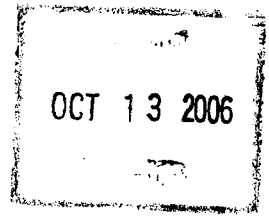
United States Department of Agriculture
Food Safety and Inspection Service
Washington, D.C. 20250



Dr. William Anderson, Director
Food of Animal Origin
Canadian Food Inspection Agency
159 Cleopatra Drive
Ottawa, Ontario K1A 0Y9
Canada

Dear Dr. Anderson:

This letter transmits the Food Safety and Inspection Service final report of a meat inspection system audit conducted in Canada April 25 through May 23, 2006. Comments from Canada have been included as an attachment to the final report. Enclosed is a copy of the final report.

If you have any questions regarding this audit or need additional information, please contact me by telephone at 202-720-3781, by fax at 202-690-4040, or by electronic mail at sally.white@fsis.usda.gov.

Sincerely,

Sally White

Sally White
Director
International Equivalence Staff
Office of International Affairs

Enclosure

FINAL

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

APRIL 25 through MAY 23, 2006

Food Safety and Inspection Service
United States Department of Agriculture

TABLE OF CONTENTS

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

1. INTRODUCTION

The audit took place in Canada from April 25 through May 23, 2006.

An opening meeting was held on April 25, 2006, in Ottawa, Canada, with the Central Competent Authority (CCA), the Canadian Food Inspection Agency (CFIA). 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, and/or Area or Regional Offices.

2. OBJECTIVE OF THE AUDIT

This audit was Phase V of the enforcement audit of Canada's meat and poultry inspection system. Phases I, II, III, and IV were conducted in December 2004, February 2005, May/June 2005, and October 2005, respectively. The objective of this audit was to determine if Canada can continue to export meat and poultry products to the United States by evaluating the performance of the CCA with respect to controls over the slaughter and processing establishments certified by the CCA as eligible to export meat and poultry products to the United States.

In pursuit of the objective, the following sites were visited: the headquarters office of the CCA, three Area Offices, 11 Regional Offices, four microbiology laboratories, and 21 establishments.

Competent Authority Visits			Comments
Competent Authority	Headquarters	1	
	Area	3	Supervise Certified Establishments
	Regional	11	Supervise Certified Establishments
Microbiology Laboratories		4	
Meat Slaughter and Processing Establishments		1	
Poultry Slaughter and Processing Establishments		1	
Meat and Poultry Processing Establishments		19	

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 microbiology laboratories (three private laboratories and one government laboratory), and 21 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 are carried out by Canada and determined if establishment and inspection system controls were in place to ensure the production of meat and poultry 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) Canadian Food Inspection Agency laws, regulations, and other requirements, and 2) any equivalence determinations made for Canada.

Equivalence determinations are those that have been made by the Food Safety and Inspection Service (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 Product
  - Establishments select samples
  - Private laboratories analyze samples

- *E. coli* O157:H7—Compositing of Samples Prior to Screening Test

- High Line Inspection System for Beef

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.) and
- The Poultry Products Inspection Regulations (9 CFR Part 381).

5. SUMMARY OF PREVIOUS AUDITS

Final audit reports are available on FSIS' website at:
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 June/July 2003 and May/June 2005.

Summary of June/July 2003 Audit Findings

Government Oversight

- Two establishments were delisted for failure to meet US requirements.
- Seven establishments received Notices of Intent to Delist for SSOP and HACCP implementation deficiencies.
- Staffing was adequate for oversight, with the exception of two areas:
    - Supervisory reviews were not conducted each month in six of the 37 establishments audited.
    - Daily inspection coverage for processing establishments was not provided for 11 of the 37 establishments audited.
- Control and supervision of inspectors in certified establishments was inadequate at the regional and local levels for performance of ante-mortem inspection, performance of post-mortem procedures, and performance of pre-operational sanitation verification.
- In eight establishments, local CFIA inspectors did not maintain records for monitoring or frequency for hands-on pre-operational sanitation verification procedures.
- Deficiencies were observed in two establishments for inadequate supervision and control over official activities and certified establishments.
- Several monthly supervisory review reports did not include a documented review of HACCP, SSOP, and the testing programs for generic *E. coli* and *Salmonella.*

Animal Disease Controls

- In one of the nine slaughter establishments audited, ante-mortem inspection procedures were not performed correctly for cows.

    - The ante-mortem veterinarian performed adequate ante-mortem inspection procedures for heifers and steers, i.e. walked around in the pen observing the animals at rest and in motion, but when he was asked to demonstrate

the ante-mortem procedure for cows, he did not observe each side of the cows as they passed by one-by-one in single file.

- In three of the nine slaughter establishments, deficiencies in post-mortem inspection procedures were observed.

Sanitation Controls

- In 19 establishments, records documenting implementation, maintenance, and effectiveness of SSOP and corrective actions were incomplete or missing.
- In 14 establishments, over-product condensation was identified.
- In 12 establishments, sanitation controls for sanitary operations were not effective.
- In 11 establishments, the SSOP was not effectively implemented.
- In 10 establishments, corrective actions written in the SSOP failed to prevent direct product contamination.
- In nine establishments, construction and maintenance controls were not effective.
- In six establishments, sanitation controls for equipment and utensils were not effective.

Slaughter/Processing Controls
HACCP Implementation

- In 20 establishments, the contents of HACCP plans did not contain all required features.
- In 19 establishments, verification and/or validation documentation was missing.
- In 13 establishments, corrective actions for a deviation from a critical limit did not contain all four regulatory requirements.
- In four establishments, HACCP plans were not reassessed annually.
- In three establishments producing ready-to-eat products, *Lm* was not considered as a hazard reasonably likely to occur.
- In three establishments, records for documentation of the written HACCP plans were not properly completed.
- In three establishments, pre-shipment review records were not available.

Control of Condemned Product

- In two establishments, condemned product controls were not effective.

Enforcement Controls

- In 32 establishments, not all FSIS requirements were being enforced.
- In eight establishments, local CFIA inspectors did not maintain records for monitoring or frequency of hands-on pre-operational sanitation verification procedures.
- In two of nine slaughter establishments, the following deficiencies were found:

- Statistical process control procedures had not been developed to evaluate the results of generic *E. coli* testing.
- Excision criteria were being used to evaluate sponge sampling results.

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 (325 grams for *Salmonella*; 25 grams for *Lm*).

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 SPS requirements.

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 US regulatory requirements, which are equivalent to Canadian requirements.

6. MAIN FINDINGS

6.1 Government Oversight

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

- However, significant deficiencies were noted in CFIA's oversight of private microbiology laboratories.

- In addition, all of CFIA's regulatory requirements were not being enforced in 20 of 21 establishments.

6.1.2 Assignment of Competent, Qualified Inspectors

CFIA has competent, qualified inspectors assigned to establishments certified for export to the United States.

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.

- 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.

6.2 Headquarters Audit

The lead auditor interviewed inspection officials and conducted a review of inspection system documents at headquarters. The document 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 Offices

The lead auditor interviewed inspection officials for government oversight functions, including records review, at three Area Offices and 11 Regional Offices. The three Area Offices were: West, Ontario, and Atlantic. The 11 Regional Offices were: Manitoba, Saskatchewan, Alberta South, British Columbia Mainland/Interior (West Area Office); Toronto, South West, North East, Central, (Ontario Area Office); New Brunswick, Nova Scotia, Prince Edward Island, (Atlantic Area Office).

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

7. ESTABLISHMENT AUDITS

The FSIS auditors visited a total of 21 establishments—one meat slaughter and processing establishment, one poultry slaughter and processing establishment, and 19 meat and/or poultry processing establishments. No establishments were delisted by CFIA. One establishment received a Notice of Intent to Delist from CFIA for SSOP and SPS deficiencies.

Specific deficiencies are noted on the attached individual establishment reports.

8. MICROBIOLOGY LABORATORY AUDITS

During laboratory audits, emphasis is 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 microbiology laboratories were reviewed: three private laboratories and one government laboratory.

- Bodycote Essais de Materiaux Canada, Inc. (private)
- Maxxam Analytics, Inc. (private)
- IG MicroMed Environmental, Inc. (private)
- CFIA Dartmouth (government)

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.

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.

Eight of 21 establishments had deficiencies in the implementation of the SSOP, which resulted in both potential and direct product contamination. Examples of findings included:

- Improper documentation of daily records for ongoing SSOP requirements in 10 establishments.
- Improper implementation of the SSOP in five establishments.
- No corrective action taken when the SSOP failed to prevent direct product contamination in one establishment.
- No reference to pre-operational sanitation in the SSOP prerequisite program, although pre-operational sanitation was occurring in one establishment.

9.2 Sanitation Performance Standards

Nineteen of 21 establishments had deficiencies in the implementation of SPS. Examples of findings included:

- Improper maintenance of grounds leading to potential rodent activity.
- Improper establishment construction or maintenance.
- Inadequate ventilation.
- Improper maintenance of dressing rooms and lavatories.
- Improperly cleaned equipment and utensils.

- Insanitary conditions in the establishments. For example, insects were found in two empty containers ready to use for rework product, and product residue was evident in bins ready for use.

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 21 establishments. Fifteen of 21 establishments had deficiencies in the implementation, corrective actions, verification and/or recordkeeping parts of HACCP.

Examples of findings included:

- In 11 establishments, there was inadequate recordkeeping documenting the written HACCP plan, the monitoring of the critical control points, and dates and times of specific occurrences.
- In seven establishments, verification and validation of the HACCP plan were not performed properly.
- In four establishments, the corrective action was not written in the HACCP plan.
- In three establishments, the HACCP plan was not adequately reassessed.
- In two establishments, ongoing monitoring of the HACCP plan was not performed properly.

11.3 Testing for Generic *E. coli*

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

Two 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. The following deficiency was noted:

- In one establishment, no stand was available to perform the testing, which made it difficult to collect the sample in a sanitary manner.

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:

- Laboratories, instead of testing 325 grams of product for *Salmonella*, only 25 grams of product was being tested.

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.

No residue laboratories were reviewed during this audit. However, residue controls at the establishments were reviewed during the on-site audits. No deficiencies were noted.

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

Two 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 two slaughter establishments.

13.3 Species Verification

No deficiencies were noted.

13.4 Monthly Reviews

In two establishments, supervisory reviews of certified establishments were not being performed and documented as required.

13.5 Inspection System Controls

Except as noted in this report, 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.

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 May 23, 2006, with the CCA. At this meeting, the preliminary audit findings were presented to inspection officials.

The CCA understood and accepted the findings.

Ghias Mughal, 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 Consumer Foods Inc./Les Aliments Maple Leaf Inc.; dba many others 870 Lagimodiere Blvd., Winnipeg, MB R2J 0T9	5 May 2006	001	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.	X
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	0
28. Sample Collection/Analysis	0
29. Records	0
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	0
31. Reassessment	0
32. Written Assurance	0

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	X
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	0
53. Animal Identification	0
54. Ante Mortem Inspection	0
55. Post Mortem Inspection	0
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	0
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

CANADA – Est. 001
5 May 2006
Maple Leaf Consumer Foods Inc.
Winnipeg, MB

13/51. Descriptions of deficiencies and corrective actions in SSOP records were not descriptive enough to evaluate the situations and the efficacy of the corrective actions. **MIR 34(2.2)**

19. Verification of thermometer calibration records did not catch a variety of errors including values exceeding the set limits. **MOP 2.7.4**

21/22/51.The hazard analysis of RTE products did not mention *Listeria monocytogenes* or *Salmonella* in the packaging step as a hazard. However, the required testing programs for both were in force. (Alternative 3 was the one chosen by this establishment.)

Monitoring records of several CCPs did not correspond with the directions for the monitoring in the Form 10s of the HACCP plans.

Monitoring records had times filled in before events occurred.

Monitoring records had times only in full and half hours increments.

One CCP plan called for three temperature measurement locations, but only one value was recorded and the operator stated that he recorded the most critical of the three.

The directions for CCP monitoring tended to be vague, such as stating that temperatures were to be taken in three locations, but not how many pieces of product. **FSEP Manual, Chapter 2, Sections 4.6.2, 4.8.2, 4.8.5**

41/51. The condensation program and the resulting records did not correspond; these records did not allow an evaluation of what the condensation situation in the establishment was. An evaluation of records showed that all of the records for several weeks were identical. **MIR 34(2.2)**

45/51. There were small rust deposits on the hinges of the spiral ham slicers. Because of the motions of these hinges, there was a potential of this rust flaking onto the hams during slicing. No actual contamination was observed. **MOP 3.6.1**

Electrical cords in several areas were placed in a manner that could cause cross-contamination either from personnel contact or floor and other non-food contact surfaces. **MOP 2.7.3**

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Rori K. Craver, DVM	for

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 Consumer Foods Inc. Mitchell's Gourmet Foods Inc. 100 McLeod Ave. Saskatoon, SK S7M 5V9	8 May 2006	069B	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.	
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	
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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.	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	0
28. Sample Collection/Analysis	0
29. Records	0
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	0
31. Reassessment	0
32. Written Assurance	0

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	X
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	0
53. Animal Identification	0
54. Ante Mortem Inspection	0
55. Post Mortem Inspection	0
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	0
57. Monthly Review	
58. RTE Sampling Plan	X
59.	

60. Observation of the Establishment

CANADA Est. 069B
8 May 2006
Maple Leaf Consumer Foods Inc.
Mitchell's Gourmet Foods Inc.
Saskatoon, SK

22/51. The descriptions of monitoring procedures in the cook and chill step CCPs did not designate how many pieces of product to monitor for temperature.

The post-lethality steps of the hazard analysis of ready-to-eat (RTE) products did not specifically mention *Salmonella* in the list of biological pathogen hazards so the auditor was unable to determine if the plan had been assessed for this hazard.

Cook step CCP records indicated a temperature which met the critical limit (CL), but some showed the use of the designated corrective actions, possibly indicative of a temperature not meeting the CL being taken but not recorded. **FSEP Manual, Chapter 2, Sections 4.6.2, 4.8.2, 4.8.5**

39/51. The door at dry materials receiving (spices) did not seal to the dock but had some small openings to the outside because the weather stripping was buckling. **MOP 2.5.9**

45/51. The seals on some of the stuffing machines did not prevent the accumulation of stuffing materials in several places on the equipment. **MOP 2.7.4**

58/51. The RTE sampling plan listed the size of sample to be taken as a minimum of 100 grams but the written direction given by CFIA calls for a minimum of 150 grams. **CFIA risk-based sampling protocol for RTE – Version 1.0**

61. NAME OF AUDITOR
Rori K. Craver, DVM

62. AUDITOR SIGNATURE AND DATE

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 Inc. /Les Aliments Maple Leaf Inc., also dba many others 326 W. Main Street Berwick, NS BOP 1E0	24 May	150	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.	X
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	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	
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	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	0
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

CANADA Est. 150
03 May 2006
Maple Leaf Consumer Foods Inc.
Berwick, NS

12/45/51.The hot dog stuffer machine had several bad O-rings causing a build-up of stuffing on several surfaces of the machine. A rubber band was being used to fix a clamp problem. **MOP 2.7.4**

12. A shovel used for removing raw materials from combos was stored contacting the wall.
There was potential cross-contamination on the kill floor from employee boots that fit under the toe-guard of a raised stand and could contact carcasses as they came by on the rail. **MOP 2.6.1.1.4.1(d)**

28/51. There was no stand available for the person doing generic *E. coli* sampling. When questioned, the establishment representative said they didn't need one; they used a tall person to do the sampling. From floor level it would be difficult to maintain sterile conditions and adequately perform the task. **MOP 11.7.3 - USA, Annex T**

39/51. There were several damaged wooden gates in use in the pens area. **MOP 2.6.1.1.1.2**

41/51. The condensation control and monitoring written plan and the implementation and records generated by this plan were not in accordance with each other. There appeared to be confusion on whether marking condensation meant that it was observed, cleaned up, or monitored for. **MIR 34 (2.2)**

46. A cardboard combo box was cut off too short which allowed it to be under the work area with product contacting the underside of a catch trough.
A knife was used to open boxes of fresh mechanically separated chicken which also cut into the boxes and contacted product. The employees thumb, which had been in contact with the outside of boxes also came in contact with the product while removing the box before it went into the mixer. The part of the product contaminated by the thumb was removed and discarded. A new procedure for box opening will be put into place.
Consumer pack sausage trays come double wrapped. Packages of trays with the outside wrap removed were in contact with those still in the outside (warehouse storage) wrapper. The same personnel were handling these packages and open packages and the trays.
A rack of trolleys ready for use was in contact with a container for paper trash next to the hand-wash sink at the entrance to slaughter.
Hoses and power cords were in use and stored in contact with the floor. They had not been well cleaned. **MOP 4.10.3(19), MOP 3.3.3, MOP 2.7.3**

61. NAME OF AUDITOR
Rori K. Craver, DVM

62. AUDITOR SIGNATURE AND DATE

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
Les Aliments O Sole Mio Inc. 4000 Rue Alfred-LaLiberté Boisbriand, QC J7H 1P7	26 Apr 06	156	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.	X
19. Verification and validation of HACCP plan.	X
20. Corrective action written in HACCP plan.	X
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	0
28. Sample Collection/Analysis	0
29. Records	0
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	0
31. Reassessment	0
32. Written Assurance	0

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	0
53. Animal Identification	0
54. Ante Mortem Inspection	0
55. Post Mortem Inspection	0
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	0
57. Monthly Review	X
58.	
59.	

60. Observation of the Establishment

CANADA Est. 156
26 April 2006
Les Aliments O Sole Mio Inc.
Boisbriand, QC

13/22/51.Entries of non-compliances, corrective actions and preventive measures in both HACCP and sanitation records were unclear and incomplete in recording what the situations were and the actions taken to correct and prevent recurrence. Many records had missing entries. **FSEP Manual, Chapter 2, Section 4.8.5**

18. There was a box in the meat cooler without any markings. The cryovac package of meat inside also had no markings. After the auditor pointed this out, both the establishment and CFIA took immediate and appropriate actions and will be developing a plan to avoid recurrences of this problem. **MOP 7.6**

19/51. Verification of HACCP and sanitation records was not noting missing signatures, initials, or other required entries. **FSEP Manual, Chapter 2, Section 4.8.5**

13/20/51.A preventive measures protocol for noncompliances had been written, but was not yet included into the HACCP plans or SSOPs. Preventive measures were being taken but the recordkeeping was inconsistent. **FSEP Manual, Chapter 2, Section 4.8.3**

21/22/51.The hazard analysis of RTE meat sauces did not mention *Listeria monocytogenes* or *Salmonella* in the packaging step as a hazard. However, the required testing programs for both were in force. Because of the conditions during the post-lethality exposure, the hazard of contamination was considered as not likely to occur, but no documentation was present. **FSEP Manual, Chapter 2, Section 4.6.2**

46/51. Overall housekeeping in non-production areas needed further attention. These areas had paper, plastic wrapping, and other debris on the floor and pushed into corners on pallet racks, pallets, etc. In both production and non-production areas, there were accumulations of dust, powders, greasy residue, shredding Teflon tape and other tapes. (These were not on or over product contact surfaces.) **MOP 3.1.3**

57/51. Supervisory reviews meeting US requirements were not available.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Rori K. Craver, DVM	

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
Supraliment S. E. C. Also DBA extended list of Olymel Corp. 531 Rue des Érables Trois Rivieres, QC G8T 7Z7	28 Apr. 06	180	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.	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.	X
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	0
28. Sample Collection/Analysis	0
29. Records	0
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	0
31. Reassessment	0
32. Written Assurance	0

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	X
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	0
53. Animal Identification	0
54. Ante Mortem Inspection	0
55. Post Mortem Inspection	0
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	0
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

CANADA – Est. 180
28 April 2006
Supraliment S. E. C.
Trois Rivieres, QC

10/51. Although pre-operational sanitation is occurring as required by regulation, there is no reference to it in the SSOP pre-requisite program. **MIR 34(2.2)**

A clean-up hose was in contact with a product work table by the small ham filling machines. Immediate corrective action was required by CFIA and taken by the establishment. **MOP 2.7.3**

13/51. Entries of non-compliances, corrective actions and preventive measures in pre-operational sanitation records were unclear and incomplete in recording what the situations were and the actions taken to correct and prevent recurrence. The QA part of pre-operational verification only generates a report if there are non-compliances. **MIR 34(2.2)**

13/20/51.Preventive measures for noncompliances have been not been written into the HACCP plans or SSOPs. **FSEP Manual, Chapter 2, Section 4.8.5**

19/51. Observation of the monitor in the verification of CCPs was documented, but the direction for it in the HACCP plans CCPs was not clear. **FSEP Manual, Chapter 2, Section 4.8.4**

45 A black oil leak was causing a spatter pattern on one of the small ham can filling machines. Immediate corrective actions were taken by the establishment. **MOP 2.7.4**

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Rori K. Craver, DVM	for

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 Inc. Dba – XL Fine Foods 3410B Ogden Road, S.E. Calgary, AB T2G 4N5	9 May 2006	205	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.	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.	
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	0
28. Sample Collection/Analysis	0
29. Records	0
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	0
31. Reassessment	0
32. Written Assurance	0

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	X
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	0
53. Animal Identification	0
54. Ante Mortem Inspection	0
55. Post Mortem Inspection	0
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

Canada Est. 205
9 May 2006
XL Foods Inc.
Calgary, AB

10. Blood and other liquids were dripping off of the needler into a basket of edible meat pieces. CFIA and the establishment took immediate and appropriate corrective actions. **MOP 2.7.3**

19/51. The needler step was not considered as a physical hazard in the hazard analysis. The control of the identified metal at receiving was identified as controlled at the farm, it was actually controlled in the establishment. **FSEP Manual, Chapter 2, Section 4.6.2**

45. Some scabbards, steels and knives in the portioning room were stored in a manner allowing for potential cross-contamination with boots and pant legs. **MOP 3.9.3**

61. NAME OF AUDITOR
Rori K. Craver, DVM

62. AUDITOR SIGNATURE AND DATE

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
Hallmark Poultry Processors Ltd. 1750 Franklin Street Vancouver, BC V5L 1P7	12 May 2006	217	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.	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 .	
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Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements	
18. Monitoring of HACCP plan.	
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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	
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	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	0
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

Canada Est. 217
12 May 2006
Hallmark Poultry Processors Ltd.
Vancouver, BC

10. One of the cut-up operations tables had a large accumulation of product that was contacting surfaces that were not normally product-contact. Appropriate corrective actions were taken.

10/51. The establishment seemed confused about their pre-operational sanitation monitoring program; the areas were clean before operations began, but the monitoring was in two stages by the same person – a post clean-up check and then a recheck which, when all deficiencies were corrected, served as the monitoring. A plan was proposed to separate these actions. **MOP 3.3.1**

13/51. Proposed preventive measures were preprinted on sanitation documents, but what actual measures were taken were not recorded. **FSEP Manual, Chapter 2, Sections 4.8.3, 4.8.5**

22/51. The HACCP hazard analysis and plans have been recently updated. In the process, the consideration of pathogens being present in incoming live birds was deleted and no longer present in the plan. The computer software used by the establishment to prepare their plan causes changes throughout the plan when any item is changed. This led to a number of inappropriate entries such as the physical hazards in the receipt of water being metal, wood, hard plastic and glass.

The chilling CCP critical limit, monitoring plan and the resultant records did not correspond to each other. **FSEP Manual, Chapter 2, Sections 2.5, 4.6.2, 4.8.1, 4.8.2, 4.8.5**

39. There was a small patch of mold on the ceiling of the wing pack room. Appropriate corrective actions were taken. **MOP 3.3.1, FSEP Sanitation Prerequisite Program E1.1.1, 1.1.3**

45. Several hoses and cords throughout the establishment had contact with the floor.

Shovel hooks for different types of shovels (edible, ice, inedible) have been installed in several areas of the establishment. No cross-contact was observed, however, the hooks allowed contact with the walls or posts that they were mounted on and the hooks were not labeled as to which shovels should be hung on them. Appropriate corrective actions were taken and preventive measures proposed. **MOP 2.7.3, MIR 34(1.1)**

46/51. The upper plastic part of the salvage line bird hangers had a heavy accumulation of soap residue. These were immediately cleaned and reinspected by CFIA. The operation was then allowed to continue. **MOP 3.3.1, FSEP Sanitation Prerequisite Program E1.1.1, 1.1.3**

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Rori K. Craver, DVM	for

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
Les Aliments Wong Wing Inc. DBA McCain Foods, McCain Foods Canada 1875 Rue Bercy Montreal, QC H2K 2T9	27 Apr 06	282	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	
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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
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18. Monitoring of HACCP plan.	
19. Verification and validation of HACCP plan.	
20. Corrective action written in HACCP plan.	X
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	0
28. Sample Collection/Analysis	0
29. Records	0
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	0
31. Reassessment	0
32. Written Assurance	0

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	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	X
52. Humane Handling	0
53. Animal Identification	0
54. Ante Mortem Inspection	0
55. Post Mortem Inspection	0
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	0
57. Monthly Review	X
58.	
59.	

60. Observation of the Establishment

CANADA Est. 282
27 April 2006
Les Aliments Wong Wing Inc.
Montreal, QC

13/20/51.Preventive measures for noncompliances/deviations are not included in the HACCP plans or SSOPs. Record keeping does not reflect the use of preventive measures, except after first recurrence of a noncompliance or deviation. **FSEP Manual, Chapter 2, Sections 4.8.3, 4.8.5**

21/22/51.The hazard analysis of RTE products did not mention *Listeria monocytogenes* or *Salmonella* in the packaging step as a hazard. However, the required testing programs for both were in force. (Alternative 3 is the one chosen by this establishment.) **FSEP Manual, Chapter 2, Section 4.6.2**

39/51. Many areas of the establishment have rust, peeling paint, temporary plastic, and grease on electrical cords. Many of these observations were on overhead structures. No actual contamination was observed, however, many of these present potential sources of contamination. **MOP 2.7.3, 3.6.1**

41. Condensation was present on the filling cone for the production of spring rolls. This was directly over uncooked product. No actual contamination was observed. **MIR 34(2.2)**

57/51. Supervisory reviews meeting US requirements were not available.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Rori K. Craver, DVM	

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
The Pasta Mill Ltd. 12803 149 St. NW Edmonton, AB T5L 2J7	10 May 06	302	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.	X
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	0
28. Sample Collection/Analysis	0
29. Records	0
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	0
31. Reassessment	0
32. Written Assurance	0

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	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	0
53. Animal Identification	0
54. Ante Mortem Inspection	0
55. Post Mortem Inspection	0
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	0
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

CANADA Est. 302
10 May 2006
The Pasta Mill Ltd.
Edmonton, AB

13/51. Descriptions of deficiencies, corrective actions and preventive measures in pre-operational sanitation records are not sufficient to evaluate the situation and following actions. **FSEP Manual, Chapter 2, Section 4.8.5**

18/22/51.There was confusion in the designation of the Critical Limits for the cooking and metal detectors CCPs, the requirements for monitoring of these CCPs, and what was actually being monitored and recorded in the establishment. **FSEP Manual, Chapter 2, Sections 4.8.1, 4.8.2, 4.8.5**

39/51. The curtains and barriers around the area of new construction did not completely separate that area from the rest of the establishment during construction. **MOP 2.5.5**

In the shipping area, the dock guards did not seal off an open trailer; there were large gaps on either side. **MOP 3.10**

41. Condensation was noted on the ceiling above the top of the freezer tunnel as the conveyor belt brought the product into pack-off. In place were a number of plastic strips. These strips were no longer attached as originally intended to prevent this condensation. These strips were also touching some product as it entered the room and could provide a vehicle for cross-contamination. The establishment and CFIA took immediate and appropriate corrective actions and presented both short term and long term plans before the conclusion of the audit. **MIR 34(2.2)**

45/51. The stickers on the cheese cutting machine were peeling and shredding.

There was an air hose over the tomato paste vat that was making contact with the contents of the vat. **MOP 2.7.3**

46. The trash barrel next to the hand wash sink at the entry to production areas was too large and not well placed as it allowed for contact with the smock of every person using the sink. This was corrected immediately by the establishment. **MOP 3.3.3**

61. NAME OF AUDITOR
Rori K. Craver, DVM

62. AUDITOR SIGNATURE AND DATE

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
Freybe Gourmet Foods Ltd. 27101 56th Avenue Langley, BC V4W 3Y4	11 May 2006	361	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.	X
20. Corrective action written in HACCP plan.	X
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	0
28. Sample Collection/Analysis	0
29. Records	0
Salmonella Performance Standards - Basic Requirements	
30. Corrective Actions	0
31. Reassessment	0
32. Written Assurance	0

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	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	0
53. Animal Identification	0
54. Ante Mortem Inspection	0
55. Post Mortem Inspection	0
Part G - Other Regulatory Oversight Requirements	
56. European Community Directives	0
57. Monthly Review	
58.	
59.	

60. Observation of the Establishment

Canada Est. 361
11 May 2006
Freybe Gourmet Foods Ltd.
Langley, BC

10. The bottom layer of sausages on a smokehouse tree in the packaging room was at a height to possibly contact employee boots and/or pant legs. When the employee removing the sausages for packaging bent over to retrieve them, her apron and smock touched the floor and then was at product level when she stood up.

There was a basket of edible slices of deli meat that was positioned with the plastic inside bag surface against a non-food contact surface of the slicing machine. When this plastic would be folded in to move the meat after the basket was full, the plastic surface would have been directly in contact with the meat. **MIR 56.(2)**

13/19/22/51. The hazard analysis for some RTE products did not identify *Listeria monocytogenes, Salmonella* and *Escherichia coli O157:H7* as pathogens of concern at the appropriate post-lethality steps.

Records generated by both the sanitation programs and HAACP plans were not well understood by the employees filling them out. Training on the records in several areas was not effective as a variety of errors persisted.

The monitoring on some CCP records did not match the critical limits to be measured in the manner that the HACCP plan was written.

Verification procedures were not complete for some CCPs.

Descriptions of deficiencies, corrective actions and preventive measures were insufficient to adequately identify situations and the following actions. **FSEP Manual, Chapter 2, Sections 4.6.2 and 4.8.5**

20/51. Corrective actions were not completely addressed for some CCPs in the HACCP plans. **FSEP Manual, Chapter 2, Section 4.8.3**

43. Ice that was ready for use in product contained several spots of a black oily substance. No product was affected. **MOP 28.(1)(n)**

45/51. Metal detectors are not Critical Control Points in this establishment; however, when the probes were run through to determine if the instruments were functioning properly, this was not recorded. Therefore, there was no way to determine by records if the detectors were functioning correctly. **FSEP Manual, Chapter 2, Sections 4.6.2, 4.8.2, 4.8.5**

46/51. An area in the warehouse surrounding a side door had litter, dirt and a cigarette butt present on the floor.

An area in packaging had several pieces of wire end on the floor left over from maintenance activities.

Scissors, knives, steels, and hooks were found stored on a variety of surfaces throughout the establishment.

In many areas of the establishment, there were electrical and other purpose cords resting on the floor.

Several areas were highly congested causing employees to frequently have their frocks or aprons come in contact with both trash containers and inedible containers. (Those containers marked inedible in the ham boning area actually contain edible product that has not yet been declared inedible so the containers will be changed.) At the exit of the sausage vacuum packaging machine there was not a designated place for the operator to put packages in which the vacuum process was not effective.

MIR 34 (Sanitation Requirements), 56.(2) (Hygienic Practices), MOP 2.7.3 (Cords, Hoses)

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Rori K. Craver, DVM	

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
Summer Fresh Salads Incorporated 181 Sharer Road Vaughan Ontario L4L 8Z3	04-27-06	0552	Canada
	5. NAME OF AUDITOR(S) Dr. Alam Khan		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	O
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	
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

Est.#: 552
City and Country: Vaughn Canada
Date: 04/27/2006

22/51 a) Records for corrective action for a deviation from the critical limit at CCP4 did not address the measures to prevent recurrence of the deviation.
b) Verification activities on numerous occasions were either not performed or responsible officials had failed to initial the record at the time of verification at CCP 4. [CFIA Reference: FSEP Implementation Manual Volume II, Chapter 4, Section 4.10, 4.12 Volume III, Chapter 5, Section 5.11 and 5.13, Volume IV, Chapter 1, Section 1.4]

39/51 A pool of stagnant water next to a garbage dumpster at the receiving dock was creating insanitary conditions and had the potential for attracting vermin and insects in the plant. [MOP 2.5]

45/51 a) The parts around a rubber filler tubing connected to the main assembly of an automatic filler/pump machine in the product packaging room had collected dirt, rust and greasy substances on them. The filler tube provides a conduit for raw product to reach other parts of the pump before packaging. The CFIA officials rejected the equipment. [CFIA Meat Inspection Regulation § 28 and CFIA Meat Inspection Manual Chapter 2.7.4 MOP 3.9]
b) The terminal portion of a shrink wrap tunnel in the product packaging room had a build-up of dirt, rust, and unidentifiable extraneous material. [CFIA Meat Inspection Regulation § 28 and CFIA Meat Inspection Manual Chapter 2.7.4 MOP 3.9]
c) An extensively corroded roller from a scale was stored with the other parts and equipment that was ready to be re-assembled for use. The establishment discarded the roller. [CFIA Meat Inspection Regulation § 28 and CFIA Meat Inspection Manual Chapter 2.7.4 MOP 3.9]
d) The exhaust cylinders for the kitchen's twin fryers were extensively rusted, and the overhead hood had areas of dirt and grease build-up. The CFIA official leading the audit rejected the equipment which was ready to use at the time of audit. [CFIA Meat Inspection Regulation § 28 and CFIA Meat Inspection Manual Chapter 2.7.4 MOP 3.9]

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan DVM	

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
Tender Choice Foods Incorporated 4480 Paletta Court Burlington Ontario L7L 5R2	05-11-06	0275	Canada
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	Dr. Alam 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
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.	
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	
37. Import	
38. Establishment Grounds and Pest Control	
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	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.	

60. Observation of the Establishment

Est.#: 275
City and Country: Burlington, Canada
Date: 05/11/2006

13/15 The daily record of SSOP did not include the preventive measures in the corrective action plans. [FSEP Vol. 3, 5.12, 5.11 & 5.13]

39/51 a) Above the rim of an open hopper, containing separated turkey product, and a 1/4" steel elbow connecting water lines was extremely corroded and created the potential for rust falling into the product. [MOP 2.5.9]

b) Poor drainage on the floor in several places in the establishment had caused water pooling. In the processing room for mechanically separated product, the standing water mixed with product residue was creating insanitary conditions. [MOP 2.5.9]

41/51 Inadequate ventilation allowed water to accumulate in several electrical fixtures in the "Whizzard" room. The interior of the fixtures presented an un-cleaned appearance. According to the establishment's sanitation record the electrical fixtures required maintenance every 30 days. [CFIA Reference: FSEP Implementation Manual Volume II, Chapter 3, Section 3.3.2]

45/51 a) A steel utility ladder placed next to a mechanical meat separator was corroded and dirty.
b) A stainless steel trident, used for handling edible product, was being stored with the product contact surface resting on the floor.
c) An open combo bin of edible turkey fat was being stored next to rolled up door used for refuse disposal and adjacent to waste filled refuse containers. [Meat Inspection Regulations, Chapter 2 and §28 and Manual of Procedures §2.7.4]

46/51 a) Accumulations of debris, wood fragments, and deteriorated concrete were observed in the corners of both productions and non-productions rooms through out the plant.
b) A roll of clear plastic combo bin liners was contacting a contaminated surface of the wheel and spool supporting the roll of liners.
c) The plastic case of a wall-mounted digital control box for a mechanical separator was discolored, smudged, and broken.
d) Pieces of cardboard, wood chips and a dust covered door mat were observed in a corner of the in-house laboratory.
[CFIA Reference: FSEP Implementation Manual Volume IV, Chapter 1, Section 1.4, Volume II, Chapter 3, Appendix II- Prerequisite Programs Review Worksheet, Prerequisite Program (D) and CFIA Meat Hygiene Manual of Procedures, Chapter 3, Section 3.3.]

The establishment took immediate corrective actions for most of the findings, for findings which were not corrected immediately the CFIA sought an action plan and completion date from the establishment.

This establishment had received NOID at the last audit. All the deficiencies identified in the report were corrected.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan DVM	

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
VLR Food Corporation 2525 Highway #56 Binbrook Ontario L0R 1C0	05-09-06	0293	Canada
	5. NAME OF AUDITOR(S) Dr. Alam Khan		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.	
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	
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	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

Est.#: 293
City and Country: Binbrook, Canada
Date: 05/9/2006

13/51 The daily records documenting corrective actions for pre-operational and operational sanitation deviations did not include preventive measures and when necessary, action taken for disposition of non-compliant product. [FSEP Vol. 3, 5.12, 5.11 & 5.13]

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan DVM	

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
Cappola Food Incorporated 25 Lepage Court Toronto Ontario M3J 3M3	05-04-06	0327	Canada
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	Dr. Alam 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
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	
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	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.	

60. Observation of the Establishment

Est.#: 327
City and Country: Toronto Canada
Date: 05/4/2006

45/51 a) The motors on each side of a spice mixer-blender machine had readily peeling paint and underlying rust present. The machine was tagged for maintenance work by the establishment. [MOP 3.9.3]

b) A plastic bushing supporting a metal rod on the pre-cut machine had visible wear and tear present, allowing dirt and grease to build-up in the void between metal rod and bushing. [MOP 3.9.3]

c) Residues of meat and fat from the previous day's production were observed adhered to the backside of a scabbard hanging on the salami stuffing machine. The observation was made during the pre-operational verification check. The scabbard was discarded by the establishment. [MOP 3.9.3]

d) During pre-operational sanitation verification check pieces of meat and fat residues were observed on the inside of a metal shroud bolted to the stuffing machine. The establishment ordered the cleaning crew to re-wash and sanitize the machine immediately. [MOP 3.9.3]

46/51 Empty cardboard boxes, loose shrink wrap, open bags of water softener, open styro-foam coolers and other miscellaneous articles were stored inappropriately in the south east corner of the dry storage room. The deficiency was corrected immediately. [CFIA Reference: FSEP Implementation Manual Volume IV, Chapter 1, Section 1.4, Volume II, Chapter 3, Appendix II- Prerequisite Programs Review Worksheet, Prerequisite Program (D) and CFIA Meat Hygiene Manual of Procedures, Chapter 3, Section 3.3.]

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan DVM	

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 Ontario M9W 5X3	05-03-06	0340	Canada
	5. NAME OF AUDITOR(S) Dr. Alam Khan		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.	
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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.	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.	
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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.	
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	
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.	

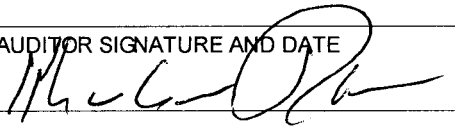
60. Observation of the Establishment

Est.#: 340
City and Country: Toronto Canada
Date: 05/3/2006

21/51 The establishment's HACCP plan did not include in the flow diagram, or have a hazard analysis conducted for Rework product. The establishment, however, maintains a log for products that require reworking. [CFIA Regulatory Reference, FSEP Form 3]

45/51 In the packaging room a double tiered wire rack had multiple rust spots due to neglected maintenance and cleaning of the rack. The rack is used for storing packaged material. The rack was removed form the packaging room. [CFIA, FSEP reference, C 1.1]

46/51 a) Meat and fat residue of varying sizes from previous batches of products were found in two corners of holding cooler # 6, edible product was stored in the cooler at the time of observation. Holding Coolers are cleaned between the batches of salami product.
b) In the salami washing room the following observations were made:
1) A hole measuring 1" in diameter was observed in the wall facing the washing cabinet
2) An opening in the ceilings for electrical cable was not sealed.
3) Poor drainage in the room had allowed water to pool around a drain creating insanitary conditions in the room.
4) A piece of sheet metal separating the left wall of the room and left wall of the wash cabinet was dirty and covered with a thin film of fatty residue.
5) Multiple pieces of small metal equipment were stored in a dark alley between the back of the washing cabinet and the back wall of the washing room creating insanitary conditions in the room. The room was rejected and product was retained by CFIA official leading the audit.
[CFIA Regulatory Reference, FSEP reference, E 1.1]

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan DVM	

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
Marsan Foods Limited 46 Modern Road Toronto Ontario M1R 3B6	05-01-06	0424A	Canada
	5. NAME OF AUDITOR(S) Dr. Alam Khan		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	
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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	
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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.	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	
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

Est.#: 0424A
City and Country: Toronto Canada
Date: 05/1/2006

22/51 The Canadian Food Inspection Agency requires establishments engaging in producing RTE products to validate its chilling phase. The establishment had a validated procedure and an established monitoring frequency to ensure that the product is chilled to 80 °F in 2 hours, however, documents supporting the subsequent step in the chilling cycle and any associated monitoring records for the CCP were not presented for review. [FSEP Vol, 3,5.11]

46/51 a) The non-cutting surface of a cutting board and the surface of the supporting frame had a thin layer of dirt, grease and discoloration.
b) Food residues from the previous day's production were observed on a rack of trays used for packaged food products. [MOP 3.9.3]

Appropriate corrective actions were initiated by the CFIA officials who participated in the audit.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan DVM	

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 10 Armthorpe Road Bramton Ontario L6T 5M4	04-28-06	0473A	Canada
	5. NAME OF AUDITOR(S) Dr. Alam Khan		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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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	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	
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	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

Est.#: 0473A
City and Country: Bramton Canada
Date: 04/28/2006

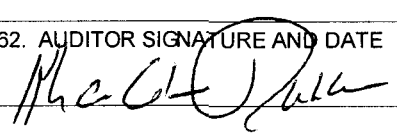
19/51 a) The process controls applied at the leaf lard receiving step was stated as the letter(s) of guarantee from the supplier. No letter(s) of guarantee was presented to the FSIS auditor for review at the time of audit. [FSEP PreReq. Prog. C1.2]
b) The establishment's HACCP plan did not include in the flow diagram, or have a hazard analysis conducted for application of hyperbaric pressure to the product. The establishment maintained the manufacture data on effective and safe use of high pressure in food preparation environment. [CFIA FSEP Vol.3, 5.12]

22/51 The critical limit for packaging at CCP 1B was selected to be a concentration of $O_2 \leq 0.5\%$, however, the documents presented for review did not support the selection of this critical limit. [FSEP Vol. 3, 5.8]

39/51 a) Cracks and deteriorating concrete were observed around the door jamb and on the floor leading to one of the exits in the finished ham boning room.
b) A shallow crack approximately 2 feet long was observed at the wall-floor junction near the door in the spice room. [CFIA Meat Inspection Regulations, §28]

46/51 No waste receptacle was present in the spice room and an empty plastic spice bag was thrown on the floor near the work station in the spice room. [MIR 34. (1), MOP (3.9)]

All the findings were either corrected on the same day or CFIA officials indicated they would initiate a plan of actions to ensure that the establishment complies with all appropriate CFIA regulations.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan DVM	

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
Les Aliments Olivieri Limited 80 Brockley Drive Hamilton Ontario L8E 3C5	05-10-06	557A	Canada
	5. NAME OF AUDITOR(S) Dr. Alam Khan		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.	
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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	
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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	X
40. Light	
41. Ventilation	
42. Plumbing and Sewage	
43. Water Supply	
44. Dressing Rooms/Lavatories	X
45. Equipment and Utensils	X
46. Sanitary Operations	X
47. Employee Hygiene	
48. Condemned Product Control	X
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. NOID	X
59.	

60. Observation of the Establishment

Est.#: 557A
City and Country: Hamilton Canada
Date: 05/10/2006

10/51 a) A soiled plastic bag was re-used to cover the mouth of a vessel attached to machine containing pulverized garlic.
b) The re-circulated water was used for chilling packaged product but the frequency of renewing it with the fresh water was not addressed in HACCP, SSOP, or pre-requisite program.
c) The sanitation or any other program did not include Clean in Place for equipments such as conduits, pipes etc. [FSEP Vol. 4, 2.5; Pre- Req. Prog. E1.1.1; MOP 2.5.9.2]

13/51 The SSOP monitoring records were not signed or initialed on daily basis; however, they were signed at the end of the week. [MOP 3.3.4]

39/51 The refrigerated product room door that opens upwards had missing weather strip at its bottom leaving gaps when fully closed. The accumulation of debris was found in the torn rubber flaps and broken bumpers of the receiving dock. [MOP 2.5.9]

44 The hairnets, wired coat hangers and soda cans were found on floor in the men's welfare room. Also, a clogged toilet was creating a foul odor but had "Not to Use Sign" displayed on the door.

45/51 a) The accumulation of debris from dough, grease from cartons and extraneous particles was observed: on the numerous non food contact surfaces; on the parts of two metal detector lines and packaging assembly lines.
b) Accumulation of debris and extraneous material was found on a flat steel plate which was supporting the motor for driving labeling lids. The steel plate was placed directly over the exposed product on the conveyor belt,
c) A rusty valve handle and loose insulation around copper tubing was observed on a post adjacent to the packaging machine.
d) A pipe in the pasteurization machine was covered with duct tape.
e) The cracks and rough welding were observed in some stainless bins
f) Accumulation of debris and unidentified particles were observed on the tools and the caddy, attached to the wall, in the product mixing room. [MOP 3.9.3}

46/51 a) Rust and brownish unidentified thick pasty material was observed around and under the periphery of water fountain in the production room.
b) The gray and white coats were commingled and were not kept separate to prevent cross contamination between ready-to-eat (RTE) and raw product areas during the break. These coats were touching the water hose and one white coat was soiled and stained.
c) A steel panel from machinery was stored on the floor in the production room.
d) Few unidentified insects were found in two empty containers, ready to use for re-work product.
e) Plastic sheets used to cover clean equipment were stored on the steps of a utility steel ladder.
f) Product residue was found in some bins, ready to use, in the processing room.
g) The barrels of chemicals were stored in close proximity to a pool of water in the chemical room. [MOP 4.5.1, 4.5.1(h), Chapter 4 Annex N]

48/51 Inedible product in twenty bins and two barrels was not denatured and was left outside the establishment for pick up. [CFIA regulatory reference will be furnished later]

The Canadian Food Safety Inspection officials issued a Notice of Intend to Delist (NOID) as result of the audit finding on May 10, 2006.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan DVM	

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
Les Aliments Tiffany Gate Foods Incorporated 195 Steinway Boulevard Toronto Ontario M9W 6H6	04-26-06	0600	Canada
	5. NAME OF AUDITOR(S)		6. TYPE OF AUDIT
	Dr. Alam 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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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	
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	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

Est.#: 600
City and Country: Toronto, Canada
Date: 04/26/2004

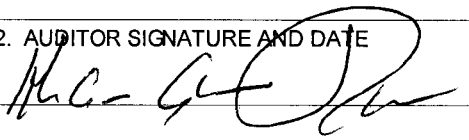
22/51 The HACCP records documenting the establishments corrective action plan for deviations from a critical limit at CCP 4 had not included the preventive measures. [CFIA Regulatory reference, FSEP Volume 3, 5.11]

39/51 a) The wall under a hand wash sink in the Kitchen where Ready to Eat product was being prepared had an area of detached plaster measuring approximately 5"x 5"x 1". The CFIA official leading the audit ordered prompt correction. [CFIA Regulatory reference, Meat Inspection Regulations (MIR), § 28]

45/51 In the fresh product cooling room, numerous steel trays with racks of finished product on them, had varying degree of black discoloration from repeated use without thorough cleaning. One empty tray with a thin layer of black soot like material on one of its corner was stacked with other trays containing finished product. [CFIA Regulatory reference: MIR § 28/29 MOP 3.10, FSEP Pre-Req. Pro E 2.1]

46/51 a) An open jar of unidentified sauce with its contents smearing the mouth, neck, and the body of the container was observed stored in a plastic bucket in the fresh product cooling room.
b) Extensive dampness was observed in the dry goods store room. Bulk dextrose bags on one pallet were damp and their contents had the potential for moisture absorption through hygroscopic action.
c) Avulsed insulation was observed on an exposed elbow joint of PVC pipe in the Salad/Vegetable Preassembly Room.
d) Two containers of sanitizers were observed on the floor in the vegetable washing room where exposed vegetables were being washed.
e) A small pool of muddy water was observed around a pallet of raw vegetables. These vegetables were to be used with RTE products.
[The relevant CFIA regulatory references: FSEP implementation manual volume IV, Chapter 1, Section 1.4, Volume II, Chapter 3, Appendix II-Prerequisite Program (D) Personnel (D1) and Meat Hygiene Manual of Procedures, Chapter 3, Section 3.3]

All the deficiencies were promptly corrected before the audit was over.

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan DVM	

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
Zadi Foods Limited 65 Deerhurst Drive Brampton Ontario L6T 5R7	05-08-06	0665	Canada
	5. NAME OF AUDITOR(S) Dr. Alam Khan		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.	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	
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	
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	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

Est.#: 665
City and Country: Bramton, Canada
Date: 05/8/2006

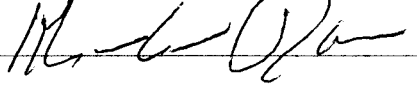
19/51 There were no decision-making documents available supporting the use of the range of ± 2.5 C° for thermometer calibration as stated in the establishment's written plan. [FSEP PreReq. Prog. C 1.2.2]

38 Dirt covered meat and fat residues were observed on the ground outside the receiving dock, creating insanitary conditions and a potential attractant for rodents. [MIR 29(20(B)(iii), MOP 3.10, PreReq. Prog. E2.1]

39/51 a) Unused machinery, equipment, utensils, and other miscellaneous debris was present on a mezzanine that opened directly into the packaging material room. This area posed a potential source of contamination for the stored packaging material for edible product.
b) Dirt and grease build-up was observed on the inner surface of a light fixture in the tumbler room.
c) Detached plaster was observed in the product washing room at the wall-floor junction, along the entire length of one wall. [CFIA Meat Inspection Regulations §28]

45/51 a) An employee's protective steel apron with heavily rusted buckles was observed laying on the processing table. [MOP3.9.3]
b) The inner plastic fringes around the tumbler opening had unidentified black residues present on their surfaces. The same fringes were also rough, irregular and discolored. The tumbler was ready to use. [MOP 3.9.3]
c) Multiple steel hooks used to hang netted encased salami in the coolers were corroded and had dirt and grease from previous uses present on them. An operator was observed picking up a hook and using it to hang salami. [MOP 3.9.3]

46/51 a) In one of the salami drying room, a used clear plastic refused bag was tied up to an electrical Switch box.
b) In the same room a steel post was observed with readily peeling paint.
c) In the product cooling room an encased salami product was observed touching the wall
c) In the tumbler room the steel panels from the tumbler were leaning against a wall and resting on the floor forming an area which collected debris.
[MIR 34(1), MOP 3.9.3]

61. NAME OF AUDITOR	62. AUDITOR SIGNATURE AND DATE
Alam Khan DVM	

Canadian Food Inspection Agency
Agence canadienne d'inspection des aliments

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SEP 2 2 2006

Ms. Sally White
Director
International Equivalence Staff
Office of International Affaires
Food Safety and Inspection Service
United States Department of Agriculture
Washington, D.C. 20250
United States of America

Dear Ms. White:

Thank you for your letter of June 28, 2006 to Dr. William Anderson, Director, Food of Animal Origin Division (FAOD), Canadian Food Inspection Agency (CFIA) and the accompanying copy of the Draft Final Report of an enforcement audit covering Canada's meat and poultry inspection system, carried out during the period of April 25 to May 23, 2006 and the opportunity to provide comments on the report.

Foreign audit reports are generally welcomed as an additional source of information for the CFIA to assess the performance of Canada's meat inspection system and to contribute to our objective for continuous improvement.

With respect to the establishment which received a "30 Day Notice of Intent to Delist", in your letter of July 7, 2006 you have acknowledged receipt of our letter of verification that corrective actions had been taken within the prescribed time frame.

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

The following are our comments and action being taken with respect to sections 6.1.1, 6.1.4 and 11.4, under the headings of Government Oversight, Adequate Administrative and Technical Support to laboratories and Testing of Ready to Eat Products:

1. The current procedure of distribution of sampling and laboratory methodologies protocol and any amendments to the protocol, generated and distributed by the Food Microbiology and Chemistry Evaluation Division of CFIA has been amended to include all private accredited laboratories involved in the programs, in the distribution.

.../2

2. At the time of distribution of the protocol and it's amendments a new form will be included. Managements of the private laboratories will be required to confirm, by the use of the form, receipt of the communication and testify to their agreement and implementation of any requirements stipulated in the protocol and any amendments. Duly filled in forms will be returned to the Food Microbiology and Chemistry Evaluation Division of CFIA.

3. The Food Microbiology and Chemistry Evaluation Division staff will verify that the forms are received from all private labs. The forms will be retained on file for records and auditing purposes.

4. The amended procedure has now been implemented.

With respect to the observations made under the heading of Sanitation Controls as well as Slaughter/Processing Controls, I wish to assure you that all are being addressed at plant and regional levels, through the action plans and corrective actions taken by the operators.

I trust that the above summarizes our response to observations outlined in the draft report and will clarify CFIA's position 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. Frédérique Moulin
National Manager
International Programs
Food of Animal Origin Division

c.c.: Robert Charlesbois
Barb Lee
Michael Sole
Rose Medaglia
Eva Pietrak
Jean Kamazi
J. Furych, CFIA