



BASIC REQUIREMENTS FOR CUSTOM ESTABLISHMENT

These requirements are in addition to compliance with Facility Sanitation Performance Standards described in Title 9 Code of Federal Regulations 9CFR 416.1 thru 416.6 found below

1. Records and Licensing:

- The establishment must be registered with the State of Maine as a Custom Slaughterhouse and/or Custom Processing Facility.
- The plant operator is responsible for maintaining records of all animals/poultry delivered for slaughter or processing, for two years.
- In the case of *custom slaughter/custom processing* the record can be made to include the name and address of the owner of the animals/poultry, the number and kinds of animals/poultry, the age of the animals in the case of cattle, quantities and types of products processed, that carcasses and meat/poultry product packages will be “NOT FOR SALE”, and that the carcass will have all age appropriate Specified Risk Material removed if present at processing .
- In the case of *custom processing only*, the record can be made to include the name and address of the owner of the carcass, the age of the animal in the case of cattle, quantities and types of products processed, that carcasses and meat/poultry product packages will be “NOT FOR SALE”, and that the carcass will have all age appropriate Specified Risk Material removed if present at processing.
Also, in the case of cattle, the record must include certification by the owner declaring that the animal was not non-ambulatory disabled.

2. Marking and Labeling:

- Red meat – carcass and parts that are prepared on a custom basis shall be marked “NOT FOR SALE” when it leaves the kill floor.
- Each package must be marked “NOT FOR SALE” immediately after being prepared, and kept identified until delivered to the owner.
- The size of the lettering will not be smaller than 3/8 of one inch.
- Poultry – must add a label to the shipping container with the words “NOT FOR SALE”, “Exempted Under P.L. 90-492”, plus the producer’s name and address.

- ### 3. Non-ambulatory disabled cattle (those that cannot walk onto the kill floor) are considered adulterated, are to be condemned, and are not allowed for human consumption whatsoever. This rule applies to Custom Slaughterhouses and Custom Processors as well as Official Inspected establishments.

4. Sanitation:

- Daily: after operation, prior to use the next day, all equipment and product contact surfaces (e.g. hand tools, knives, hooks, tables, bandsaws, grinders, cubers, etc.) shall be thoroughly cleaned. When equipment or product contact surfaces are contaminated with milk, pus, fecal material, or ingesta, operations must be stopped so that 180 degree Fahrenheit (F) water can be used to sanitize them. In addition, equipment and hand utensils must be cleaned during operations as often as needed to prevent organic matter accumulation.
- Employee practices: employees must wear clean clothing, wash hands at the start of operations, wash hands after using restroom, wash hands when contaminated with fecal material, ingesta, pus, or milk, and wear a clean head covering or hair restraint.
- All product shall be unadulterated (e.g free of fecal material, hair, dust, dirt, scaling paint, rust, grease, cigarette ashes, BSE specified risk material etc.)
- Facilities: floors, walls and ceiling shall be constructed so as to be readily cleanable, kept clean, leak proof, and in good repair. There shall be abundant ventilation for all rooms to insure sanitary conditions.

5. Pest Control:

- The plant operators must make every effort to prevent entry of insects, rodents, vermin, animals (e.g. dogs, cats, raccoons, skunks, etc.), and wild birds into the facility.
- Outside premises must be kept clean and tidy; rubbish must not accumulate and weeds must be controlled to avoid harborages and breeding places for rodents and other animals.

6. Inedible material control:

- Inedible material (e.g. bones, intestines, lungs, heads, hooves, etc.) fat and meat scraps must be properly denatured, and placed in a water-tight covered container labeled INEDIBLE.
- For all cattle and calves:
Small intestines, tonsils and spinal cord must be removed and not used for human consumption
- For cattle 30 months of age and over (see tooth chart below), the following material must not be used for human consumption:
 - Small intestines, tonsils, spinal cord, head, brain, eyes, trigeminal ganglia, skull, dorsal root ganglia, and the backbone (**this includes the “T” portion of the t-bone, porterhouse for example, but not the rest of the cut**).

In the case of cattle or calves, if one custom exempt facility must transport carcasses with any Specified Risk Material present on the carcass to another custom exempt facility for processing, it may do so if the owner states in writing that this movement is allowed to occur. The age of the animal must be verified to

the receiving custom establishment so that any Specified Risk Material can be removed during processing.

7. Raw pork control:

- Meat food products containing raw pork must be treated to destroy trichina.
- The plant operator must keep a time and temperature log for cooking to show what was done to destroy trichina (i.e. cook to temperature of 144 degrees Fahrenheit or above). Freezing, smoking, and curing can also be used to destroy trichina.
- Swine carcasses and parts must not touch any other species and equipment must be cleaned after swine carcasses or parts are processed and before any other species is processed.

8. Water Supply:

- i. The plant operator is responsible for ensuring the water is potable when operating. A current water certificate must be kept on file indicating satisfactory water quality:
Well water must be tested 2x per year. The test should include coliform bacteria, nitrite and nitrate levels.
or
A current municipal water certificate indicating satisfactory water quality.
- ii. The plant must have an ample supply of water that is hot enough for thorough cleanup and fat particle removal, and 180° F water for disinfection and where necessary.
- iii. The plant operator is responsible for installing and maintaining devices to prevent back-siphonage into potable water lines.

9. Sewer/Waste disposal:

- The plant operator is responsible for maintaining a record that the sewer/waste disposal system at the location has been approved by local/state authorities and that no sewer/waste problems occur on the premises.

Failure to follow these guidelines may result in withdrawal of custom exemption privileges.

**SUBCHAPTER E—REGULATORY REQUIREMENTS UNDER THE
FEDERAL MEAT INSPECTION ACT AND THE POULTRY
PRODUCTS INSPECTION ACT**

PART 416—SANITATION

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AUTHORITY: 21 U.S.C. 451–470, 601–695; 7

U.S.C. 450, 1901–1906; 7 CFR 2.18, 2.53.

SOURCE: 61 FR 38868, July 25, 1996, unless otherwise noted.

§ 416.1 General rules.

Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated. [64 FR 56417, Oct. 20, 1999]

§ 416.2 Establishment grounds and facilities.

(a) *Grounds and pest control.* The grounds about an establishment must be maintained to prevent conditions that could lead to insanitary conditions, adulteration of product, or interfere with inspection by Maine Department of Agriculture (MDOA) program employees. Establishments must have in place a pest management program to prevent the harborage and breeding of pests on the grounds and within establishment facilities. Pest control substances used must be safe and effective under the conditions of use and not be applied or stored in a manner that will result in the adulteration of product or the creation of insanitary conditions.

(b) *Construction.*

(1) Establishment buildings, including their structures, rooms, and compartments must be of sound construction, be kept in good repair, and be of sufficient size to allow for processing, handling, and storage of product in a manner that does not result in product adulteration or the creation of insanitary conditions.

(2) Walls, floors, and ceilings within establishments must be built of durable materials impervious to moisture and be cleaned and sanitized as necessary to prevent adulteration of product or the creation of insanitary conditions.

(3) Walls, floors, ceilings, doors, windows, and other outside openings must be constructed and maintained to prevent the entrance of vermin, such as flies, rats, and mice.

(4) Rooms or compartments in which edible product is processed, handled, or stored must be separate and distinct from rooms or compartments in which inedible product is processed, handled, or stored, to the extent necessary to prevent product adulteration and the creation of insanitary conditions.

(c) *Light.* Lighting of good quality and sufficient intensity to ensure that sanitary conditions are maintained and that product is not adulterated must be provided in areas where food is processed, handled, stored, or examined; where equipment and utensils are cleaned; and in hand-washing areas, dressing and locker rooms, and toilets.

(d) *Ventilation.* Ventilation adequate to control odors, vapors, and condensation to the extent necessary to prevent adulteration of product and the creation of insanitary conditions must be provided.

(e) *Plumbing.* Plumbing systems must be installed and maintained to:

- (1) Carry sufficient quantities of water to required locations throughout the establishment;
- (2) Properly convey sewage and liquid disposable waste from the establishment;
- (3) Prevent adulteration of product, water supplies, equipment, and utensils and prevent the creation of insanitary conditions throughout the establishment;
- (4) Provide adequate floor drainage in all areas where floors are subject to flooding-type cleaning or where normal operations release or discharge water or other liquid waste on the floor;
- (5) Prevent back-flow conditions in and cross-connection between piping systems that discharge waste water or sewage and piping systems that carry water for product manufacturing;
- (6) Prevent the backup of sewer gases.

(f) *Sewage disposal.* Sewage must be disposed into a sewage system separate from all other drainage lines or disposed of through other means sufficient to prevent backup of sewage into

areas where product is processed, handled, or stored. When the sewage disposal system is a private system requiring approval by a State or local health authority, the establishment must furnish MDOA with the letter of approval from that authority upon request.

(g) *Water supply and water, ice, and solution reuse.*

(1) A supply of running water that complies with the National Primary Drinking Water regulations (40 CFR part 141), at a suitable temperature and under pressure as needed, must be provided in all areas where required (for processing product, for cleaning rooms and equipment, utensils, and packaging materials, for employee sanitary facilities, etc.). If an establishment uses a municipal water supply, it must make available to MDOA, upon request, a water report, issued under the authority of the State or local health agency, certifying or attesting to the potability of the water supply. If an establishment uses a private well for its water supply, it must make available to MDOA, upon request, documentation certifying the potability of the water supply that has been renewed at least semi-annually.

(2) Water, ice, and solutions (such as brine, liquid smoke, or propylene glycol) used to chill or cook ready-to-eat product may be reused for the same purpose, provided that they are maintained free of pathogenic organisms and fecal coliform organisms and that other physical, chemical, and microbiological contamination have been reduced to prevent adulteration of product.

(3) Water, ice, and solutions used to chill or wash raw product may be reused for the same purpose provided that measures are taken to reduce physical, chemical, and microbiological contamination so as to prevent contamination or adulteration of

product. Reuse that which has come into contact with raw product may not be used on ready-to-eat product.

(4) Reconditioned water that has never contained human waste and that has been treated by an onsite advanced wastewater treatment facility may be used on raw product, except in product formulation, and throughout the facility in edible and inedible production areas, provided that measures are taken to ensure that this water meets the criteria prescribed in paragraph (g)(1) of this section. Product, facilities, equipment, and utensils coming in contact with this water must undergo a separate final rinse with non-reconditioned water that meets the criteria prescribed in paragraph (g)(1) of this section.

(5) Any water that has never contained human waste and that is free of pathogenic organisms may be used in edible and inedible product areas, provided it does not contact edible product. For example, such reuse water may be used to move heavy solids, to flush the bottom of open evisceration troughs, or to wash antemortem areas, livestock pens, trucks, poultry cages, picker aprons, picking room floors, and similar areas within the establishment.

(6) Water that does not meet the use conditions of paragraphs (g)(1) through (g)(5) of this section may not be used in areas where edible product is handled or prepared or in any manner that would allow it to adulterate edible product or create insanitary conditions.

(h) *Dressing rooms, lavatories, and toilets.*

(1) Dressing rooms, toilet rooms, and urinals must be sufficient in number, ample in size, conveniently located, and maintained in a sanitary condition and in good repair at all times to ensure cleanliness of all persons handling any product. They must be separate from the rooms and compartments in which products are processed, stored, or handled.

(2) Lavatories with running hot and cold water, soap, and towels, must be placed in or near toilet and urinal rooms and at such other places in the establishment as necessary to ensure cleanliness of all persons handling any product.

(3) Refuse receptacles must be constructed and maintained in a manner that protects against the creation of insanitary conditions and the adulteration of product.

[64 FR 56417, Oct. 20, 1999]

§ 416.3 Equipment and utensils.

(a) Equipment and utensils used for processing or otherwise handling edible product or ingredients must be of such material and construction to facilitate thorough cleaning and to ensure that their use will not cause the adulteration of product during processing, handling, or storage. Equipment and utensils must be maintained in sanitary condition so as not to adulterate product. (b) Equipment and utensils must not be constructed, located, or operated in a manner that prevents MDOA inspection program employees from inspecting the equipment or utensils to determine whether they are in sanitary condition.

(c) Receptacles used for storing inedible material must be of such material and construction that their use will not result in the adulteration of any edible product or in the creation of insanitary conditions. Such receptacles must not be used for storing any edible product and must bear conspicuous and distinctive marking to identify permitted uses.

[64 FR 56417, Oct. 20, 1999]

§ 416.4 Sanitary operations.

(a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.

(b) Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.

(c) Cleaning compounds, sanitizing agents, processing aids, and other chemicals used by an establishment must be safe and effective under the conditions of use. Such chemicals must be used, handled, and stored in a manner that will not adulterate product or create insanitary conditions. Documentation substantiating the safety of a chemical's use in a food processing environment must be available to MDOA inspection program employees for review.

(d) Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments.

[64 FR 56417, Oct. 20, 1999]

§ 416.5 Employee hygiene.

(a) *Cleanliness.* All persons working in contact with product, food-contact surfaces, and product-packaging materials must adhere to hygienic practices while on duty to prevent adulteration of product and the creation of insanitary conditions.

(b) *Clothing.* Aprons, frocks, and other outer clothing worn by persons who handle product must be of material that is disposable or readily cleaned. Clean garments must be worn at the start of each working day and garments must be changed during the day as often as necessary to prevent adulteration of product and the creation of insanitary conditions.

(c) *Disease control.* Any person who has or appears to have an infectious disease, open lesion, including boils, sores, or infected wounds, or any other abnormal source of microbial contamination, must be excluded from any operations which could result in product adulteration and the creation of insanitary conditions until the condition is corrected.

[64 FR 56417, Oct. 20, 1999]

§ 416.6 Tagging insanitary equipment, utensils, rooms or compartments.

When an MDOA program employee finds that any equipment, utensil, room, or compartment at an official establishment is insanitary or that its use could cause the adulteration of product, he will attach to it a "U.S. Rejected" tag. Equipment, utensils, rooms, or compartments so tagged cannot be used until made acceptable. Only an MDOA program employee may remove a "U.S. Rejected" tag.

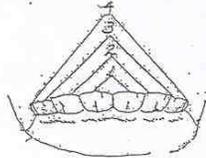
[64 FR 56417, Oct. 20, 1999]

Tooth chart for aging cattle, 30 months or older

Cattle Dental Formula. (Adapted from Bovine Practitioner, No. 9-74, and "Incisor Tooth Eruption, Development and Attrition," Texas A&M University.)



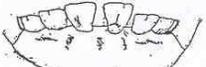
Upper and lower arches showing premolars and molars.
 1—2nd premolar; 2—3rd premolar; 3—4th premolar; 4—1st molar;
 5—2nd molar; and 6—3rd molar.



18 months



19 months



20 months

Cattle Dental Formula (continued)



20 1/2 months



21 months



22 months



23 1/2 months



25 months

Cattle Dental Formula (continued)



25 1/2 months



27 months



27 1/2 months



29 1/2 months



30 months



32 months

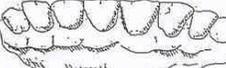
Cattle Dental Formula (continued)



34 months



5 years



7 years



9 years



11 years