United States Department of Agriculture
Food Safety and Inspection Service
Washington, D.C. 20250

Dr. William Anderson, DVM, MSc
Director, Meat Programs Division
Canadian Food Inspection Agency
14 Colonnade
Ottawa, Ontario K2E 7M6

OCT 29 2007

Dear Dr. William Anderson:

The Food Safety and Inspection Service (FSIS) conducted an on-site audit of Canada's meat, poultry, and egg products inspection system May 1 through June 6, 2007. Comments received from the government of Canada have been included as an attachment to the final report. Enclosed is a copy of the final audit report

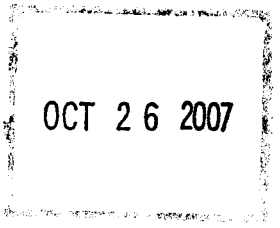
If you have any questions regarding the FSIS audit or need additional information, please contact me at telephone number (402) 344-5100, by facsimile at (402) 344-5169, or electronic mail at donald.smart@fsis.usda.gov.

Sincerely,

Donald Smart
Director
International Audit Staff
Office of International Affairs

Enclosure

FINAL



FINAL REPORT OF AN AUDIT CARRIED OUT IN CANADA COVERING CANADA'S MEAT, POULTRY, AND EGG PRODUCTS INSPECTION SYSTEM

MAY 1 through JUNE 6, 2007

Food Safety and Inspection Service
United States Department of Agriculture

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ABBREVIATIONS AND SPECIAL TERMS USED IN THE REPORT

CCA	Central Competent Authority [Canadian Food Inspection Agency]
CFIA	Canadian Food Inspection Agency
E. coli	*Escherichia coli*
FSIS	Food Safety and Inspection Service
Lm	*Listeria monocytogenes*
PR/HACCP	Pathogen Reduction/Hazard Analysis and Critical Control Point Systems
Salmonella	*Salmonella* species
SPS	Sanitation Performance Standards
SSOP	Sanitation Standard Operating Procedures
CCP	Critical Control Point(s)
RTE	Ready-to-Eat Products
MOP	CFIA Manual of Procedures

1. INTRODUCTION

The audit took place in Canada from May 1 through June 6, 2007.

An opening meeting was held on May 1, 2007, in Ottawa, Canada, with the Central Competent Authority (CCA). At this meeting, the lead auditor confirmed the objective and scope of the audit and confirmed the itineraries of the auditors.

Each auditor was accompanied during the entire audit by representatives from the CCA, the Canadian Food Inspection Agency (CFIA), and/or Area or Regional Offices.

2. OBJECTIVE OF THE AUDIT

This audit was a routine audit. The objective of this audit was to determine if Canada can continue to export meat, poultry, and egg products to the United States by evaluating the performance of the CCA with respect to controls over the slaughter, processing, and egg products establishments certified by the CCA as eligible to export to the United States.

In pursuit of the objective, the following sites were visited: the headquarters office of the CCA, two Area Offices, two Regional Offices, four microbiology laboratories, one residue laboratory, four egg products establishments, one cold storage, and 19 slaughter and/or processing establishments.

Competent Authority Visits			Comments
Competent Authority	Headquarters	1	
	Area	2	Supervise Regional Offices
	Regional	2	Supervise Certified Establishments
Microbiology Laboratories		4	
Residue Laboratory		1	
Egg Products Establishments		4	
Cold Storage Facility		1	
Meat Slaughter and Processing Establishments		5	
Meat Processing Establishments		3	
Poultry Slaughter Establishments		1	
Poultry Slaughter and Processing Establishments		1	
Poultry Processing Establishments		1	
Poultry Slaughter, Meat & Poultry Processing Establishments		2	
Meat and Poultry Processing Establishments		6	

3. PROTOCOL

This on-site audit was conducted in three parts. One part involved interviews with headquarters personnel to discuss oversight programs and practices, including enforcement activities. The second part involved interviews with CFIA inspection officials at Headquarters, Area, and Regional offices and a review of selected records in these offices. The third part involved on-site visits to four private microbiology laboratories, one government residue laboratory, one cold storage, four egg products establishments, and 19 meat and poultry slaughter and/or processing establishments.

Program effectiveness determinations of Canada's inspection system focused on five areas of risk: (1) sanitation controls, including the implementation and operation of Sanitation Standard Operating Procedures (SSOP) and Sanitation Performance Standards (SPS), (2) animal disease controls, (3) slaughter/processing controls, including the implementation and operation of Hazard Analysis and Critical Control Points (HACCP) systems and a testing program for generic *Escherichia coli (E. coli)*, (4) residue controls, and (5) enforcement controls, including testing programs for *Salmonella*. Canada's inspection system was assessed by evaluating these five risk areas.

During all on-site establishment visits, the auditors evaluated the nature, extent and degree to which findings impacted on food safety and public health. The auditors also assessed how inspection services were carried out by Canada and determined if establishment and inspection system controls were in place to ensure the production of meat, poultry, and egg products that are safe, unadulterated and properly labeled.

At the opening meeting, the lead auditor explained that Canada's inspection system would be audited against two standards: (1) CFIA laws, regulations, and other requirements, and 2) any equivalence determinations made for Canada.

Equivalence determinations are those that have been made by FSIS for Canada under provisions of the Sanitary/Phytosanitary Agreement. The following equivalence determinations have been made for Canada:

- *Salmonella* Testing of Raw Product
  - Establishments select samples
  - Private laboratories analyze samples

- *Listeria monocytogenes* (*Lm*) Testing of Ready-to-Eat (RTE) Product
  - Establishments select samples
  - Private laboratories analyze samples

- *E. coli* 0157:H7—Compositing of Samples Prior to Screening Test

- High Line Inspection System for Beef

- Canadian residue control program

- Generic *E. coli* testing for minor species
- MFLP-28 Bax® analytical method for *Lm* in RTE products
- MFLP-30 Bax® analytical method for *E. coli* O157:H7

4. LEGAL BASIS FOR THE AUDIT

The audit was undertaken under the specific provisions of United States laws and regulations, in particular:

- The Federal Meat Inspection Act (21 U.S.C. 601 et seq.).
- The Federal Meat Inspection Regulations (9 CFR Parts 301 to end), which include the PR/HACCP regulations.
- The Poultry Products Inspection Act (21 U.S.C. 451 et seq.).
- The Poultry Products Inspection Regulations (9 CFR Part 381).
- The Egg Products Inspection Act (21 U.S.C. 1031 et seq.).
- The Egg Products Inspection Regulations (9 CFR Parts 590 and 592)

5. SUMMARY OF PREVIOUS AUDITS

Final audit reports are available on FSIS' website at the following address: www.fsis.usda.gov/regulations_&_policies/foreign_audit_reports/index.asp

The last two comprehensive audits of Canada's meat and poultry inspection system were conducted in May/June 2005 and April/May 2006.

Summary of May/June 2005 Audit Findings

Government Oversight

- There was no risk-based sampling program for ready-to-eat products.
- CFIA and private laboratories were using unapproved methods to test product for *Listeria monocytogenes* and *Salmonella.*
- CFIA required a 125 gram sample size for ready-to-eat product sampling instead of a 350 gram sample size.

Sanitation Controls

- In eight establishments, there were deficiencies in implementation of the SSOP, which resulted in both potential and direct product contamination.
- In 14 establishments, there were deficiencies in implementation of Sanitation Performance Standards.

Enforcement Controls

- CFIA issued five Notices of Intent to Delist for deficiencies in SSOP, HACCP or SPS requirements. No establishments were delisted.
- In 29 of 35 establishments, CFIA was not enforcing all of the U.S. regulatory requirements, which are equivalent to Canadian requirements.

Summary of April/May 2006 Audit Findings

Government Oversight

- Significant deficiencies were noted in CFIA's oversight of private microbiology laboratories.
- There had been no direct contact between CFIA and the private laboratories giving instructions for a sample size of 325 grams for *Salmonella* testing of ready-to-eat products. Notification from CFIA of the increase to 325 grams went to the inspection force with instructions to inform the establishments, who were then to inform the private laboratories. CFIA did not follow-up with the private laboratories regarding the requirements of the *Salmonella* testing program.
- At one private laboratory, the quality assurance manager stated that not all methods used to test products for export had been validated in-house. Validation was in progress but not yet completed.

Sanitation Controls

- Eight of 21 establishments had deficiencies in the implementation of the SSOP, which resulted in both potential and direct product contamination.
- Nineteen of 21 establishments had deficiencies in the implementation of SPS.

Slaughter/Processing Controls

- Fifteen of 21 establishments had deficiencies in the implementation, corrective actions, verification, and/or recordkeeping parts of the HACCP requirements.
- In one establishment, no stand was available to perform the testing for generic *E. coli*, which made it difficult to collect the sample in a sanitary manner.
- Instead of collecting 325 grams of product for *Salmonella* testing, only 25 grams of product was being collected.

Enforcement Controls

- CFIA issued one Notice of Intent to Delist for deficiencies in HACCP, SSOP, or SPS requirements. No establishments were delisted.
- In 20 of 21 establishments, CFIA was not enforcing all of the U.S. regulatory requirements, which are equivalent to Canadian requirements.

6. MAIN FINDINGS

6.1 Government Oversight

The CFIA is the CCA for Canada's meat, poultry, and egg products inspection system, and CFIA has ultimate control over the production of food products derived from animals, poultry, and eggs. Canada is divided into four areas of administration and field operations: Atlantic, Ontario, Quebec, and the West. The West Area has six Regional Offices. The remaining Areas each have four Regional Offices.

6.1.1 Ultimate Control and Supervision

CFIA has ultimate control and supervision over official activities of all employees, laboratories, and certified establishments.

6.1.2 Assignment of Competent, Qualified Inspectors

CFIA has inspectors assigned to establishments certified for export to the United States. It appeared that not all inspectors had a complete understanding of the requirements of the Multi Commodity Activity Program (MCAP) tasks, and were not well trained in the performance of their inspection tasks. A new inspection task and reporting system called the Compliance Verification System (CVS) is scheduled to begin in the latter part of 2007 or early 2008.

6.1.3 Authority and Responsibility to Enforce the Laws

The authority and responsibility of enforcing applicable laws and regulations are vested in the CFIA.

6.1.4 Adequate Administrative and Technical Support

CFIA has adequate administrative and technical support to carry out its responsibilities, except as noted below.

- Of the five Canadian microbiological laboratory methods listed in Meat Hygiene Directive 2006-26 as usable for analyses on RTE product, only one of these methods had been deemed equivalent by FSIS. One additional method has been deemed equivalent and was included as a notation.
- No method listed for the analysis of *Salmonella* in raw or RTE products had been deemed equivalent.

6.2 Headquarters Audit

The auditors conducted a review of inspection system documents at Headquarters, two Area Offices, and two Regional Offices. The records review included the following:

- Internal review reports.

- Supervisory visits to establishments that are certified to export to the United States.
- Training records for inspection personnel.
- New laws and implementation documents such as regulations, notices, directives and guidelines.
- Control of products from livestock with conditions such as tuberculosis, cysticercosis, etc., and of inedible and condemned materials.
- Export product inspection and control including export certificates.
- Enforcement records, including examples of criminal prosecution.

No concerns arose as a result the examination of these documents at headquarters and at the other locations.

6.2.1 Audit of Area and Regional Inspection Sites

The following Area Offices were audited for government oversight functions:

- West and Atlantic

The following Regional Offices were audited for government oversight functions:

- Saskatchewan and Quebec

No concerns arose from interviews with inspection officials or from the records reviews at the Area and Regional Offices.

7. ESTABLISHMENT AUDITS

The FSIS auditors visited a total of 24 establishments – four egg products establishments, one cold storage, five meat slaughter and processing establishments, three meat processing establishments, one poultry slaughter establishment, one poultry slaughter and processing establishment, one poultry processing establishment, six meat and poultry processing establishments, and two poultry slaughter with meat and poultry processing establishments.

One establishment was delisted by CFIA. Six establishments received Notices of Intent to Delist (NOIDs) from CFIA for HACCP, and/or SSOP, and/or SPS deficiencies.

Specific deficiencies are noted on the attached individual establishment reports.

8. MICROBIOLOGICAL LABORATORY AUDITS

During laboratory audits, emphasis was placed on the application of procedures and standards that are equivalent to United States' requirements.

Microbiology laboratory audits focus on analyst qualifications, sample receipt, timely analysis, analytical methodologies, analytical controls, recording and reporting of results, and check sample programs. If private laboratories are used to test United States samples, the auditors evaluate compliance with the criteria established for the use of private laboratories under the FSIS PR/HACCP requirements.

Four private microbiology laboratories were reviewed.

- Bodycote (Norwest) Laboratory in Calgary, AB
- Gelda Scientific – Gelda Foods in Mississauga, ON
- Jacques Whitford in St. John's, NL
- Vanderpol's Eggs Ltd. in Abbottsford, BC

The following deficiency was found:

- When private laboratories do the analysis for *Salmonella* in RTE product, some use method MFHPB-20 as is listed in the above Directive. Since the laboratories operate on a client basis, they perform the requested analyses. The amount of sample to be tested in the method is 25 grams as was seen in a number of received laboratory results reports in various establishments. This is the weight for domestic product and for all other countries' export requirements. The method can also be used at 325 grams, but that is only done if the laboratory has received a request for 325 grams or if they have been informed that the product is for U.S. export. Many of the establishments did not understand that they must make that specific request for the analyses to satisfy U.S. requirements.

9. SANITATION CONTROLS

As stated earlier, the FSIS auditors focused on five areas of risk to assess Canada's meat and poultry inspection system. The first of these risk areas that the FSIS auditors reviewed was Sanitation Controls.

Based on the on-site audits of establishments, and except as noted below, Canada's inspection system had controls in place for SSOP programs, all aspects of facility and equipment sanitation, the prevention of actual or potential instances of product cross-contamination, good personal hygiene practices, and good product handling and storage practices.

In addition, Canada's inspection system had controls in place for water potability records, back-siphonage prevention, separation of operations, temperature control, workspace, ventilation, ante-mortem facilities, welfare facilities, and outside premises.

9.1 SSOP

Each establishment was evaluated to determine if the basic FSIS regulatory requirements for SSOP were met, according to the criteria employed in the United States' domestic inspection program.

- Seventeen of the 20 slaughter and/or processing establishments (including cold storage) audited had deficiencies in the implementation, maintenance, corrective actions, and/or recordkeeping requirements of the SSOP. These deficiencies resulted in both potential and direct product contamination.
- None of the four egg products establishments had deficiencies in the SSOP.

Examples of findings included but were not limited to:

- Descriptions of non-compliances, causes, corrective actions, and preventive measures were either missing or not written in sufficient detail for the establishments' management or for CFIA personnel to verify the effectiveness of the actions.
- Records were not completed in the manner described in the HACCP plans including such items as times and temperatures.
- The sanitation pre-requisite programs did not address the cleaning and monitoring of some areas of the establishments.
- Condensate was present in various rooms of the establishments and was observed dripping on personnel, boxes, product and/or product contact surfaces in various rooms of the establishments.
- The positioning of product presented a variety of cross-contamination scenarios, such as contact with boots, floors, platforms, street clothes, and/or splashes of water from the floor. Product handling practices also led to cross-contamination by the handling of boxes, pallet dividers, product-contact surfaces, and product without ever washing hands or changing gloves.
- Personal equipment such as knives, steels and scabbards were placed in product and on other inappropriate surfaces while employees were working.
- Heavy dust and protein residues were found on the fans in a cooler room that led directly into a RTE slicing room.
- Pre-operational sanitation inspection verifications revealed many food contact and non-food contact surfaces with meat, fat particles, and residue of previous days' production adhered to the surfaces.
- Pre-operational sanitation monitoring by the establishment was performed only on slaughter day and not on processing only days.
- Sanitation records revealed repetitive deficiencies with either no preventive measures or preventive measures that were ineffective.
- There was a build-up of fat and debris in a sanitizer that did not have enough water in it to sanitize the knives.
- Hooks for edible product were not maintained in a sanitary manner.

Attached individual establishment audit checklists contain the details.

9.2 Sanitation Performance Standards

- Nineteen of the 20 slaughter and/or processing establishments (including the cold storage) audited had deficiencies in SPS.

- Two of the four egg products establishments had deficiencies in SPS.

Examples of findings included but were not limited to:

- Inedible containers were observed contacting personnel working with edible product, edible product, edible product containers, and/or food contact surfaces.
- Pest control devices were absent, pest control plans did not account for physical changes in the establishment, and/or establishment personnel were not following or were not documenting follow-up on recommendations of the pest control companies' representatives.
- There were no brackets or other sanitary methods of storage for hoses, brooms, mops, squeegees, and/or condensation wiping tools.
- Condensate was present in processing rooms, coolers, and freezers.
- The positioning and handling of product presented a variety of potential cross-contamination scenarios, such as contact with boots, floors, platforms, street clothes, and/or splashes from the floor.
- There was rust and corrosion on many pieces of equipment and overhead structures.
- There were cracks and rough welds on Vemags and other stainless steel containers which could lead to the formation of biofilms.
- Establishment pre-requisite programs for water and/or ice were not written or followed in the manner specified in the CFIA Manual of Procedures.
- There was no floor drain in the area of the sticker in a hog plant, and resulted in the operator standing on a number of support pads in a pool of water and blood.
- Personal equipment such as knives, scabbards, steels, mesh gloves, cotton gloves, and sleeves were left on food contact surfaces and other inappropriate places when employees went for rest breaks.
- Cross-contamination was observed between clean and soiled aprons and frocks.
- Walls, floors, ceilings, and/or overhead structures were in poor repair. Insulation was exposed in processing room and cooler locations.
- Packaging materials were stored in an insanitary manner.
- Plastic curtains and/or gaskets around doors were in poor repair.
- Freezers and storage areas not maintained in a sanitary manner.
- Outside premises not maintained to prevent pest harborage.
- Excessive shell fragments were observed in breaking machines and collection pots. Excessive shell fragments were also observed past the filtering system in the performance of a pour test.

Attached individual establishment audit checklists contain the details.

10. ANIMAL DISEASE CONTROLS

The second of the five risk areas that the FSIS auditors reviewed was Animal Disease Controls. These controls include ensuring adequate animal identification, control over condemned and restricted product, implementation of the requirements for Bovine

Spongiform Encephalopathy and specified risk materials, and procedures for sanitary handling of returned and reconditioned product.

No deficiencies were noted.

11. SLAUGHTER/PROCESSING CONTROLS

The third of the five risk areas that the FSIS auditors reviewed was Slaughter/Processing Controls. The controls include the following areas: ante-mortem inspection procedures; ante-mortem disposition; humane handling and humane slaughter; post-mortem inspection procedures; post-mortem disposition; ingredients identification; control of restricted ingredients; formulations; processing schedules; equipment and records; and processing controls of cured, dried, and cooked products. No deficiencies were found in the controls listed above.

The controls also include the implementation of HACCP systems in all establishments and the implementation of a generic *E. coli* testing program in slaughter establishments.

11.1 Humane Handling and Slaughter

No deficiencies were noted.

11.2 HACCP Implementation

All establishments approved to export meat and poultry products to the United States are required to have developed and adequately implemented a HACCP program. Each of these programs was evaluated according to the criteria employed in the United States' domestic inspection program.

The HACCP programs were reviewed during the on-site audits of the 24 establishments.

- One of the 20 slaughter/processing/cold storage establishments audited had a deficiency in the basic HACCP requirements.
- None of the four egg products establishments audited had any deficiencies in the basic HACCP requirements.
- Thirteen of the 20 slaughter/processing/cold storage establishments audited had deficiencies in the implementation of HACCP requirements. The majority of these deficiencies were in recordkeeping.
- One of the four egg products establishments audited had deficiencies in the implementation of HACCP requirements. This was in calibration of equipment.

Examples of findings included but were not limited to:

- Descriptions of deviations, corrective actions, and preventive measures were either missing or not written in sufficient detail for the establishments' management or for CFIA personnel to verify the effectiveness of the actions.

- CCP monitoring and verification records had missing times, missing initials, missing temperatures, and entries that were not actual measured values. Records were not completed as described in the plans.
- HACCP plans had poorly described hazards which led to critical limits, monitoring procedures, corrective actions, preventive measures and verification procedures that did not follow in a logical manner or address the hazard.
- Supporting documentation was missing for many of the decisions made throughout the HACCP system.
- Pre-shipment reviews were not conducted for all products, in some cases just the normal verification of paperwork.
- Hazard analysis was not conducted for all steps in the flow diagram.
- Records were not maintained for a receiving CCP.
- Calibration of monitoring instruments was not completed at the frequency designated, was not recorded as in the plan, and/or the plan did not designate an acceptable range.

Attached individual establishment audit checklists contain the details.

11.3 Testing for Generic *E. coli*

Canada has adopted the FSIS regulatory requirements for generic *E. coli* testing.

Nine establishments audited were required to meet the basic FSIS regulatory requirements for generic *E. coli* testing and were evaluated according to the criteria employed in the United States' domestic inspection program. Three of the nine slaughter establishments had deficiencies in the generic *E. coli* testing program.

Examples of findings included but were not limited to:

- When total coliform and *E. coli* counts had exceeded the acceptable limits, no action was taken.
- The recording program for *E. coli* results was not functioning correctly.

Attached individual establishment audit checklists contain the details.

11.4 Testing of Ready-to-Eat Products

Canada has adopted the FSIS regulatory requirements for testing of ready-to-eat products, with the exception of the following equivalent measures:

- Establishments select samples.
- Private laboratories analyze samples.

Several of the establishments audited were producing ready-to-eat products for export to the United States. The following deficiency was noted:

- Many of the establishments did not realize their obligation to notify the private laboratories that the RTE products sent for analysis were for U.S. export and required that the *Salmonella* analysis be done on 325 grams of product rather than on 25 grams of product, the Canadian domestic standard.

12. RESIDUE CONTROLS

The fourth of the five risk areas that the FSIS auditors reviewed was Residue Controls. These controls include sample handling and frequency, timely analysis, data reporting, tissue matrices for analysis, equipment operation and printouts, minimum detection levels, recovery frequency, percent recoveries, and corrective actions.

One CFIA government residue laboratory was reviewed during this audit.

- CFIA Saskatoon Meat Residue Laboratory in Saskatoon, SK

No deficiencies were noted.

Residue controls at the establishments were reviewed during the on-site audits. The following deficiency was noted:

- One of the nine slaughter establishments did not receive their residue sampling schedule for FY 2006-2007 and performed no residue sampling in that time period.

13. ENFORCEMENT CONTROLS

The fifth of the five risk areas that the FSIS auditors reviewed was Enforcement Controls. These controls include the enforcement of inspection requirements and the testing program for *Salmonella.*

13.1 Daily Inspection in Establishments

Inspection was being conducted daily in all establishments audited.

13.2 Testing for *Salmonella* in Raw Product

Ten slaughter establishments were required to meet the basic FSIS regulatory requirements for *Salmonella* testing and were evaluated according to the criteria employed in the United States' domestic inspection program.

Canada has adopted the FSIS requirements for testing for *Salmonella*, with the exception of the following equivalent measures:

- Establishments select samples.
- Private laboratories analyze samples.

Testing for *Salmonella* was properly conducted in the 10 slaughter establishments.

However, the following deficiency would apply to the analysis of these samples.

- There was no Canadian method for *Salmonella* analysis of meat and poultry products that had been deemed equivalent by the U.S.

13.3 Species Verification

The following deficiency was noted:

- Two establishments that produced both single and multiple species ground products did not have species identification sampling scheduled for them by CFIA.

13.4 Periodic Supervisory Reviews

Periodic supervisory reviews of certified establishments were being performed and documented as required with the following exception:

- In one establishment, supervisory reviews had not detected that all days were not accounted for on the daily attendance roster.

13.5 Inspection System Controls

Except as noted in this report and below, the CCA had controls in place for ante-mortem and post-mortem inspection procedures and dispositions; restricted product and inspection samples; disposition of dead, dying, diseased or disabled animals; shipment security, including shipment between establishments; and prevention of commingling of product intended for export to the United States with product intended for the domestic market.

- Inspection system controls at all levels were not fully developed and implemented. There were many instances of deficiencies both in the documentation reviews and in the operations audits that should have been addressed prior to the FSIS audit. Some inspection personnel were not well-trained in the performance of their inspection tasks.
- Inspection personnel were not conducting hands-on pre-operational sanitation inspection verification or were not conducting it at the frequency required.

In addition, controls were in place for the importation of only eligible livestock from other countries, i.e., only livestock from eligible third countries and certified establishments within those countries, and the importation of only eligible meat products from other counties for further processing.

Lastly, adequate controls were found to be in place for security items, shipment security, and products entering the establishments from outside sources.

14. CLOSING MEETING

A closing meeting was held on June 6, 2007, with the CCA. At this meeting, the primary findings and conclusions from the audit were presented by the auditor.

The CCA understood and accepted the findings.

Rori K. Craver, DVM
Lead Auditor

15. ATTACHMENTS

Individual Foreign Establishment Audit Forms
Foreign Country Response to Draft Final Audit Report

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Maple Leaf Meats Incorporated 1 Warman Road Winnipeg, MB, Canada R2J 4E5	05/29/07	7A	Canada
	5. NAME OF AUDITOR(S) Alam Khan, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOPs have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	
29. Records	
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	X
39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	X
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

Date: 05/29/07 Est #: 7A (Maple Leaf Meats Incorporated []) (Brandon, Canada)

10 Many ready to use knives had fat and meat residues from the previous days work. The entire knife rack was rejected by the CFIA official leading the audit. [MOP 3.7]

15/51 Hazard analysis was not conducted for the rework step identified in the flow diagram. The establishment would conduct hazard analysis on this step. [MIR Section 34(1.1)]

38/51 a) The trap entry hole of the catch-all mouse trap was blocked by masses of fat and meat. The CFIA supervisor cleared the obstruction of the trap. [MOP 3.10]
b) The pest control program requires that the comments and corrective action of the pest management contractor should be followed. Multiple reports by the pest management firm indicated a problem with L-14 trap and yet no action was taken by the establishment to correct the problem identified by the contractor. The management indicated that that they would follow the program carefully in the future. [FSEP E 2.1.1]

39/51 The covering of a rain guard roller of the loading dock was hanging loose, and foam of the pad was exposed. The establishment personnel gave assurance to fix the problem in very near future. [MOP 2.5.9]

45/51 A trailer in use for transportation of combo bins had rusty hardware on the door and in the interior of the truck. The establishment personnel gave assurance to correct the problem as soon as possible. [MIR 49 (b)]

46 Multiple S shaped steel hooks attached to the pulleys used to hang porcine carcasses were stored on steps of a stairs leading to the carcass unloading area. The CFIA official leading the audit rejected the hooks and pulleys.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Bumbrae Farms Limited R.R. # 1 Lyn, ON K0E 1M0	09 May 2007	E26	Canada
	5. NAME OF AUDITOR(S) Marshall Thibodeaux		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	O
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

Date: 09 May 2007 Est #: E26 (Burnbrae Farms Limited [P/CS]) (Lyn, ON, Canada)

There were no significant findings. The findings from the previous audit had been addressed; there were no ineligible eggs entering the breaking room during this audit. The establishment had installed new equipment.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Marshall Thibodeaux	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Lashbrook Produce Limited 115 Bonnie Crescent Elmira, ON N3B 3G2	04 May 2007	E34	Canada
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	Thibodeaux, Craver, Khan		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
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12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
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18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	
29. Records	
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment — Date: 04 May 2007 Est #: E34 (Lashbrook Produce Limited [P/CS]) (Elmira, ON, Canada)

46. A. Operators on both of the breaking machines were not removing shall fragments from the breaking cups; approximately 10% of the cups on the small machine had shell fragments. No attempt to correct the issue was made until the auditors identified the issue to CFIA inspection personnel.

B. The collection pots on both of the machines had excessive collections (four to eight cups) of shell fragments in the screens with product still running over them.

C. CFIA inspection personnel performed a demonstration (with no settling time) pour test. This test showed about one-eighth cup of shell fragments in a 30-pound container of liquid egg. This was significantly more than would be expected as this product had already passed the filtration system.

CFIA Processed Egg Regulations, Operation and Maintenance of Registered Processed Egg Stations 8.(1), 8.(25).

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
for Thibodeaux, Craver, Khan	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Cargill Limited - Cargill Limitee; dba Cargill Egg Products 21-25 Newbridge Road Etobicoke, ON M8Z 2L6	03 May 2007	E35	Canada
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	Thibodeaux, Craver, Khan		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

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Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	X
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
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24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	
29. Records	
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment Date: 03 May 2007 Est #: E35 (Cargill Limited - Cargill Limitee; dba Cargill Egg Products [P]) (Etobicoke, ON,

19. Required quarterly calibration of equipment-integrated monitoring devices and pasteurizing equipment was not performed in the fourth quarter (January – March 2007).

CFIA Processed Egg Regulations, Operation and Maintenance of Registered Processed Egg Stations 8.(25).

46. A. Bags of mix were opened over the mix vat by using a knife to cut through from the outer layer in to the mix itself. The entire bag was then held over the mix vat to empty it. Because these bags were held on an elevated pallet jack for the convenience of the operator, the door to the mix room was held continuously open into a non-food processing hallway.

CFIA Processed Egg Regulations, Operation and Maintenance of Registered Egg Stations 8.(4).

B. In the packaging room for bags of liquid pasteurized egg products, filled and sealed bags were stacked on the top of the lid of an edible barrel. There was splattered egg product on the lid and the bags. As the operator salvaged the product from these bags into the barrel, product was spilled on to the bags and lid of the barrel as well as down the sides of the barrel. She was attempting to salvage product while keeping the lid on in a mostly closed position. After this, she picked up bags off the floor and continued to work without washing her gloves.

CFIA Processed Egg Regulations, Operation and Maintenance of Registered Egg Stations, 8.(4).

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
for Thibodeaux, Craver, Khan	6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Global Egg Corporation 17 Newbridge Road Etobicoke, ON M8Z 2L6	07 May 2007	E36	Canada
	5. NAME OF AUDITOR(S) Marshall Thibodeaux		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
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19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	O
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

Date: 07 May 2007 Est #: E36 (Global Egg Corporation []) (Etobicoke, ON, Canada)

There were no significant findings. The findings from the previous audit had been addressed; there were no ineligible eggs entering the breaking room during this audit. The establishment had installed new equipment.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Marshall Thibodeaux	for [signature] 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Expresco Foods 8205 Transcanadian Hwy. St. Laurent, QC H4S 1S4	5/15/07	36	Canada
	5. NAME OF AUDITOR(S) Rori K. Craver, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
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Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
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20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	O
Part E - Other Requirements	
36. Export	
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46. Sanitary Operations	
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

Date: 5/15/07 Est #: 36 (Expresco Foods [P/CS]) (St. Laurent, QC, Canada)

22. Not all CCP records had the time of the event recorded. The deviation record that was required to be created for the CCP deviation of the metal detector not functioning did not contain a written preventive measure. FSEP Manual Chapter 2 Section 4.8.5

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
for Rori K. Craver, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Elevages Perigord (1993) Incorporated 228 rue Principale St-Louis-de-Gonzague J0S 1T0	14 May 2007	37	Canada
	5. NAME OF AUDITOR(S) Rori K. Craver, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
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Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	X
39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58. NOID	X
59.	

60. Observation of the Establishment Date: 14 May 2007 Est #: 37 (Elevages Perigord (1993) Incorporated [S/P/CS]) (St-Louis-de-Gonzague, Canada)

10/11/51. The slaughter and cutting operations were moved to a new building three weeks ago. The written SSOP had not been revised since December 2005 and so did not address the new building and rooms. It also did not address the changes in procedures and frequencies for pre-operational and operational sanitation for the rooms previously used for those operations. Sanitation monitoring was being performed, but the cutting room had been left from the last work day of the previous week until the day of the audit with only a rinse; sanitation monitoring was conducted on the day of the audit. CFIA conducted pre-operational sanitation verification on the day of the audit before releasing the room for use. Meat Inspection Regulations (MIR) 34 (2) (2.1); Meat Hygiene Manual of Procedures (MOP) Section 3.3 & 3.3.1

10/46/51. The written SSOP for the "cone" table used in the removal of meat from duck carcasses did not include a way to clean the cones between carcasses, leading to cross-contamination between carcasses. The level of the cones as they returned to be reloaded was very close to the floor and below the level of the platform where the employees stand, leading to potential cross-contamination from boots and splashes. CFIA ordered temporary measures until the system could be reconfigured.

38/51. There were no pest control devices present for the new building. A plan was faxed on the day of the audit to the establishment management. They had told the CFIA personnel earlier in the day that the pest control person would be out that day but he never showed up. CFIA had previously addressed the situation, but plant management had not yet satisfactorily responded. MIR 34 (10); MOP 4.1.8

39/46/51. There were no brackets for hanging hoses, no hangers for floor squeegees or condensation squeegees, and no slants on tops of lockers. Some of these were on order and some had been received but not installed. CFIA had addressed some of these issues with establishment management personnel. MIR 34 (1) (1.1); MOP 2.7.1(2) & 2.6.7.3

58. CFIA issued a Notice of Intent to Delist based on the above findings.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
for Rori K. Craver, DVM	DVM 6/4/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Northern Goose Processors Limited Lots 1 to 7 and 13 to 17100 First Street, Southwest Teulon R0C 3B0	05/30/07	63	Canada
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	Alam Khan, DVM		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

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Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	X
28. Sample Collection/Analysis	
29. Records	X
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
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35. Residue	
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37. Import	
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39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	X
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	O
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59. Delistment	X

60. Observation of the Establishment — Date: 05/30/07 Est #: 63 (Northern Goose Processors Limited [S/P]) (Teulon, Canada)

10 a) Condensate mixed with debris and unidentified blackish material from the edges and other parts of ice machine was dripping directly into freshly made ice to chill poultry carcasses and parts. The CFIA official rejected the ice machine and the ice bin [MOP3.6.1]
b) A ready-to-use ice buggy had fat or meat particles from previous day's production. The buggy was tagged by the CFIA officials. [MOP 3.7]
c) A plastic lug containing chilled turkey necks in iced water had a feather floating in it. The feather was removed from the product. [MOP 19.4.1.2]
d) The water level in a sanitizer to sanitize knife after each sticking was far below the overflow stem and had debris and fat build up inside the sanitizer. The appropriate corrective action was requested by the CFIA officials. [MOP 3.8]
e) Water was observed falling from an overhead pipe onto a roll of plastic sheet used in combo bins for storage and transportation of edible product. Drops of water were also observed falling on a nearby stainless steel work table which was not in use at the time of audit. The plastic roll was discarded by the management and the work table was rejected by the CFIA veterinary in-charge. [MOP 3.6.1]

13/51 a) The review of the SSOP monitoring record indicated that the pre-operational sanitation procedures were performed only when the establishment slaughtered. The sanitation procedures were not being performed on the days when establishment processed (cut-up). The CFIA official will assist establishment revising it SSOP. [MOP 3.7]
b) At many occasions SSOP corrective action did not define the actual deviations and always missing preventive measures. The CFIA official's official will assist establishment revising it SSOP. [FSEP manual appendix VI]
c) The temperature of the sanitizers was being monitored but not recorded. CFIA officials will assist establishment revising it SSOP. [MOP 3.8]

22/51 a) Occasionally, the time temperature monitoring record for poultry giblets did not record the starting time of the temperature. On numerous occasions the time to reach the critical limit of 4°C was not indicated. At another occasion the product was removed from the chilling medium and transfer to combo bins before the critical limit of 4°C was met. [FSEP Section 4.8.2]
b) At CCP 2B the monitoring record described deviations as only "defects" without specifying the type of defects. The establishment gave assurance that future monitoring record will define deviation completely. [FSEP Manual 4.8.3 A]

27/51 The *E. coli* plan did not address how randomization of carcass selection for *E. coli* sampling was achieved. [MOP 11.7.3-USA, Annex T]

29/51 The evaluation of *E. coli* test results indicated that establishment had not met the criteria established for process control verification at more than three separate occasions. The establishment gave assurance that *E. coli* plan will be reassessed. [MOP 11.7.3-USA, Annex T]

39/51 a) Numerous openings in walls and ceilings around the cables or plumbing were not sealed. The CFIA has requested the corrective action from the establishment. [MOP 2.5.6 & 2.5.7]
b) Varying degree of rust and peeling paint were observed on some overhead structures in the evisceration room. The CFIA has requested the corrective action from the establishment. [MOP 3.6.1]
c) A pair of lamps was not lit at one of the trimmer station. Several pairs of lamps were not lit in the inedible storage area. The establishment gave assurance that all burnt lamps will be immediately replaced. [MOP 2.5.4]

41/51 a) The ceiling of the ice machine was covered with beaded condensate. No ready-to-use ice on edible product was stored underneath the ceilings. [MOP 3.6.1]
b) A leaky overhead plumbing attached to a condenser unit was observed in the fresh product packaging room. No product was seen stored underneath the leaky pipe. [MOP 3.6.1]
c)The plumbing including a valve exiting a condenser unit in a freezer located in the packaging was rusty and was wet indicating an obscure leak in the plumbing line. No product was stored underneath the leakage at the time of observation. [MOP 3.6.1]
d) The rubberized lining of the freezer door of a freezer located in fresh product packaging room was broken at few places and missing from the other. The establishment gave assurance that deficiencies identified in item 41 a-d will be corrected as soon as possible. [MOP 2.5.9}

46/51 a)The trough under the feather picker and scalder was blocked by a heap of feathers causing water from the scalder and picker to flow freely on the kill floor. [MOP 2.5.3]
b) In the dry goods supply room boxes of packaging material were stored on the floor. [MOP 3.6.5]
The establishment gave assurance that deficiencies identified in item 41 a-d will be corrected as soon as possible.

59 The CFIA officials and the FSIS auditor reached a consensus to remove this establishment from the list of the certified establishments eligible to export to the U.S. based on the deficiencies identified above.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Maple Leaf Foods 144 Edinburgh Drive Moncton, NB E1E 2K7	18 May 2007	95	Canada
	5. NAME OF AUDITOR(S) Rori K. Craver, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	X
13. Daily records document item 10, 11 and 12 above.	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible *establishment individual.*	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	X
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. *Equipment and Utensils*	
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

Date: 18 May 2007 Est #: 95 (Maple Leaf Foods [P/CS]) (Moncton, NB, Canada)

10. In one cooler there was condensation dripping on to products. These were fully encased products awaiting slicing. All products in this cooler were tagged and held by the establishment for further analysis. Meat Inspection Regulations (MIR) – Section 37

13/22/51. Sanitation and HACCP records were not documented in sufficient detail to visualize the problems encountered and determine effectiveness of corrective actions. Amendments to FSEP Manual

12/13/51. There were no preventive measures listed in the sanitation documents as the establishment had a written requirement for an event to occur three days in a row before they would consider preventive measures. CFIA national personnel explained that preventive measures are required for any event. FSEP Manual – Appendix VI – Guidelines for a complete Written Program

41. The small plastic dividers over and including the rails going from room to room had beaded condensation and grease. The roll-up door to the bacon slicing room was covered with condensation. It was tagged to prevent usage until it was cleaned. MIR Section 37

46. In the slicing department, when longer products to be sliced were cut off of the trees, the motion caused the products to potentially touch the floor, stands, boots, or street clothes below the level of the aprons. Longer aprons were immediately furnished. This same problem of potential contacts with clothing, etc., was noted in several other departments. Immediate corrective actions were taken by the establishment. MIR Section 34 (21.) (b)

46/51. In the slicing room, holding coolers and freezers, the products hung too low on the racks allowing them potential contact with boots, street clothes, the floor and splashes. Products possibly affected were tagged by the establishment for hold and microbiological testing. MIR Section 34 (21.) (b)

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
for Rori K. Craver, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Aurpal Incorporated 1661 Rue Marcoux Marieville J3M 1E8	16 May 2007	100	Canada
	5. NAME OF AUDITOR(S) Rori K. Craver, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	X
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	X
47. Employee Hygiene	X
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

Date: 16 May 2007 Est #: 100 (Aurpal Incorporated [P/CS]) (Marieville, Canada)

22/51. There was no supporting documentation for the frequencies for any of the calibrations of measuring equipment. There were no initials on HACCP records at the time of the recording of a monitoring event. FSEP Manual Chapter 2 – Section 5

41/51. There was condensation over the doorway to the equipment wash room. There was heavy frost on some of the parts of the refrigeration units in the freezer. There were frozen ice droplets and frost on top of several boxes in the freezer. CFIA ordered immediate corrective actions in both areas. Meat Inspection Regulations (MIR) – Section 37

46. In several storage and freezer rooms of the establishment, boxes of product were allowed to contact the walls. The brush used to clean out a cooking vat in the cooking room was placed on the floor between uses. Meat Hygiene Manual of Procedures Chapter 2 – 2.6.3 & MIR Section 34 (1.1)

47. An employee was observed using his teeth to break the tape being used to seal a box of product. MIR Section 56 (2)

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
for Rori K. Craver, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Versa Cold Valley Center 31785 Marshall Road RR #5 Abbotsford, BC Canada, V2T 5Z8	05/09/07	S110	Canada
	5. NAME OF AUDITOR(S) Alam Khan, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenthg implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	X
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	O
24. Labeling - Net Weights	O
25. General Labeling	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	O
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	O
34. Species Testing	O
35. Residue	O
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

Date: 05/09/07 Est #: S110 (VersaCold[]) (Abbotsford, BC Canada)

19/51 The corrective actions on monitoring/verification records for HACCP procedures for November 06, and January 07 did not include cause of the deviation and/or preventive measures to be taken. One of the check boxes on the same record had a question mark for to the acceptability or unacceptability of the procedure. [FSEP Ch. 2 Sec 4.8.5]

CFIA supervisor gave assurance that the establishment would comply with the applicable regulations

46/51 The plastic curtain on an exit door in a freezer had broken, frayed, discolored and missing strips. [FSEP Pre-requisite E 1.1.2]
The establishment management gave assurance that the plastic curtain would be replaced as soon as possible.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam R. Khan, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Springhill Farms SouthEast 35-14-15 West Neepawa R0J 1H0	05/31/07	126	Canada
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	Alam Khan, DVM		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	
29. Records	
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	X
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment Date: 05/31/07 Est #: 126 (Springhill Farms [S/P]) (Neepawa, Canada)

10 Porcine tongues were contacting employee's boots and foot stands, as carcass rail was entering into evisceration area. No tongues from today's production will be saved. Establishment has presented a plan to adjust the stand so the carcasses heads and the foot will have a sizeable spatial separation.

41 A dripping condensate from an overhead plumbing was falling on the floor of the trim packaging room. No product contamination was observed. CFIA official requested immediate corrective action. The establishment will fix the problem within 24 hours.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Sunterra Meats Ltd. 4312 - 51st Street Innisfail T4G 1A3	5/18/07	136	Canada
	5. NAME OF AUDITOR(S) Alam Khan, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	
29. Records	
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

Date: 5/18/07 Est #: 136 (Sunterra Meats Ltd. [S/P]) (Innisfail, Canada)

13 Many of the establishment's SSOP records were missing the description of deficiencies and corrective actions. The establishment corrected the problem right away. [MIR 34.2.1]

22/51 The establishment did not maintain records of monitoring, corrective actions and verification associated with CCP 2B for receiving fresh meats and packaging materials. This problem was corrected immediately by the establishment. [MIR 30.1.1]

39/51 1) Overhead structures including the carcass rails had localized areas of rust or corrosion present through out the establishment [MOP 2.5.7 and 4.1.2]
2) The door leading into the shipping/receiving cooler was in bad repair and had corroded hinges. [M.O.P 2.5.9]
3) A steel sink tank in the laundry room used to store pulleys and other product equipment was rusty. [MIR 28.1.Q]
4) Old plumbing and steel pipes on the wall above the sink were corroded. [M.O.P 2.5.6]
5) The walls in the laundry room and the processing room had holes greater than two inches in diameter. The CFIA issued a corrective action request to the establishment. [MOP 2.5.6]

46/51 Folding cartons for edible product were not stored in a sanitary manner. The top layer of cartons on each pallet had visible debris. Rolls of plastic sheets used in packaging edible product were placed against the wall. The establishment has corrected the findings immediately. [MIR 92.1]

61. NAME OF AUDITOR

Alam Khan, DVM

62. AUDITOR SIGNATURE AND DATE

DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Wingtat Game Bird Packers Inc. 9752-186th St. Surrey, BC, V4N 3N7 Kamloops Div. Yale District V0E 1W0	05/11/2007	176A	Canada
	5. NAME OF AUDITOR(S) Alam Khan, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	X
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	
29. Records	
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	X
39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	
53. Animal Identification	O
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58. NOID	X
59.	

60. Observation of the Establishment

Date: 05/11/2007 Est #: 176A (Wingtat Game Bird Packers) [S]) (Surrey, BC, Canada)

10 a) Ready-to-use racks to hang birds for chilling were observed with blood stains, meat and/or fat particles, and one such rack was used to hang carcasses at the time of the audit. [MIR 34.2.1]
b) The plastic curtain covering the opening in the wall for the entry of the conveyor line from the kill floor to the evisceration floor had not been cleaned in recent days. The curtain strips had accumulations of fat and grease. [MIR 34.2.1]
c) The pneumatic cylinder of the lung vacuum machine in the evisceration room was covered with a thick layer of black grease which was posing potential for contamination of the passing chicken carcasses. [MIR 34.2.1]
d) A ready-to-use metal colander for the giblet harvest was placed on the utility cart which was collecting contaminated water dripping from the evisceration line. [MOP 2.4.4]
e) The transfer table on the kill floor had a pile of chicken carcasses contacting each other. The control in the HACCP plan for prevention of cross contamination at this step states, "manual transfer and re-hang". [MIR 30.1.1]
f) The cleaning of the plastic curtains hanging from the overhead support enclosing multiple work areas in the evisceration room and under the conveyor line was not included in any sanitation or pre-requisite programs. The establishment gave assurance that they would clean and sanitize the curtains every morning. [MIR 34.2.1]

All the deficiencies identified in items a-f have already been corrected by the establishment before the audit was over.

19/51 The frequency for the verification of the CCP monitoring was selected to be every three months, however, no supporting data for the chosen frequency was presented. The establishment gave assurance to correct the problem as soon as possible. [MIR 30.1.1]

22/51 On multiple occasions, the responsible person for reviewing pre-shipment reviews did not check the "meet or not meet" box for the CCPs on the kill and evisceration floors. [FSEP Vol. 3, 5.11]

38/51 Broken totes, old rusty equipment, miscellaneous mechanical parts, pallets of unidentified building parts, bags of salt, a tractor tire and other un-identifiable objects were stored in disarray on the grounds adjacent to the establishment. The CFIA has requested compliance; the establishment gave assurance that the premises would be straightened out as soon as possible. [MIR 30.1.1]

46/39/51 a) Two inedible containers in the evisceration room were observed overflowing with the refuse and stacked on top of each other. [MIR 34.5]
b) A stainless steel cabinet attached to the evisceration had collected debris on it and was littered with discarded objects. [MIR 34.2.1]
c) A cover of totes for the edible product was stored on the floor in the dry goods room. The establishment corrected the deficiencies identified in items a-c immediately. [MOP 2.4.4]

58 Following a discussion of the findings, the CFIA officials present at the audit decided to issue the establishment a Notice of intent to delist (NOID) due to SSOP and SPS findings.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Eastern Protein Foods Limited 30 Chipman Drive Kentville, NS B4N 3X1	31 May 2007	203	Canada
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	RoriK. Craver, DVM		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	X
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	X
29. Records	
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	X
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	X
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	X
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	X
51. Enforcement	X
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment Date: 31 May 2007 Est #: 203 (Eastern Protein Foods Limited [P/CS]) (Kentville, NS, Canada)

10/51. A. There were several instances of product residue on walls and a door.

B. There was potential cross-contamination with the handling routine of the worker boxing Mechanically Deboned Product (MD). He was touching boxes, pallet dividers, the inside of the boxes (product contact) and product all without washing his hands or changing gloves.

C. Large metal vats of chicken skins stored in the cooler had no plug so product was hanging out of the bottom onto the floor. This product is going to pet food, but the containers are used for both edible product and that intended for pet food. The establishment said the product was not yet declared inedible.

D. The pre-requisite program for microbiological sampling of ice was not being followed as stated in the program.

13/22/51. A. The reports generated by pre-operational sanitation monitoring did not follow the written program and were very vague and incomplete. The deviation records for sanitation, other pre-requisite programs, and for HACCP were incomplete and did not accurately identify causes or clear and manageable preventive measures.

B. The daily QA audit report called for a time to be recorded with each temperature taken. The majority of the records only had the temperatures.

C. The HACCP CCP1 for MD had a requirement for recording time; however it was not possible to tell from the HACCP plan or from the records if this time was for the production of the lot(s) of MD, the time the digestion test was begun, the time the test was completed (takes about two hours), or the time the entry was written.

19/22/51. A. It is not possible to tell from the Monthly QA audits whether the monitoring verifications cover the monitors on both shifts since no time is recorded.

B. Pre-shipment review is done on quick ship products as they ship on the day of production. However, those products shipping the next day only have the verification record review that is done the following morning, not a separate pre-shipment review.

28/51. Both total coliform and *Escherichia coli* counts had exceeded the set limits in the program but no action had been taken. (These were not from this year.)

38. There was a lack of follow-up documentation for the recommendations left by the pest control company representative. The last report had noted a bat caught in a tin-cat trap and a mouse caught in a tin-cat, but those comments were only on the electronic print-out and not on the report. The establishment person reviewing the report had not looked at the electronic print-out and so had not noted the findings.

41. The outside wall of the IQF freezer had condensation. The freezer had excessive ice and frost and some boxes were stored under these areas. The floor of this freezer had a heavy ice build-up. The outside of this same freezer had a build-up of frost and ice on a previous door that had been closed off. CFIA has addressed some parts of the ventilation concerns in recent audits.

45. A. In the chicken breast trim area, there was personal equipment (knives, steels, scabbards) stored on the work surfaces and in a tub of product.

B. There were broken links in a white conveyor belt in the trim area.

C. Equipment such as an oil can, hoses, etc. were stored on the top of the tray-pack wrapper machine.

D. The side belts on the tray packer were stained and had old product residue on them.

46/51. A. There were electrical cords sitting on top of equipment that was not in use but in a room that had been pre-op and was in use. The equipment had nothing on it to identify that it would not be used on that day.

B. A squeegee for wiping condensation was stored between pipes on a wall next to the IQF partial cook line.

C. A small shelf off the edge of the bagging line coming from the IQF was allowing some product to gather there and thaw with the possibility that it could be knocked off and go into a bag of frozen product. The pieces sitting on this shelf were thawed.

D. There were hoses contacting the floor in several areas.

E. There was a brine pail stored upside down on a mixing machine.

F. There were no longer used electrical cords hanging over the whole length of the deboning line. Many of these cords were not clean.

G. There were unsmooth welds and cracks in several of the large metal combos. These could lead to the formation of biofilms.

50. From March 2, 2007 to May 3, 2007, there was no evidence of a visit from CFIA on the second shift. All production days did have at least one visit.

51. The MCAP task for pre-operational sanitation verification comes up twice a month. This inspector had only been doing record reviews and had not done on-site verification for at least three months.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
For Rori K. Craver, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Piller Sausages and Delicatessens Limited 443 Wismer Street Waterloo N2J 4A4	07 May 2007	229	Canada
	5. NAME OF AUDITOR(S) Rori K. Craver, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	O
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		**Part E - Other Requirements**	
10. Implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.	X	39. Establishment Construction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	X
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		45. Equipment and Utensils	X
18. Monitoring of HACCP plan.		46. Sanitary Operations	X
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		**Part F - Inspection Requirements**	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X	49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	O
25. General Labeling		53. Animal Identification	O
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)		54. Ante Mortem Inspection	O
Part D - Sampling Generic *E. coli* Testing		55. Post Mortem Inspection	O
27. Written Procedures	O	**Part G - Other Regulatory Oversight Requirements**	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
Salmonella Performance Standards - Basic Requirements		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O		
32. Written Assurance	O		

60. Observation of the Establishment Date: 07 May 2007 Est #: 229 (Piller Sausages and Delicatessens Limited [P]) (Waterloo, Canada)

13/22/51 The descriptions of noncompliances, corrective actions, and preventive measures were not written in sufficient detail for establishment management or inspection personnel to verify the effectiveness of the actions.

43. At the handwash sink at the management/maintenance entrance to the processing areas, there was no hot water available.

45. A. Color coding of edible, inedible, and trash containers was not consistent throughout the establishment leading to the possibility of inedible containers being used for edible product. There was no signage available in the various rooms to identify the coding of these containers.

B. Inedible and trash containers in several areas were placed in a manner that could allow for contact with personnel working with edible product and also with edible product containers and food contact surfaces. An edible container was used as a catch pan under a slicing machine in a location appropriate for an inedible container.

46. When the Technical Services Manager picked up packages of sliced product that had fallen out of the edible product catch-bin on to the floor, he wiped them off on his pant leg and then replaced them into the catch bin. Immediate corrective actions for this deficiency were ordered by CFIA officials.

51. Inspection personnel were not conducting hands-on pre-operational sanitation verification at this establishment prior to the beginning of production after the establishment had conducted their monitoring. The regional supervisor assured the auditor that this would be corrected.

The auditor was assured by CFIA officials that all deficiencies found in this audit would be scheduled for correction.

**CFIA references will follow at a later date.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
for Rori K. Craver, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
OLYMEL S.E.C/L.P 7550, 40th Ave Red Deer (Alberta) Canada T4N 6R7	05/17/07	270A	Canada
	5. NAME OF AUDITOR(S) Alam Khan, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	
29. Records	
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	O
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	X
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58. NOID	X
59.	

60. Observation of the Establishment Date: 05/17/07 Est #: 270A (Quality Meat Group Ltd. []) (Vancouver, Canada)

10 a) Condensate from the overhead structure was dripping observed falling onto the carcasses exiting the freeze blast carcass holding area. (MIR 37, MOP 3.6.4)
b) The heads attached to the swine carcasses were contacting the split saw platform as the carcass rail was entering into the evisceration area. [MOP 4.1.4(2)]
c) Two carcasses at the break-up table area were observed with black specks of unidentified material around the neck region. [MOP 4.5.2 (h)] Deficiencies identified in a-c were corrected immediately.

39/51 a) The rubberized edges of the doors of some of the freezers and coolers were torn, frayed or missing. [MOP 2.5.9]
b) The roll-up door on the old shipping dock was not fully closed, leaving a gap and creating a potential for vermin entry. [MOP 2.5.9]
c) Detached concrete was observed at a post near a freezer. The concrete was also missing in its entire length from a raised surface (step) at the junction of blast freeze carcass holding cooler and old shipping dock. The two rooms are separated by a door which would not close completely. [MOP 2.5.6- 2.5.9]
d) A drain in the passage for the carcass rail was littered with dirt and wood chips. A pool of standing water was also observed around the drain. [M.I.R 28.1 p]
e) A closed-end circular hole was observed near a freezer in the shipping area creating a potential for debris or/ moisture collection. [MOP 2.5.8] The management provided work orders for items a, b, c and e; item d was corrected immediately.

45/51 A stainless steel container for edible product had rough welds posing a potential for bio-film formation. [MOP 2.7.2] The deficiency gave assurance corrected as soon as possible.

46/51 a) A room adjacent to freeze blast carcass holding cooler and identified as an old shipping dock area was used to store plastic bins containing old kill line equipment (pulleys, gambrels etc.) and sundry other items. The plastic used to cover the bins was discolored and covered with debris. A cigarette butt was also found on the plastic sheet. [MOP 34.2.1]
b) In the South Q carcass holding cooler an area was cordoned off with an old dirty thin plastic sheet which was torn at several places and had holes in it. [MOP 34.2.1]
c) Debris was littering the floor in some freezers and coolers. [MOP 34.2.1]
Items a and c were corrected before the audit was over. The establishment gave assurance that the finding identified in item will be corrected as soon as possible.

58 The CFIA officials present at the audit issued a Notice of Intent to Delist (NOID) to the establishment following a discussion with the FSIS auditor on the findings during the audit.
The CFIA has generated a Corrective Action Request. The establishment has corrected most of the findings before the audit was over. For other findings establishment gave assurance that they will correct them as soon as possible

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan, DVM	6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
C ountry Ribbon Inc. Bldg. 902-907 East Whitehills Road St. John's, NL A1C 5L7	29 May 2007	291	Canada
	5. NAME OF AUDITOR(S) Rori K. Craver, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	
29. Records	X
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	X
35. Residue	X
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	X
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	X
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	X
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment Date: 29 May 2007 Est #: 291 (C ountry Ribbon Inc. [S/P]) (St. John's, NL, Canada)

10/51. The frequency for the cleaning of the cooling room adjacent to and leading into the RTE slicing room was once per week, checked by the cleaning supervisor once per week and verified by QA once per month. There was dust and protein residue on the fans in the room.

13/22/51. The deviation reports did not well document the cause of the deviation, the corrective actions or the preventive measures. CFIA reviews did not note the deficiencies in the deviation reports.

22/51. In the hazard analysis, the hazards are not well identified. When those hazards are transferred to the HACCP plan, the monitoring, corrective actions and preventive measures do not follow in a logical manner and do not reflect the hazard identified. The frequencies for monitoring and verification do not have supporting documentation. The frequency for the verification of deviation procedures is not frequent enough to allow for corrective actions and preventive measures to be completed in a timely manner.

29/51. The program that plots the results for the generic *Escherichia coli* program does not correctly identify the thirteen day window when there have been either unacceptable or marginal results.

34/51. No species testing was scheduled for this establishment in FY 2006-2007 even though they produce single and multi-species sausages.

35/51. The residue sampling plan was never received by CFIA at the establishment. Although they attempted to follow up on this, the plan was never received and no residue samples were taken at this establishment for FY 2006-2007. The plan for 2007-2008 has been received.

38. There was poorly documented follow-up by the establishment on recommendations made the pest control company personnel.

43/51. The water sampling program deviation program was not written in accordance with the CFIA Manual of Procedures.

45. The mop for condensation used exclusively in the RTE slicing room was stored with the mop head leaning against the wall and hand soap dispenser.

46. Employee personal equipment was left all over, many pieces on inappropriate surfaces when the packing room went on break.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
for Rori K. Craver, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Dollar Food Manufacturing Incorporated 1410 Odlum Drive Vancouver V5L 4X7	05/14/07	335	Canada
	5. NAME OF AUDITOR(S) Alam Khan, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58. NOID	X
59.	

60. Observation of the Establishment — Date: 05/14/07 Est #: 335 (Dollar Food Manufacturing Incorporated [P]) (Vancouver, Canada)

10/51 a)The surface around the blade guide of a ready-to-use band saw was covered with crusty material consisting of fat, meat and other extraneous material. [FSEP E 1.1.2]
b) A ready-to-use stainless steel tank and its drain tube had residues from the previous day's operations. [FSEP E 1.1.3]
c) Three S-shaped hooks for use in the edible product handling room were observed stored on the steps of a stair in the dryer room. The establishment immediately corrected the problems identified in items a-c. [FSEP E 1.1.2]

22/51 a) The frequency for thermometer calibration was not stated and the procedure did not define the range of the acceptable accuracy of the calibrated thermometer compared to the standard thermometer. [Pre-Req. Prog. C 1.2.2]
b) On multiple occasions, the HACCP supervisor had missed the second verification of monitoring as required by the HACCP plan. [MIR 30.1.1]
c) On multiple occasions the HACCP deviations were not defined adequately and abbreviated as "rejected". The establishment gave assurance to correct the problems identified in a-c immediately. [FSEP Vol. 3, 5.7 & 5.9]

39/51 a) The floor of a product dehydrating unit had an approximately 6x6x3 cm pit large enough to retain water and allow dirt /debris to accumulate. [MOP 2.5.8]
b) The door of a dryer unit had a rubber gasket which was torn and missing from some places. CFIA official leading the audit requested compliance; the establishment gave assurance that deficiencies would be removed as soon as possible. [MOP 2.7.2]

58 CFIA officials present at the audit issued the establishment a Notice of Intent to Delist based due to SSOP and other findings noted above.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Santa Maria Foods Corporation 353 Humberline Drive Toronto M9W 5X3	08 May 2007	340	Canada
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	Rori K. Craver, DVM		[X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	X
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	X
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

13. Entries on sanitation records did not contain sufficient detail to describe the findings or to allow verification of the efficiency of corrective actions and preventive measures. Inspection officials have been addressing the issue, but improvement was still minimal. FSEP Manual Chapter 2 – Section 4.8.5

22. Entries on some calibration records did not reflect the values actually observed. Entries on nitrite scaling/weighing records reflected the target weight but not the actual weight of nitrite. FSEP Manual Chapter 2 – Section 4.8.5

33. Establishment personnel had not informed the laboratory that the RTE product being sent for testing was destined for US export. The lab therefore did not use 325 g samples for *Salmonella* analyses. This was an additional establishment requested program. Meat Hygiene Manual of Procedures (MOP) – Chapter 11 – Export - Annex U – USDA Performance Standards for *Salmonella*

45/51. A. The air hose connections above one of the slicing machines were rusty and had shredding Teflon tape. Immediate corrective actions were taken by the establishment. Meat Inspection Regulations (MIR) – Section 28 (1) (Q), (R) & MOP – Chapter 2 – Section 2.7.2

B. There was rust along the housing on the bowl chopper. Some of the areas were directly above open areas of the bowl. The equipment was immediately taken out of service by the establishment. A new one is on order. Establishment personnel assured the auditor that measures to ensure sanitary conditions would be taken before the equipment was put back into service. MIR Section 28 (1) (Q), (R) & MOP Chapter 2 – Section 2.7.2

C. Several Vemags used for ground and pre-ground product had rough welds on the interior walls which can not be completely cleaned and could lead to the formation of bio-films. MIR – Section 28 (1) (Q), (R) & MOP – Chapter 2 – Section 2.7.2

46. There were several instances of potential cross-contamination contact observed in the raw stuffing area including the outside of a product tote used to push product across a table, contact between hanging stuffed product and the bin holding hanging sticks, and very close proximity of a rack of raw product to the coat hanging stand. MIR Section 56 (2) & MOP Chapter 2 – Section 2.4.4 (h) (i) & FSEP Manual – Chapter 2 _ Section 4.4.2 & 4.5

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
FOC Rori K. Craver, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Natural Organic Food Group, NOFG 6 MacAleer Drive Charlottetown C1E 2A1	24 May 2007	474	Canada
	5. NAME OF AUDITOR(S) Rori K. Craver, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	X
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	X
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	X
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	
29. Records	
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	X
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	X
39. Establishment Construction/Maintenance	X
40. Light	
41. Ventilation	X
42. Plumbing and Sewage	X
43. Water Supply	X
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	X
46. Sanitary Operations	
47. Employee Hygiene	X
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	X
58. Notice of Intent to Delist	X
59.	

60. Observation of the Establishment — Date: 24 May 2007 Est #: 474 (Natural Organic Food Group, NOFG [S/P/CS]) (Charlottetown, Canada)

10. There were several instances of product handling on the slaughter floor where there was actual and potential product contact between employees' boots and/or the stand where the employee was stationed. One of these involved the evisceration procedure and the product was then put in the trays for presentation and CFIA inspection with no notification that the product had been contaminated. The same type of deficiency was found in the 2005 FSIS audit. Meat Inspection Regulations (MIR) – Section 34 (21.) (b)

11/13/22/51. Pre-operational/operational sanitation monitoring records did not have sufficient detail to identify the findings, describe the corrective actions, or verify that the corrective actions taken were effective. No preventive measures were recorded on these records. A new section had been added for corrective actions and preventive measures to be recorded, but only on a very few records had it been used. Initials and check-offs for some QC related daily and weekly tasks had not been completed. HACCP records also lacked detail. This is a repeat of a finding from the FSIS audit of 2005. Additionally, there did not appear to be a program of maintenance (assessment) of the sanitation program as some deficiencies were repeated for several days in a row but no preventive measures were proposed and the establishment appeared to be unaware that there was a trend developing. FSEP Manual – Appendix VI – Guidelines for a Complete Written Program

21/22/51. The hazard descriptions, critical limits, monitoring procedures and deviation procedures for the CCPs in slaughter and cut-up did not follow in a logical progression. The hazard description for the CCP for zero tolerance for visible fecal, ingesta (and milk) was written as the "inadequate removal of the contaminated area." Corrective actions for this CCP were to repeat the 10 front or hind carcass sampling. If that sampling had no deviations, that were no further actions. Only if two successive lots sampled had a deviation, would further measures be taken. FSEP Manual – Chapter 2 – Section 4

34. No species testing is done by CFIA at this establishment even though they produce a pork sausage and a beef and pork sausage. Meat Hygiene Manual of Procedures (MOP) - Chapter 5 – 5.6.5

38/51. The pest control program did not contain written follow-up to actions suggested by the contract pest control company. FSEP Manual - Appendix VI – Guidelines for a Complete Written Program

39/51. There was exposed insulation on an overhead pipe in the carcass cooler. There were no carcasses under that area at the time. MIR – Section 28 (1c)

39/41/51. There was beaded condensation on some rails in the carcass cooler. This is a repeat of a finding from the 2005 FSIS audit. There were no carcasses under that area at the time. There was a plastic strip curtain in the freezer that had frozen condensate on it and several panels were ripped partially off. MIR - Section 37

42. There was no floor drainage around the area of the sticker. Even though this employee had a slightly raised area to stand on, he was surrounded by water with blood in it. MOP – Chapter 2 – 2.5.8

43/51. In October 2006, there were two water samples submitted to the lab that resulted in total coliform counts above what is acceptable by CFIA standards (maximum of 10 CFU/100 ml.) Four samples are taken at a time (every six months), two had results of zero, one had a result of 14 and one had a result of 80. The corrective action taken was that those two samples were repeated at the same location eleven days later. The reports from the lab only give a result, not an acceptability of the result. The results come by standard mail. There is no SOP for the sampling procedure to assure that it is done in an aseptic manner. The MOP gives definitive deviation procedures which were not followed and not written into the pre-requisite program for water; these procedures involved a daily sample taken for three days following the failure and other extra sampling in the weeks following. Only one sample was taken for each of the two sites and when those results were negative, nothing more was done. The unacceptable results were not reported to CFIA. MOP – Chapter 3 – 3.2.2

45/51. A. There was rust on many pieces of equipment in various rooms of the establishment. Some of these locations were over product contact surfaces. Hoses were not hung on the hangers provided and had large sections on the floor. MIR Chapter 28. (1) (q) & (r)

B. Inedible barrels were placed in both the slaughter and cut up areas so that there was contact between them and employees, employees' equipment, and box liners for edible product boxes. This is related to a finding from the 2005 FSIS audit. MOP Chapter 3 – 3.8.5

47. Personal work equipment, knives, mesh gloves, plastic gloves, sleeves, were left haphazardly everywhere when the kill floor employees went to break; this included knives left in a hand wash sink. A bottle of chemicals and gloves were left in another hand wash sink in the inedible area. MIR – Section 34 (21.) (b)

51. CFIA personnel had not noted the water sampling problem in either MCAP tasks or quarterly audits. CFIA personnel were not following up and closing out Corrective Action Plans from the establishment. MCAP tasks were not being completed at the frequency designated and a large group of tasks were being left for the end of the month. MOP – Chapter 3 – 3.2.2

57. The CFIA daily attendance log had three days in February and one in April that did not have an entry. CFIA was able to demonstrate through other paperwork that inspection personnel had been present. These logs had not been verified by supervisory reviews. MOP Chapter 11 – 11.7.3 – 3 (a) (ii) (iii)

58. A Notice of Intent to Delist was given by the CCA to the establishment based on discussion following the audit and for the above findings of SSOP, SPS, and HACCP.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
for Rori K. Craver, DVM	6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
Olivieri Foods Limite/Les Aliments Olivieri Limite 80 Brockley Drive Hamilton L8E 3C5	05/07/07	557A	Canada
	5. NAME OF AUDITOR(S) Alam Khan, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOPs have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
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Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment Date: 05/07/07 Est #: 557A (Olivieri Foods Limite/Les Aliments Olivieri Limite [P]) (Hamilton, Canada)

10/51 The following observations were made during the pre-operational sanitation verification:
a) In the kitchen, a ready-to-use stainless steel barrel for edible product was smeared with tomato sauce on the inner and outer edge of the rim from the previous day's operation. The lid of the barrel was observed lying on the kitchen floor.
b) The connecting end of a stainless steel pipe for flushing the kettles was resting on the floor in the kitchen.
c) The parts of a mouthpiece assembly from a forming machine had dough and flour residues on them from the previous day's operation.
d) One of the mixer paddles of a sauce hopper had a ½ " long thin layer of dough-flour mixed residues on its edge.
e) One of the Vemag hoppers had unidentified dark brown material attached to one of its blades.
f) Two of the product cooling units had residues of dough and other extraneous material scattered throughout the units. A thin brown paste of dough flour and water was observed trapped in the space along the outer panel and an inner short vertical bar of one of the unit. [FSEP E 1.1.3]

46/51 a) Used plastic liners and boxes were observed lying on the floor in the kitchen. [FSEP E 1.1.2]
b) A tool chest and some hand tools were observed stored on a work table next to an exposed block of cheese. An empty box was also found near the bulk cheese on the same table. [FSEP D 2.1.1]
c) In the (whip) cooler, some unidentified equipments were stored on the floor. [FSEP E1.1]
In the same cooler, the plastic liner smeared with the tomato sauce was observed protruding and touching the exterior of a partially closed barrel. All the identified deficiencies in items a-c were corrected by the establishment. [FSEP B 2.1.2]

The establishment had corrected all deficiencies which were identified in the NOID issued to the establishment during the audit conducted on 05/10/2006.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
XL Foods Incorporated 11811555 - 24th Avenue North West Moose Jaw S6H 7T2	05/22/07	597	Canada
	5. NAME OF AUDITOR(S) Alam Khan, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
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Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
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16. Records documenting implementation and monitoring of the HACCP plan.	
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Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	
28. Sample Collection/Analysis	
29. Records	
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	
31. Reassessment	
32. Written Assurance	

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	X
40. Light	X
41. Ventilation	X
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	X
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	
53. Animal Identification	
54. Ante Mortem Inspection	
55. Post Mortem Inspection	
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment Date: 05/22/07 Est #: 597 (XL Foods Incorporated [S/P]) (Moose Jaw, Canada)

10 A steel hook used to hang carcasses on a rail was seen stored on the footboard of a trim stand. CFIA requested compliance from the establishment; immediate corrective actions were initiated. [FSEP E 1.1.2]

39/51 a) A PVC pipe that drained the solid refuse from the offal harvest room had a loose coupling that allowed seepage of water and solid refuse to accumulate in an area around the coupling at floor wall-junction in the harvest packaging room. [M.O.P 2.5.6]
b) Signs of rain water seepage were evident around the roof-wall juncture in the dry goods/packaging room.
c) The hinges of the door of a freezer were badly rusted. [MIR 28]
d) Throughout the kill floor ceilings were covered with pieces of plastic sheets to collect rain water. The sheets were dated with black marker for date of installation; however, use of sheets or their maintenance were not referenced in any sanitation or pre-requisite program. [MIR 28]
e) Old torn pieces of plastic were observed tied to several overhead structures in the kill floor.
f) Loose insulation was observed hanging from a pipe. [MIR 28]
g) A lamp fixture over the product in the cooler had rusty or corrosion spots and was missing the fixture cover. [MOP 2.5.4(c)]
h) The floor of the chemical storage room was littered with used gloves and a couple of rusty aerosol cans. Barrels of chemicals were stored on the floor. [FSEP E 1.1.2, MIR 34 (1.1)]
The establishment gave assurance that items a-g would be corrected as soon as possible. Item h was corrected immediately.

41/51 Dripping Condensate was observed at the entrance to a cooler for fresh carcasses. No product was passing the cooler at the time of this observation. An employee was assigned to the area to monitor the condensation until the ventilation problem could be solved permanently. [MIR 37]

45/51 Two inedible containers had multiple cracks. The containers were discarded. [MIR 34.5]

46/51 a) A trolley for holding rail hooks used to hang carcasses had meat and fat particles from the previous day's operation. The establishment gave assurance to correct the problem. [MOP 2.7.1.2]
b) A long steel hook used to move and pull edible products on the table was hung on the wall with the cleaning and sweeping equipment. The Establishment corrected the problem. [MOP 2.4.4]
c) The floor of the freezer in the offal harvest area was littered with debris.] The Establishment personnel gave assurance to take care of the cooler sanitation with the general housekeeping. [MOP 34.2.1

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan, DVM	DVM 6/11/07

United States Department of Agriculture
Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY
New Food Classics 820 60th Street E Saskatoon S7K 8G8	05/24/07	761	Canada
	5. NAME OF AUDITOR(S) Alam Khan, DVM		6. TYPE OF AUDIT [X] ON-SITE AUDIT [ ] DOCUMENT AUDIT

Place an X in the Audit Results block to indicate noncompliance with requirements. Use O if not applicable.

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results
7. Written SSOP	
8. Records documenting implementation.	
9. Signed and dated SSOP, by on-site or overall authority.	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements	
10. Implementation of SSOP's, including monitoring of implementation.	X
11. Maintenance and evaluation of the effectiveness of SSOP's.	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.	
13. Daily records document item 10, 11 and 12 above.	X
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements	
14. Developed and implemented a written HACCP plan .	
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	
16. Records documenting implementation and monitoring of the HACCP plan.	
17. The HACCP plan is signed and dated by the responsible establishment individual.	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	
21. Reassessed adequacy of the HACCP plan.	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.	
Part C - Economic / Wholesomeness	
23. Labeling - Product Standards	
24. Labeling - Net Weights	
25. General Labeling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moisture)	
Part D - Sampling Generic *E. coli* Testing	
27. Written Procedures	O
28. Sample Collection/Analysis	O
29. Records	O
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	O
31. Reassessment	O
32. Written Assurance	O

Part D - Continued Economic Sampling	Audit Results
33. Scheduled Sample	
34. Species Testing	
35. Residue	
Part E - Other Requirements	
36. Export	
37. Import	
38. Establishment Grounds and Pest Control	
39. Establishment Construction/Maintenance	
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	
45. Equipment and Utensils	
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	
Part F - Inspection Requirements	
49. Government Staffing	
50. Daily Inspection Coverage	
51. Enforcement	X
52. Humane Handling	O
53. Animal Identification	O
54. Ante Mortem Inspection	O
55. Post Mortem Inspection	O
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	O
57. Monthly Review	
58. NOID	X
59.	

60. Observation of the Establishment

Date: 05/24/07 Est #: 761 (New Food Classics [P]) (Saskatoon, Canada)

10 The following observations were made during pre-operational sanitation verification:
a) The pin hole of cylindrical shafts from the mouthpiece assembly of two separate grinders was packed with meat and fat residues from the previous day's production.
b) The Surface of a work table had meat or fat particles from the previous day's production.
c) In the grinding room, the hopper of a grinding machine had an area around the auger which was smeared with pieces of fat and meat from the previous day production.
d) A few stainless steel totes for product storage had fat or meat particles.
e) Two large plastic bins for product storage had fat or meat particles.
f) A residue of fat and meat mix was observed in both nitrogen tunnels.
g) Fat and meat particles were found scattered on the floor in the pre-grinding area. The pre-operational sanitation program requires that all floors be cleaned prior to operation. [From a-g, FSEP E 1.1.3]

The establishment management corrected all the findings identified above, and re-presented the grinding room for pre-operational sanitation verification.

13/51 a) Preventive measures for corrective actions were not included in the daily records documenting operational sanitation non-compliances. [MOP 3.3.4]
b) Records documenting operational and pre-operational sanitation monitoring reflected repetitive deficiencies. The preventive measures for operational and pre-operational sanitation for non compliances were not effective in preventing the recurrence of same deficiencies. [MOP 3.3.4] The establishment gave assurance that they would comply with MIR and evaluate its SSOP.

46/51 a) Heavy buildup of meat, fat, grease and debris was observed in pulley-and-chain enclosure box of a grinding machine. The finding was corrected immediately by the establishment. [MOP 2.7.1.2(b)]
b) A soiled blue apron was observed hung with clean white frocks. The finding was corrected immediately. [MIR 56(1)(6); FSEP D2.1.1]

58 Following a discussion on the findings, the CFIA officials present at the audit decided to issue the establishment a Notice of Intent to Delist (NOID) because of SSOP and SPS concerns arose as a result of the audit.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan, DVM	6/11/07

Canadian Food Inspection Agency
Agence canadienne d'inspection des aliments

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Mr. Donald C. Smart
Director, International Audit Staff
Office of International Affairs – FSIS
1299 Farnam Str, Suite 300
Omaha, NE 68102
United States of America

Subject: Draft Final Audit Report, May 1 – June 6, 2007.

Dear Mr. Smart:

Thank you for your e-mail, dated August 9, 2007, to Dr. Bill Anderson, Director, Meat Programs Division (MPD), Canadian Food Inspection Agency (CFIA), and the attached copy of the Draft Final Audit Report carried out in Canada for the period of 1st of May to 6th of June, 2007. This office appreciates the opportunity to provide comments on this report.

Foreign Audit Reports are welcomed as an additional source of information to CFIA, in order to assess the performance of the Canadian meat inspection system and enable a continuous improvement.

With regards to the six establishments which received a "30 Day Notice of Intent to Delist" (NOID), you have acknowledged the receipt of our letters of verification that corrective actions had been taken within the prescribed time frame. The action plans were accepted by the Food Security and Inspection System (FSIS) and no further actions were requested.

Furthermore, we have received your letter, dated July 26, 2007, that you had reviewed and accepted the corrective actions and action plan of Establishment 63, which was de-listed during the Audit. As a result of this letter, it was recommended that Establishment 63 be re-listed.

The plant specific reports were forwarded to each establishment for an appropriate follow up. All plant specific deficiencies that were noted in the inspection reports were corrected either immediately or are being corrected through the implementation of action plans.

.../2

Following the 2007 USDA audit, an audit checklist was designed to address all generic findings, found during the Audit, and reported in the Draft Audit Report.

CFIA Food Safety Enhanced Program (FSEP) auditors have scheduled and are currently performing FSEP audits in all
Federally Meat and Poultry Establishments based on this audit checklist. This process will allow any construction, maintenance and sanitation issues to be addressed.

As well, CFIA has been developing the Compliance Verification System (CVS) as a way of addressing concerns associated with uniformity, duplication, accountability and enforcement. In the long term, meeting the CVS design objectives will enhance our ability to implement an efficient, effective, and uniform food inspection system in all of Canada's Federally licensed meat establishments.

The CVS is an evolutionary inspection program which is based on the delivery of food safety and non-food safety related verification tasks by inspection staff to ensure industry compliance to regulations. This new approach to inspection has been designed to meet the following objectives:

- Integrate compliance activities into one system, which reduces duplication;
- Highlight industry accountability;
- Focus CFIA activities on compliance verification to regulatory requirements;
- Integrate HACCP requirements into compliance verification activities;
- Provide inspection staff with clearly defined tasks to enhance uniform delivery;
- Provide frontline staff with effective enforcement tools;
- Verify operators' written programs are implemented and effective to meet regulatory requirements;
- Implement a Quality Management System (QMS);
- Support the strategic direction of the CFIA business plan to move industry and government towards a more science-based risk management system.

Full implementation of the CVS, in all federally licensed meat establishments, is scheduled for April 01, 2008. Prior to full implementation, inspection staff will receive a four (4) day CVS in-class training course followed by a mentorship program beginning in September 2007. A one day industry workshop will also be held during September 2007 in 11 locations throughout Canada in order to reinforce the roles and responsibilities of industry, and to introduce the CVS.

Central to an effective CVS is an effective enforcement policy. The enforcement policy has been developed to provide guidance to inspection staff when establishments are in non-compliance to the Act and Regulations. The Program Network and Regional Veterinary Officers have a clearly defined role in ensuring that they can provide the necessary guidance and support that inspection staff will require during their compliance verification activities.

.../3

The following are our comments with respect to the section on Microbiology Laboratory Audits:

Regarding the comment in Section 6.1.4 - Main Findings - Adequate Administrative and Technical Support:

- Of the five Canadiam micro lab methods, listed in the Meat Hygiene Directive 2006-26, (Dr. Kamanzi's directive), only one of these methods has been deemed equivalent by FSIS (E coli 0157 BAX). One additional method has been deemed equivalent and included as a notation (Listeria BAX).
- No method for the analysis of Salmonella in raw or RTE products has been deemed equivalent.

We wish to advise you that all methods used by CFIA and private laboratories in Canada are approved by the Government of Canada and are published in the Health Canada's Compendium of Microbiology Methods and can be found on the following Health Canada web site:
http://www.hc-sc.gc.ca/fn-an/res-rech/analy-meth/microbio/index_e.html On tha comment

In addition, we would like to clarify that in the case of raw meat products, our export requirements prescribe that *Salmonella* testing for the purpose of meeting FSIS performance standards must be performed using the testing methodology specified in the Pathogen Reduction; HACCP Systems; Final Rule.

The CFIA Science Branch will be applying for equivalency of methodology for the *Salmonella* BAX, and cultural confirmation methods for *Salmonella*, *Listeria* and *Ecoli* 0157 in meat and eggs.

CFIA officials present during the on-site audit and during the exit meeting did not challenge any of the individual observations made by the USDA/FSIS auditors. Having said that, I would however like to voice my concern over the tone of general statements made in the draft final report. In section 9.2, the following overall statement is being made on the subject of the Sanitation Performance standards (SPS); "Nineteen of 20 slaughter and/or processing establishments (including cold storage) audited had deficiencies in SPS."

We found that this statement is unnecessarily severe. We believe that the 19 establishments include all establishments where some findings were classified as indicating non-compliance with requirements. We agree that the findings identified in the plant reports were observed during the audit, but would suggest that the statement be changed to: In addition, some of the SPS requirements were not being enforced adequately in 19 of 20 establishments.

.../4

I trust the above summarizes our response to observations outlined in the draft report and will clarify the position of CFIA on same matters raised in the draft report.

Should you wish to discuss further or need clarification on the above, please do not hesitate to contact me.

Yours sincerely,

for Dr. Bill Anderson
Director
Meat Programs Division