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TITLE 9--ANIMALS AND ANIMAL PRODUCTS

CHAPTER III--FOOD SAFETY AND INSPECTION SERVICE, MEAT AND POULTRY INSPECTION, DEPARTMENT OF AGRICULTURE

PART 318--ENTRY INTO OFFICIAL ESTABLISHMENTS; REINSPECTION AND PREPARATION OF PRODUCTS--Table of Contents

Subpart A--General

Sec. 318.23 Heat-processing procedures, cooking instructions, and cooling, handling, and storage requirements for uncured meat patties.

(a) Definitions. For purposes of this section, the following definitions shall apply:

(1) Comminuted. A processing term describing the reduction in size of pieces of meat, including chopping, flaking, grinding, or mincing, but not including chunking or sectioning.

(2) Heat-processed. Treatment by a heat source, including, but not limited to, frying, broiling, baking, or roasting, which results in a fully-cooked, partially-cooked, or char-marked product.

(3) Patty. A shaped and formed, comminuted, flattened cake of meat food product.

(b) Processing procedures for heat-processed patties. Fully-cooked, partially-cooked, or char-marked patties shall be processed as follows:

(1) Heat processing. (i) Official establishments which manufacture fully-cooked patties shall utilize one of the heat-processing procedures in Table A of this paragraph:

Table A.--Permitted Heat-Processing Temperature/Time Combinations for Fully-Cooked Patties

Minimum internal temperature at the center of each patty		Minimum holding time after maximum temperature is reached	
Degrees		Time	
Fahrenheit	or Centigrade	(Minutes)	or (Seconds)
151	66.1	0.68	41
152	66.7	.54	32
153	67.2	.43	26
154	67.8	.34	20

155	68.3	.27	16
156	68.9	.22	13
157 (and up)	69.4 (and up)	.17	10

(ii) Official establishments which manufacture partially-cooked patties shall raise the internal temperature at the center of each patty to a minimum internal temperature of 140 deg.F. and then cool it to a maximum internal temperature of 40 deg.F within 2 hours.

(iii) Official establishments which manufacture char-marked patties (if marked by a heat source) may raise the temperature at the center of each patty, but not above 70 deg.F, when the char-marks are applied to the patty. The process of char-marking the patty and cooling the patty to a maximum internal temperature of 40 deg.F shall be completed within 2 hours or less.

(iv) The official establishment shall measure the holding time and temperature of at least one heat-processed patty from each production line each hour of production to assure control of the heat process. The temperature measuring device shall be accurate within 1 deg.F.

(2) Cooling. (i) Fully-cooked patties shall be cooled to an internal temperature of 40 deg.F or below within 2 hours after heat-processing.

(ii) Cooling requirements for partially-cooked and char-marked patties are combined with those for heat-processing and are contained in paragraph (b)(1)(ii) and (iii) of this section.

(iii) The internal temperature measuring device shall be accurate within 1 deg.F.

(3) Cooking instruction label requirement. (i) Partially-cooked patties shall bear the labeling statement ``Partially-cooked: For Safety Cook Until Well Done (Internal Meat Temperature 160 deg.F)''. The labeling statement shall be adjacent to the product name, at least one-half the size of the largest letter in the product name, and prominently placed with such conspicuousness (as compared with other words, statements, designs or devices in the labeling) as to render it likely to be read and understood by the ordinary individual under customary conditions of purchase and use.

(ii) Char-marked patties. Product shall bear the labeling statement ``Uncooked, Char-marked: For Safety, Cook Until Well Done (Internal Meat Temperature 160 deg.F)''. The labeling statement shall be adjacent to the product name, at least one-half the size of the largest letter in the product name, and prominently placed with such conspicuousness (as compared with other words, statements, designs or devices in the labeling) as to render it likely to be read and understood by the ordinary individual under customary conditions of purchase and use.

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(4) Sanitary handling and storage practices. Fully-cooked patties shall be handled in accordance with the following provisions so as to assure that the patties are not recontaminated.

(i) To prevent direct contamination of fully-cooked patties, official establishments shall:

(A) Physically separate areas where unpackaged, fully-cooked patties are handled from areas where less-than-fully-cooked products are handled using a solid impervious floor to ceiling wall; or

(B) Handle unpackaged, fully-cooked patties and less-than-fully-

cooked product at different times, and cleaning the entire area after handling other products before handling unpackaged, fully-cooked patties; or

(C) Submit a written procedure through the inspector-in-charge to the Regional Director detailing the steps to be taken which would avoid recontamination of fully-cooked patties by less-than-fully-cooked cooked product during processing.

(ii) To prevent indirect contamination of fully-cooked patties:

(A) Any work surface, machine, or tool which contacts other product shall be cleaned and sanitized before it contacts unpackaged fully-cooked patties. The sanitizer shall be germicidally equivalent to 50 ppm chlorine.

(B) Employees shall wash their hands with soap and water and sanitize their hands whenever they enter the fully-cooked patty area or before handling unpackaged, fully-cooked patties. They must also wash and sanitize their hands whenever they become contaminated during operations to avoid contamination of fully-cooked patties. The sanitizer shall be germicidally equivalent to 50 ppm chlorine.

(C) All employee outer garments, including aprons, smocks, and gloves shall be identified as restricted for use in the fully-cooked area only. The employee shall change garments at least daily. The garments shall be hung in a designated location before the employee leaves the area.

(iii) Fully-cooked patties stored in the same room with other product, shall first be packaged or covered to prevent microbial contamination.

(iv) Fully-cooked, partially-cooked, and char-marked patties shall be stored at a chamber temperature of 40 deg.F or below.

(c) Requirements for handling heating or cooling deviations. (1) If for any reason a heating or cooling deviation has occurred, the official establishment shall investigate and identify the cause; take steps to assure that the deviation will not recur; and place on file in the official establishment, available to any duly authorized representative of the Secretary, a report of the investigation, the cause of the deviation, and the steps taken to prevent recurrence; and

(2) In addition, in the case of a heating deviation, the official establishment may (i) reprocess the affected product, by a method in paragraph (b)(1)(i) in this section, or (ii) use the affected product as an ingredient in another product processed to one of the temperature and time combinations in paragraph (b)(1)(i) in this section, provided this does not violate the final product's standard of composition, upset the order of predominance of ingredients, or perceptibly affect the normal product characteristics, or (iii) relabel the affected product as a partially-cooked patty product, if it meets the partially-cooked requirements in paragraph (b)(1)(ii) of this section.

(3) In addition, in the case of a cooling deviation, contact the Regional Director to determine the disposition of the product.

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