767 or **Julie Nilges** at jnilges@nd.gov or 701-204-3248.

Meat Messenger

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Regulation Reminder

4.1-31-18. Cooperation with federal government.

The commissioner shall cooperate with the United States Department of Agriculture to develop and administer the state meat inspection program provided for under this chapter and to ensure its requirements are at least equal to those imposed by federal law. The commissioner may accept, from the United States Department of Agriculture, advice and assistance in planning and otherwise developing the state meat inspection program; technical and laboratory assistance and training, including necessary curricular and instructional materials and equipment; and financial and other assistance for the administration of the program.

Clean *then* Sanitize

Improperly using sanitizer can be dangerous. Too much sanitizer can be toxic and too little will not destroy bacteria and viruses, so all food processors must know how to prepare and use sanitizers.



Bacteria can grow very quickly in damp cloths. That is why all wiping cloths should be stored in a sanitizing solution that is mixed to proper concentration between uses. The bucket of sanitizer should be replaced every 2-3 hours, depending on usage. Food debris uses up the sanitizer, so a bucket of dirty sanitizer water is not an effective sanitizer.

Do not mix other chemicals or soap with the sanitizer because it changes the effectiveness, and even worse, the sanitizer and soap could potentially react and release toxic fumes. The only effective way to clean and sanitize is to clean then sanitize.

Maricopa County, Arizona. *Food Safety Manual for the Food Service Worker*. Dec. 2006, <https://www.arizonascots.com/GamesForms/FoodSafety.pdf>.

Molds: What Are They and Are They Hazardous?

There are an estimated 300,000 or more species of molds that live on plant or animal matter. Molds are fungi that spread through microscopic spores released into the air water or carried by insects. Think of thistle or weed seeds blowing through the air from place to place. Airborne mold spores often grow throughout entire rooms and can contaminate other areas of facilities as well.

Mold may be visible on the surface of food, but surface molds can be embedded deep into the food with rootlike threads, used to extract nutrients. Some dangerous varieties of molds often release toxic byproducts (mycotoxins), break down food, and simply make food unwholesome.

Moldy food is often unsafe because it can trigger allergic reactions, including breathing difficulties, or in some situations the mycotoxins can cause illness. Mycotoxins are poisonous substances produced by certain molds found primarily in grain and nut crops, and other foods such as celery, grape juice and apples. The Food and Agriculture Organization (FAO) of the United Nations estimates that 25 percent of the world's food crops are affected by mycotoxins. The most notable mycotoxins are aflatoxins, cancer-causing poisonous contaminants, often found in animal feeds. The prevention of aflatoxin is one of the most challenging toxicology issues of present time.

Even though most molds prefer warmer temperatures, they can grow at refrigerator and freezing temperatures. Molds also tolerate salt and sugar better than most other yeasts and bacteria. Controlling pH of food is the greatest controlling factor for both bacterial and mold growth concerns. Meat from well-rested animals may have a lower pH than meat from fatigued animals, so humane slaughter practices influence mold and bacteria growth. Foods might start with a pH which precludes bacterial growth, but as a result of metabolism of other microbes (yeasts or molds), pH shifts may occur and permit bacterial growth. Water activity, pH and temperature of the food must be considered when trying to control mold, which is also important in controlling bacteria.

Being vigilant while cleaning is vital for controlling mold. Molds on affected foods release spores, which can build up in your coolers, refrigerator, scrub brushes and other cleaning utensils, leading to contamination of much more than the you can see. Trim moldy carcasses often and deep-clean coolers on a regular basis to prevent the accumulation of molds throughout your facility.

United States Department of Agriculture Food Safety and Inspection Service. https://www.fsis.usda.gov/wps/portal/food-safety-education/get-answers/food-safety-fact-sheets/safe-food-handling/molds-on-food-are-they-dangerous/ct_index.

Food and Drug Administration. *Bad Bug Book: Foodborne Pathogenic Microorganisms and Natural Toxins*. 2012, <https://www.fda.gov/food/foodborneillnesscontaminants/causesofillnessbadbugbook/ucm2006773.htm>.

GRILLIN' like a...

P = Place the Thermometer!
Place the food thermometer into the **thickest** part of the meat.

145 °F W/ 3 MIN REST		STEAKS
145 °F W/ 3 MIN REST		PORK CHOPS
165 °F		CHICKEN
160 °F		GROUND BEEF

R = Read the Temp!
Wait about **10-20 secs** for the temperature to be accurately displayed. Foods must reach the safe internal temps listed here for safety.

O = Off the Grill!
Once the meat is at a safe temperature, take it off the grill.

Put cooked food on a **CLEAN PLATE!**

Label Submissions: Required Documentation Supporting Claims of Animal Raising

An inspected meat or poultry establishment is required to use labels that are in compliance with the Federal Meat Inspection Act, the Poultry Products Inspection Act and all the implementing regulations.



The Food Safety and Inspection Service (FSIS) has updated the compliance guideline on documentation needed to support animal-raising claims. The updated guideline refers to the types of supporting documentation required with label submissions to support these claims.

Required for all mandatory labeling requirements as prescribed in Title 9 of the Code of Federal Regulations section 317.2 and 381 Subpart N., animal-raising claims and all labels with or without special claims, have to be submitted to the North Dakota Meat & Poultry Inspection Program (NDMPIP) prior to being used on the product for compliance under 9 CFR 412.1(c)(3). All labels with special claims and labels with animal-raising claims must be submitted with specific documentation to support all such claims that appear on that label. Examples of animal-raising claims include, but are not limited to:

- Raised without antibiotics
- Organic

- Grass-fed
- Free-range
- Raised without the use of hormones

For most animal-raising claims, the documentation typically needed to support these claims includes:

1. A detailed written description explaining the controls used for ensuring that the raising claim is valid from birth to harvest or the period of raising being referenced by the claim;
2. A signed and dated document describing how the animals are raised (e.g., vegetarian-fed, raised without antibiotics, grass-fed), to support that the specific claim made is truthful and not misleading;
3. A written description of the product-tracing and segregation mechanism from time of slaughter or further processing through packaging and wholesale or retail distribution;
4. A written description for the identification, control, and segregation of non-conforming

animals or products; and

5. If the claim is certified by a third party, a current copy of the certification is needed.

This updated guideline includes definitions for frequently used animal-raising claims, the detailed supporting documentation

required for each specific claim that appears on the label, additional information regarding the claim “grass-fed,” information required for duplicating raising claims from purchased product, and examples of labels bearing claims.

The updated guideline should be encouraged for establishments with producers and customers that wish to submit request for approvals of animal-raising claims on product labels to begin using this guideline.

For more information and direction, talk with your inspector before assuming any claim is ok for a label. The guideline is available at: <https://www.fsis.usda.gov/wps/portal/fsis/topics/regulatory-compliance/compliance-guides-index>. Once copies of the guideline have been published, go to <http://www.fsis.usda.gov/wps/wcm/connect/6fe3cd56-6809-4239-b7a2-bccb82a30588/RaisingClaims.pdf?MOD=AJPERES>.

Revised Guideline Appendix A and B: Implementation Date Set

On June 16, 2017, FSIS published a Federal Register Notice announcing the availability of two updated compliance guidelines regarding the destruction (lethality) of Salmonella and other pathogens in ready-to-eat (RTE) products and the control of pathogen growth in heat-treated RTE and not-ready-to-eat (NRTE) products during hot-holding and cooling (stabilization). FSIS is including the time-temperature tables and cooling options in these guidelines that were previously found in Appendices A and B. The guidelines, which were originally made available in 1999, have new recommendations that establishments can use to achieve lethality and stabilization of these products. Further, that FSIS is providing establishments using the 1999 versions of FSIS Appendix A and B as scientific support for lethality and stabilization procedures, one year from 3/22/2018, the date of issuance FSIS Notice 17-18, to review the revised lethality and stabilization guidance issued in 2017 and determine whether additional documentation or changes are needed to support their process required in title 9 CFR 417.5(a)(1), and to then validate any changes made to follow the new guidelines or additional support over 90 calendar days (9 CFR 417.4(a)(1)).

The changes are to clarify cooking and cooling recommendations in response to commonly asked questions and more current scientific information. A summary of the major changes to the 1999 versions of Appendix A and B are as follows.

1. For Appendix A, FSIS has re-emphasized that the humidity recommendations apply to all

cooked products (including poultry) unless the establishment can support humidity does not need to be addressed. FSIS has not changed the humidity recommendations other than re-emphasizing that they apply to all products. The time temperature tables previously found in Appendix A also have not changed.

2. For Appendix B, FSIS has specified that:
 - a. Option 1 applies to both partially cooked small mass products and fully cooked products while other stabilization options apply only to fully cooked products.
 - b. Option 1 also now includes a recommended come up time to the final heating temperature for partially cooked products of less than or equal to 1 hour.
 - c. Option 2 includes multiple parts to the recommendation: Chilling should begin within 90 minutes after the cooking cycle is completed. All product should be chilled from 120°F to 80°F in 1 hour and from 80°F to 55°F in 5 hours (6 hours total cooling time) followed by continuous chilling until the product reaches 40°F.
 - d. To use Option 3, establishments should incorporate at least 250 ppm sodium erythorbate or ascorbate, along with at least 100 ppm ingoing sodium nitrite (either from a purified or natural source such as celery powder).
 - e. Option 4 was added to

incorporate guidance that had been in FSIS Directive 7110.3 (cancelled by FSIS Directive 7111.1). The recommendations in this option no longer apply to products with greater than or equal to 120 ppm sodium nitrite and a brine concentration of 3.5%.

Both compliance guidelines provide additional options for achieving lethality and stabilization not previously found in the 1999 versions to provide greater flexibility to establishments and also contains other useful guidance including detailed information on how to evaluate heating and cooling deviations. If an establishment chooses to adopt different procedures than those outlined in the revised Appendix A and Appendix B guidelines, they would need to support why those procedures are effective. Additional types of scientific support establishments may use include other published processing guidelines, journal articles, results of pathogen modeling programs, challenge studies, and advice from processing authorities that includes reference to scientific data.

Consult with your inspector for a copy of the major changes, or download full compliance guides on FSIS' website at: <https://www.fsis.usda.gov/wps/wcm/connect/bf3f01a1-a0b7-4902-a2df-a87c73d1b633/Salmonella-Compliance-Guideline-SVSP-RTE-Appendix-A.pdf?MOD=AJPERES> and also at <https://www.fsis.usda.gov/wps/wcm/connect/9ac49aba-46bc-443c-856b-59a3f51b924f/Compliance-Guideline-Stabilization-Appendix-B.pdf?MOD=AJPERES>.

Generic E. coli Statistical Process Control

Beginning June 1, under the Pathogen Reduction/HACCP Regulation, slaughter establishments are required to test carcasses for generic E. coli as a means of verifying their process control. How can a small or very small establishment meet the requirement of 9 CFR 310.25? First review 9 CFR 310.25(a)(2)(v)(A), which states that very low volume establishments that collect samples by sponging should collect at least one sample per week, starting the first full week of operation after June 1 of each year. They should continue sampling at a minimum of once each week the establishment operates until June 1 the following year, or until 13 samples have been collected, whichever comes first.



Establishments slaughtering cattle, swine, sheep or goats can meet the requirements of 9 CFR 310.25(a)(4) by recording the individual sample result on a Statistical Process Control (SPC) chart. Results from baseline data collected for each species below may be used as control limits. The sampling should occur at the flank, brisket and rump for cattle, sheep and goats; and ham, belly and jowl for swine. The establishment plots its test results on a control chart and compares them to the UCL (upper control limit) and LCL (lower control limit) to evaluate process control. These limits are derived from baseline data collected by or for FSIS.

For cattle, the LCL and UCL (cfu/cm²) is 0.0 to 3.1 respectively. For swine, the LCL and UCL (cfu/cm²) is 0.46 to 400 respectively. If no more than three sample results out of the 13 are above the 0.00, the process is in control.

United States Department of Agriculture Food Safety and Inspection Service. "Generic E. coli Statistical Process Control." Aug. 31, 2017, https://askfsis.custhelp.com/app/answers/detail/a_id/149/~generic-e.-coli-statistical-process-control.

FSIS Recalls & Alerts Count (Jan - Mar 2018)

Products contaminated with bacteria	589,513 + lbs.	8 recalls
Products contaminated with extraneous materials	580,513 lbs.	7 recalls
Products that may have been under-processed	38,349 lbs.	4 recalls
Products with undeclared allergens	29,544 lbs.	9* recalls
Products made without the benefit of inspection	12,507+ lbs.	3* recalls
Products misbranded	743 lbs.	1 recall
Total Recalls 1st Quarter 2018 (*some recalls due to a multitude of reasons)		
Class 1 recalls - 28 Reasonable probability that eating the food will cause health problems or death	Class 2 recalls - 2 Potential health hazard situation in which there is a remote probability of adverse health consequences from eating the food	Class 3 recalls - 1 Situation in which eating the food will not cause adverse health consequences
Nearly 1.3 million lbs. of meat and poultry implicated in recalls		

Further information on all current recalls and alerts can be found at: <http://www.fsis.usda.gov/wps/portal/fsis/topics/recalls-and-public-health-alerts>

Classified Ads

We are always looking for industry related items to advertise in the Meat Messenger. We post sale and want ads FREE. Contact Julie Nilges (701-204-3248) at jnilges@nd.gov or Nathan Kroh (701-328-4767) at nkroh@nd.gov with product description and contact information.

A Golden Opportunity Awaits. For Sale: The Butcher Block in Oakes, N.D.

A thriving business that does custom and state inspected slaughter and processing. A large retail business, with good sales volume. Willing to train the right person or sell outright.

Call Ron at 701-742-2713.

Meat Tumbler: 500 lb. capacity, DFE Brand, without vacuum, completely stainless steel;

Smokehouses: 500 lbs.capacity each;

Globe Meat Slicer: Functioning, but needs minor work;

True Brand cooler: Cooler has two sliding doors and was manufactured in 2001 - \$1,000;

New one-quart plastic containers with lids: - \$20 per lot of 50.

Please contact Calvin or Alex for more information on any of the above at 701-743-4451. Located in Parshall.

Wanted - Carcass Rail: 50 ft. of overhead carcass rail for small animal slaughter facility. Call Fred at 701-429-8066 if you have rail for sale.

Wanted - Next-to-New Band Saw: Please call Bruce at 701-254-4232, if you have a nice condition band saw to offer for sale.

Splitting Saw for Sale: Good condition carcass splitting saw available. Located in Great Bend. For more information, call Steve Manock at 701-545-7513.

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