



United States  
Department of  
Agriculture

Food Safety  
and Inspection  
Service

Washington, D.C.  
20250

*Don*

JUL 10 2006

Q.F.B. Amada Vélez Méndez  
Directora General de Inocuidad Agroalimentaria,  
Acuícola y Pesquera  
Servicio Nacional de Sanidad, Inocuidad y  
Calidad Agroalimentaria (SENASICA)  
Secretaría de Agricultura, Ganadería, Desarrollo  
Rural, Pesca y Alimentación (SAGARPA)  
Guillermo. Pérez Valenzuela No. 127, piso 2  
Col. Del Carmen, Coyoacán  
C.P. 04100, México D.F.

Dear Ms. Vélez:

The Food Safety and Inspection Service (FSIS) conducted an on-site audit of Mexico's meat and processed poultry inspection system November 8 through November 22, 2005. Enclosed is a copy of the final audit report. We did not receive any comments from the government of Mexico regarding the draft final audit report.

If you have any questions regarding the 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](mailto:sally.white@fsis.usda.gov).

Sincerely,

*Steven McDonald*  
*for*

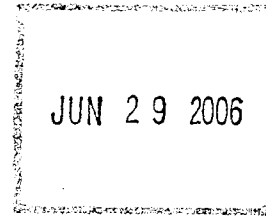
Sally White  
Director  
International Equivalence Staff  
Office of International Affairs

Enclosure

Cc:

Suzanne Heinen, Minister-Counselor, American Embassy, Mexico City  
Enrique Lobo, Agricultural Minister, Embassy of Mexico, Washington, DC  
Robert Macke, Assistant Deputy Administrator, ITP, FAS  
Jeanne Bailey, FAS Area Director  
Amy Winton, State Department  
Barbara Masters, Administrator, FSIS  
Linda Swacina, Executive Director, FSIA, OIA  
Karen Stuck, Assistant Administrator, OIA, FSIS  
William James, Deputy Assistant Administrator, OIA, FSIS  
Donald Smart, Director, Review Staff, OPEER, FSIS  
Sally White, Director, IES, OIA, FSIS  
Clark Danford, Director, IEPS, OIA, FSIS  
Mary Stanley, Director, IID, OIA, FSIS  
Andreas Keller, IES, OIA, FSIS  
Steve McDermott, IES, OIA, FSIS  
Country File (Mexico)

**FINAL**



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

November 8 through November 22, 2005

Food Safety and Inspection Service  
United States Department of Agriculture

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## ABBREVIATIONS AND SPECIAL TERMS USED IN THE REPORT

BSE	Bovine Spongiform Encephalopathy
CCA	Central Competent Authority [Servicio Nacional de Sanidad Inocuidad y Calidad Agroalimentaria (SENASICA)]
CFR	U.S. Code of Federal Regulations
CVO	Chief Veterinary Officer
<i>E. coli</i>	<i>Escherichia coli</i>
FSIS	Food Safety and Inspection Service
MVZ	Medical Veterinarian and Animal Protection (Medico Veterinario Zootecnista)
NOID	Notice of Intent to Delist
PR/HACCP	Pathogen Reduction/Hazard Analysis and Critical Control Point System
RTE	Ready to Eat
SAGARPA	Secretary for Agriculture, Livestock, Rural Development, Fisheries and Food (Secretaria de Agricultura, Ganaderia, Desarrollo Rural, Pesca Y Alimentación)
<i>Salmonella</i>	<i>Salmonella</i> species
SENASICA	National Service for Animal Health, Food Safety, and Agricultural and Food Quality Assurance (Servicio Nacional de Sanidad Inocuidad y Calidad Agroalimentaria)
SSOP	Sanitation Standard Operating Procedures
TIF	Federal Inspection Type (Tipo Inspeccion Federal)

## 1. INTRODUCTION

The audit took place in the Republic of Mexico from November 8 through November 22, 2005.

An opening meeting was held on November 8, 2005, in Mexico City with the Central Competent Authority (CCA). At this meeting, the auditor confirmed the objective and scope of the audit, the auditor's itinerary, and requested additional information needed to complete the audit of Mexico's meat and processed poultry inspection system.

The auditor was accompanied during the entire audit by representatives from the CCA, Servicio Nacional de Sanidad Inocuidad y Calidad Agroalimentaria (SENASICA) and/or representatives from the SENASICA state inspection offices.

## 2. OBJECTIVE OF THE AUDIT

This audit was a routine annual audit. The objective of the audit was to evaluate 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 processed poultry products to the United States.

In pursuit of the objective, the following sites were visited: the Central office and five meat and/or poultry processing establishments.

Competent Authority Visits			Comments
Competent Authority	Central	1	Mexico City
	State	0	
Laboratories		0	
Meat Slaughter Establishments		2	
Meat/Poultry Processing Establishments		3	Establishments producing beef, pork and/or poultry products.

## 3. PROTOCOL

This on-site audit was conducted in three parts. One part involved visits with CCA officials to discuss oversight programs and practices, including enforcement activities. The second part involved an audit of a selection of records in the country's inspection headquarters and regional offices. The third part involved on-site visits to five meat slaughter and/or processing establishments.

Program effectiveness determinations of Mexico's inspection system focused on five areas of risk: (1) sanitation controls, including the implementation and operation of Sanitation Standard Operating Procedures (SSOP), (2) animal disease controls, (3) slaughter/processing controls, including the implementation and operation of Hazard

Analysis Critical Control Point (HACCP) programs and a testing program for generic *E. coli*, (4) residue controls, and (5) enforcement controls, including a testing program for *Salmonella* species. Mexico's inspection system was assessed by evaluating these five risk areas.

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

At the opening meeting, the auditor explained that Mexico's meat inspection system would be audited against two standards: (1) FSIS regulatory requirements and (2) any equivalence determinations made for Mexico. FSIS requirements include, among other things, daily inspection in all certified establishments; monthly supervisory visits to certified establishments; humane handling and slaughter of animals; ante-mortem inspection of animals and post-mortem inspection of carcasses and parts; the handling and disposal of inedible and condemned materials; sanitation of facilities and equipment; residue testing; species verification; and requirements for HACCP, SSOP, and testing for generic *E. coli* and *Salmonella*.

Equivalence determinations are those that have been made by FSIS for Mexico under provisions of the Sanitary/Phytosanitary Agreement. Currently, Mexico has an equivalence determination regarding an exemption from performing species verification.

#### 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 Pathogen Reduction/HACCP regulations.

#### 5. SUMMARY OF PREVIOUS AUDITS

Final audit reports are available on FSIS' website at the following address:  
[http://www.fsis.gov/Regulations\\_&\\_Policies/Foreign\\_Audit\\_Reports/index.asp](http://www.fsis.gov/Regulations_&_Policies/Foreign_Audit_Reports/index.asp)

During the June-July 2005 FSIS audit of Mexico's inspection system:

- One establishment received a Notice of Intent to Delist (NOID).
- Inadequate government enforcement was identified in thirteen establishments.
- Five establishments were cited for inadequate sanitation performance standards (SPS).
- Six establishments were cited inadequate implementation of SSOP requirements.

- One establishment was cited for inadequate sampling collection/analysis for generic *E. coli* testing.
- One establishment was cited for inadequate implementation of *Listeria monocytogenese* requirements for Ready to Eat (RTE) products.
- Twelve establishments were cited for inadequate implementation of HACCP requirements.

## 6. MAIN FINDINGS

### 6.1 Government Oversight

SENASICA is responsible for regulating Mexico's meat and processed poultry inspection system and live-animal health requirements. This responsibility includes certifying and regulating TIF establishments for the exportation of meat or processed poultry products to the United States.

The production of meat and poultry products in Mexico is conducted either in TIF establishments or in municipal establishments. SENASICA has authority only over TIF establishments, whereas Mexico's Department of Health has authority also over municipal establishments. The majority of the meat and poultry production in Mexico is conducted in TIF establishments. Only TIF establishments have the authority to produce product for export to other countries.

#### 6.1.1 CCA Control Systems

The auditor conducted a review of inspection system documents that included the following:

- Internal review reports.
- Supervisory visits to establishments that were certified to export to the United States.
- Training records for inspectors and laboratory personnel.
- New laws and implementation documents such as regulations, notices, directives and guidelines.
- Sampling and laboratory analyses for residues.
- Sanitation, slaughter and processing inspection procedures and standards.
- Export product inspection and control including export certificates.

No concerns arose as a result of examination of these documents.

#### 6.1.2 Ultimate Control and Supervision

Each TIF establishment is under the direct authority of a SAGARPA state office. Each state office has at least one SENASICA state supervisor who is assigned to provide government oversight of all TIF establishments within the state and to assure that inspection requirements are being enforced at the TIF establishments. Based on the size of the state and/or the number of TIF establishments, SENASICA may assign two or more state supervisors. In addition, SENASICA has assigned a MVZ supervisor to each



TIF establishment certified to export meat or processed poultry to the United States. Additional MVZ inspection officials are assigned to certified establishments to carry out government inspection responsibilities. Daily inspection by inspection officials is being carried out in all TIF establishments certified to export to the United States.

SENASICA has adequate levels of authority (headquarters, state offices, and certified establishments) to ensure effective oversight of all U.S. import inspection requirements.

### 6.1.3 Assignment of Competent, Qualified Inspectors

Upon entering government employment as official inspectors, new employees undergo induction training as well as participate in on-the-job practical training under the supervision of experienced veterinarians. Training is supplemented by refresher courses on inspection requirements and participation in U.S. government technical assistance programs. Audit findings indicate that Mexico needs to continue training its inspection personnel to maintain competency regarding the FSIS inspection requirements.

### 6.1.4 Authority and Responsibility to Enforce the Laws

SENASICA has the authority and responsibility to enforce the applicable laws relevant to establishments producing product for export to the United States.

### 6.1.5 Adequate Administrative and Technical Support

During the audit, the audit team found that SENASICA has administrative and technical support to operate Mexico's inspection system and has the ability to support a third-party audit.

## 6.2 Headquarters Audit

The auditor conducted a review of inspection system documents that included the following:

- Supervisory visits to certified establishments that export to the United States
- Sampling and analyses for residues and water supply
- Pathogen reduction and other food safety initiatives such as SSOP and HACCP programs, generic *E. coli*, *Salmonella* species, and *Listeria monocytogenes* testing
- Sanitation, slaughter and processing inspection procedures and standards
- Control of products from livestock with conditions such as tuberculosis, cysticercosis, etc., and inedible and condemned materials
- Export product inspection and control, including export certificates

## 7. ESTABLISHMENT AUDITS

The FSIS auditor visited a total of five establishments (two slaughter and processing establishments and three processing establishments). None of the establishments was delisted and none received NOID from Mexico's CCA.

## 8. RESIDUE AND MICROBIOLOGY LABORATORY AUDITS

No laboratories conducting residue and microbiological testing were reviewed.

## 9. SANITATION CONTROLS

As stated earlier, the FSIS auditor focuses on five areas of risk to assess Mexico's meat inspection system. The first of these risk areas that the FSIS auditor reviewed was Sanitation Controls.

Based on the on-site audits of establishments, and except as noted below, Mexico'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, and except as noted below, Mexico's inspection system had controls in place for water potability records, chlorination procedures, back-siphonage prevention, separation of operations, temperature control, work space, 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. In one of the five establishments audited, implementation of SSOP requirements was inadequate.

- A plastic yellow basket was stored on the floor under a boning table, had edible and/or rework product; the edible product was observed touching the electrical cord running right above the yellow basket, {9CFR 416.13}.

### 9.2 Other Sanitation Concerns

- In one establishment, a hole measuring approximately 3"x3"x3", stuffed with used napkins and debris was observed in a post at the entrance to the cooking room.
- In one establishment, beaded condensation was falling onto the racks ready to store packaged boxes, and a steady dripping of water from an overhead rubber hose was falling in a passageway. Some ready to use utensils were stored in close proximity of the leakage in the passageway. The plant employees use both areas to access other production areas.
- In one of five establishments, an un-cleaned air filter was observed hanging from a vent inside the storing facility for material used in smoking of meat product.

- In one establishment, stacks of folded cartons for meat packaging were stored in an insanitary manner on a pallet. The cartons were damp and covered with a thin layer of dust.
- In one establishment, a stainless steel bowl, which had a wide crack at the bottom, and a metal guard cone from a grinding machine with torn and cracked plastic strips attached to the base of the cone were observed during pre-operational inspection.
- In one establishment, the establishment did not have a written sanitation program for the ice storage room. The FSIS auditor observed a plant employee entering the ice storage room and standing on a pile of ice cubes to fill containers of ice. The employee did not change work boots or clothing. Plant management stated that the ice was being used for Mexico's domestic market.

## 10. ANIMAL DISEASE CONTROLS

The second of the five risk areas that the FSIS auditor reviewed was Animal Disease Controls. These controls include ensuring adequate animal identification, humane handling and humane slaughter, control over condemned and restricted product, and procedures for sanitary handling of returned and reconditioned product.

There had been no outbreaks of animal diseases with public health significance since the last FSIS audit.

## 11. SLAUGHTER/PROCESSING CONTROLS

The third of the five risk areas that the FSIS auditor reviewed was Slaughter/Processing Controls. The controls include the following areas: ante-mortem inspection procedures; ante-mortem disposition; 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.

The controls also include the implementation of HACCP systems in all establishments, implementation of a testing program for generic *E. coli* in slaughter establishments and for *Listeria monocytogenes* in establishments producing ready to eat products, and implementation of the Bovine Spongiform Encephalopathy (BSE) control measures.

- One establishment did not conduct a hazard analysis of its HACCP, SSOP, or another prerequisite program to determine that if BSE was a hazard reasonably likely to occur. The hazard analysis should have included the following:
  - Segregation of animals of less than 30 months of age and 30 months of age and greater. This establishment was slaughtering cattle of both age categories.

- The removal of the intestine for domestic market and procedures to assure segregation of small intestine from product eligible for the U.S. market.
- The transfer of some carcasses with SRM to certified establishment TIF 300 where the removal process would occur.

### 11.1 Humane Handling and Slaughter

No deficiencies were identified.

### 11.2 HACCP Implementation

All establishments approved to export meat 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 five establishments. Of these, there was inadequate implementation of some of the HACCP requirements in two establishments:

- In one establishment, the HACCP plan did not include the frequency of verification for the calibration of thermometers
- In one establishment, on multiple occasions the direct observation of HACCP verification activities was not performed with the frequency stated in the HACCP plan by the responsible plant official
- In one establishment, the HACCP plan did not include the following steps in the flow diagram, or in hazard analysis for the following steps:
  - Receiving of non-meat material
  - Rework product
  - Returned product

### 11.3 Testing for Generic *E. coli*

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

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

- One establishment did not maintain accurate records of the generic *E. coli* test results, in terms of CFU/cm<sup>2</sup>, and had not developed a statistical process control method to evaluate the *E. coli* test results.

#### 11.4 Testing for *Listeria monocytogenes*

Two of the establishments audited were producing ready-to-eat products for export to the United States. In accordance with United States requirements, the HACCP plans in these establishments had been reassessed to include *Listeria monocytogenes* as a hazard reasonably likely to occur.

### 12. RESIDUE CONTROLS

The fourth of the five risk areas that the FSIS auditor 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 deficiencies were noted.

### 13. ENFORCEMENT CONTROLS

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

- In one establishment visited, the inspector at the viscera inspection station did not palpate the rumeno-reticular junction of the stomach of one carcass.

#### 13.1 Daily Inspection in Establishments

Inspection was being conducted and documented daily in all processing establishments audited.

#### 13.2 Testing for *Salmonella*

No deficiencies were identified.

#### 13.3 Species Verification

FSIS had previously granted Mexico an exemption from conducting species verification testing. The FSIS auditor verified that adequate controls were in place to assure clear separation of meat products of different species.

#### 13.4 Monthly Reviews

During this audit, it was found that in all five establishments, monthly supervisory reviews were being performed and documented as required.

### 13.5 Inspection System Controls

SENASICA had controls in place for restricted product, inspection samples, 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 from eligible third countries and certified establishments within those countries, and the importation of only eligible meat products from other countries for further processing.

Lastly, except as noted below, adequate controls were found to be in place for security items, products entering the establishments from outside sources, and shipment security:

- Government officials did provide adequate oversight, integrity, or security or ensure sample integrity when shipping samples to the laboratory.

### 14. CLOSING MEETING

A closing meeting was held on November 22, 2005, in Mexico City with the CCA. At this meeting, the primary findings and conclusions from the audit were presented by the auditor.

The CCA understood and accepted the findings.

Dr. Alam Khan  
Senior Program Auditor



## 15. ATTACHMENTS

Individual Foreign Establishment Audit Forms

Foreign Country Response to Draft Final Audit Report *(no comments received)*

## Foreign Establishment Audit Checklist

<b>1. ESTABLISHMENT NAME AND LOCATION</b> American Beef S.A. de C.V. Retorno Pablo Neruda No. 107, Complejo 31136 Chihuahua Chihuahua, Mexico	<b>2. AUDIT DATE</b> 11/18/2005	<b>3. ESTABLISHMENT NO.</b> TIF 154	<b>4. NAME OF COUNTRY</b> Mexico
<b>5. NAME OF AUDITOR(S)</b> Dr. Alam Khan		<b>6. TYPE OF AUDIT</b> <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

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



60. Observation of the Establishment

Est. #: TIF 154 Processing establishment  
City and Country: Chihuahua Mexico  
Date: 11/17- 11/18/2005

45/51 A stainless steel bowl, which had a wide crack at the bottom, and a metal guard cone from a grinding machine with torn and cracked plastic strips attached to the base of the cone were observed during pre-operational inspection, {9CFR 416.6}.

These deficiencies were brought to the attention of the SENASICA official leading the pre-operation audit who rejected the noncompliant articles.

61. NAME OF AUDITOR

Dr. Alam Khan

62. AUDITOR SIGNATURE AND DATE

 11/28/2005

### Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Compania Ganadera Vi-Ba Hermanos, S.A. de C.V. Carretera Antigua A Padilla Santander Jimenez, Tamaulipas Mexico	2. AUDIT DATE 10/24/2005	3. ESTABLISHMENT NO. TIF 299	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Dr. Alam Khan		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

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

80. Observation of the Establishment

Est. #: 299 Slaughter establishment  
 City and Country: Santander Jimenez Mexico  
 Date: 11/14/2005

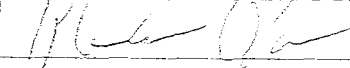
- 15/51 The establishment's HACCP plan did not include the following steps in the flow diagram, or in the hazard analysis for the following steps:
  - 1) Receiving of non-meat materials
  - 2) Rework product and
  - 3) Returned product.
  
- 46/51 The establishment did not have a written sanitation program for the ice storage room. The FSIS auditor observed a plant employee entering the ice storage room and standing on a pile of ice cubes to fill containers of ice. The employee did not change work boots or clothing. Plant management stated that the ice was being used for Mexico's domestic market, {9CFR 416.4}.
  
- 58/51 The establishment had not conducted a hazard analysis of its HACCP, SSOP, or another prerequisite program to determine if BSE was a hazard reasonably likely to occur. The hazard analysis should have included the following:
  - 1. Segregation of animals of less than 30 months of age and 30 months of age and greater. This establishment was slaughtering cattle of both age categories.
  - 2.
  - 3. The removal of the intestine for domestic market and procedures to assure segregation of small intestine from product eligible for the U.S. market.
  - 4. The transfer of some carcasses with SRM to certified establishment TIF 300 where the removal process will occur, {9CFR 417.2 & 310.22(d)}.
  
- 51/55 The inspector at viscera station did not palpate the rumeno-reticular junction of the stomach, {9CFR 310.1(a)}.
  
- 19/51 HACCP plan did not list the frequency of the verification for the calibration of thermometers, {9CFR 417.2(C) (4)}.
  
- 22/51 On multiple occasions the direct observation of HACCP verification activities was not performed by the responsible plant official with the frequency stated in the HACCP plan, {417.4(a) (2) (ii)}.
  
- 29/51 The establishment did not maintain accurate records of the generic *E. coli* test results, in terms of CFU/cm<sup>2</sup>, and statistical process control method to evaluate *E. coli* test result, {9CFR 310.25}.

With the exception of the finding regarding post-mortem examination, no corrective actions were initiated by the establishment personnel, or by the SENASICA official accompanying the FSIS auditor.

61. NAME OF AUDITOR

Dr. Aiam Khan DVM

62. AUDITOR SIGNATURE AND DATE



11/28/2005

United States Department of Agriculture  
Food Safety and Inspection Service

## Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Intercomas S.A. DE C.C. Carretera CD Cuauhtemoc, Km. 7.5 Colonial Las Animas, 31450 Chihuahua, Chihuahua, Mexico	2. AUDIT DATE 10/17/2005	3. ESTABLISHMENT NO. TIF 90	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Dr. Alam Khan		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements	Audit Results	Part D - Continued Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and dated SSOP, by on-site or overall authority.		35. Residue	
<b>Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements</b>		<b>Part E - Other Requirements</b>	
10. implementation of SSOP's, including monitoring of implementation.		36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
12. Corrective action when the SSOP's have failed to prevent direct product contamination or adulteration.		38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	X
<b>Part B - Hazard Analysis and Critical-Control Point (HACCP) Systems - Basic Requirements</b>		40. Light	
14. Developed and implemented a written HACCP plan .		41. Ventilation	X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.	X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
17. The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories	
<b>Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements</b>		45. Equipment and Utensils	
18. Monitoring of HACCP plan.		46. Sanitary Operations	X
19. Verification and validation of HACCP plan.		47. Employee Hygiene	
20. Corrective action written in HACCP plan.		48. Condemned Product Control	
21. Reassessed adequacy of the HACCP plan.		<b>Part F - Inspection Requirements</b>	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.		49. Government Staffing	
<b>Part C - Economic / Wholesomeness</b>		50. Daily inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	X
24. Labeling - Net Weights		52. Humane Handling	
25. General Labeling		53. Animal Identification	
26. Fin. Prod. Standards/Boneless (Defects/AQL/ParK Skins/Moisture)		54. Ante Mortem Inspection	
<b>Part D - Sampling Generic E. coli Testing</b>		55. Post Mortem Inspection	
27. Written Procedures	O	<b>Part G - Other Regulatory Oversight Requirements</b>	
28. Sample Collection/Analysis	O	56. European Community Directives	O
29. Records	O	57. Monthly Review	
<b>Salmonella Performance Standards - Basic Requirements</b>		58.	
30. Corrective Actions	O	59.	
31. Reassessment	O	60.	
32. Written Assurance	O	61.	

80. Observation of the Establishment

Est. #: TIF 90 Processing Establishment  
City and Country: Chihuahua Mexico  
Date: 11/17/2005

- 39/51 A hole measuring approximately 3"x3"x3", stuffed with used napkins and debris was observed in a post at the entrance to the cooking room, {9CFR 416.2(b)}. The deficiency was corrected while audit was in progress.
- 41/51 A unclean air filter was observed hanging from a vent inside a storing facility for material used in smoking of meat product, {9CFR 416.2(d)}. The filter was replaced with a new one before the audit was over.

81.

82.

81. NAME OF AUDITOR  
Dr. Alam Khan DVM

82. AUDITOR SIGNATURE AND DATE

 11/28/2005

### Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION Empacadora La Cabana, S.A. de C.V. Hacienda Vieja la Nopalera S/N, Congregacion Calles Montemorelos, Nuevo Leon, Mexico	2. AUDIT DATE 11/15/2005	3. ESTABLISHMENT NO. TIF 104	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Dr. Alam Khan		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

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

60. Observation of the Establishment:


Est. #: 104 Processing establishment  
City and Country: Montemorelos Mexico  
Date: 11/15/05

There were no significant findings to report after consideration of the nature, degree and extent of all observation.

61. NAME OF AUDITOR

Dr. Alam Khan

62. AUDITOR SIGNATURE AND DATE

 11/28/2005

### Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION KeKen Commercializadora Porcicola Mexicana Km. 3.5 Carret. Uman – Poxila Uman Yucatan, Mexico	2. AUDIT DATE 11/10/2005	3. ESTABLISHMENT NO. TIF 152	4. NAME OF COUNTRY Mexico
5. NAME OF AUDITOR(S) Dr. Alam Khan		6. TYPE OF AUDIT <input checked="" type="checkbox"/> ON-SITE AUDIT <input type="checkbox"/> DOCUMENT AUDIT	

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

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



## 60. Observation of the Establishment

Est. #: TIF 152 Slaughter/Processing Establishment  
City and Country: Uman - Poxila Uman Yucatan, Mexico

Date: 11/10/2005

10/51 A plastic yellow basket was stored on the floor under a boning table had edible and/or rework product; the edible product was observed touching the electrical cord running right above the yellow basket, {9CFR 416.13}.

The lead auditor from SENASICA immediately requested compliance and the establishment complied.

41/51 Beaded condensation was falling onto the racks ready to store packaged boxes, and a steady dripping of water from an overhead rubber hose was falling in a passageway. Some ready to use utensils were stored in close proximity of the leakage in the passageway. The plant employees use both areas to access other production areas, {9CFR 416.2}.

Immediate corrective actions were initiated and completed while the audit was underway.

45/51 Stacks of folded cartons for meat packaging on a pallet were stored in insanitary manner. The cartons were damp and covered with a thin layer of dust, {9CFR 416.3}.

The SENASICA officials leading the audit rejected the pallet and contents thereon.

TOR  
DVM

62. AUDITOR SIGNATURE AND DATE

*[Handwritten Signature]* 11/28/2005

**Country Response Not Received**