

United States
Department of
Agriculture

Food Safety and Inspection Service Washington, D.C. 20250



Q.F.B. Amada Vélez Méndez Directora General de Inocuidad Agroalimentaria, Acuícola y Pesquera Servico Nacional de Sanidad, Inocuidad y Calidad Agroalimentaria (SENASICA) Secreteria de Agricultura, Ganaderia, 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.

, Me Darumo of

Sincerely,

Sally White

Director

International Equivalence Staff
Office of International Affairs

Enclosure

Country File (Mexico)

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
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FINAL

JUN 2 9 2006

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

E. coli Escherichia coli

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)

Salmonella Salmonella 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 Establishment	2		
Meat/Poultry Processing Estab	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

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:
 - o Receiving of non-meat material
 - Rework product
 - o 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/cm², and had not developed a statistical process control method to evaluate the *E. coli* test results.

10

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 counties 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.

1/2-6-1 Jan

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)*

Unities States Department of Agriculture Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1 ESTABLISHMENT NAME AND LOCATION	2. AUDIT E	DATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY	
American Beef S.A. de C.V.	11/18/2005		TIF 154	Mexico	
Retorno Pablo Neruda No. 107, Complejo	5. NAME OF AUDITO		1		
31136 Chihuahua				6. TYPE OF AUDIT	
Chihuahua, Mexico	Dr. Alam Kha			X ON-SITE AUDIT D	OCUMENT AUDIT
Place an X in the Audit Results block to inc	licate nor	ncomp	liance with requirem	ients. Use O if not appli	cable.
Part A - Sanitation Standard Operating Procedures (S	SSOP)	Audit		art D - Continued	Audit
Basic Requirements 7. Written SSOP		Results		onomic Sampling	Results
			33. Scheduled Sample		
8. Records documenting implementation.			34. Species Testing		
9. Signed and dated SSOP, by on-site or overall authority. Sanitation Standard Operating Procedures (SSOP)			35. Residue		
Ongoing Requirements			Part E -	Other Requirements	
10. Implementation of SSOP's, including monitoring of implemen	tation.		36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import		
 Corrective action when the SSOPs have falled to prevent dire product contamination or adulteration. 	ect		38. Establishment Grounds	and Pest Control	
13. Daily records document item 10, 11 and 12 above.			39. Establishment Construction/Maintenance		
Part B - Hazard Analysis and Critical Control		F. Comment	40. Light		
Point (HACCP) Systems - Basic Requirements 14. Developed and implemented a written HACCP plan.		2	41. Ventilation		
15. Contents of the HACCP list the food safety hazards			42 Diambia J C		-
critical control points, critical limits, procedures, corrective acti 16. Records documenting implementation and monitoring of the	ions.		42. Plumbing and Sewage 43. Water Supply		
HACCP plan.			44. Dressing Rooms/Lavator		
The HACCP plan is signed and dated by the responsible establishment individual.			45. Equipment and Utensils		X
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			10 0 0		^_
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 Con	etrol .	
21. Reassessed adequacy of the HACCP plan.			Part F - Ins	spection Requirements	
22. Records documenting: the written HACCP plan, monitoring of the critical control points, idates and times of specific event occurrence.	the		49. Government Staffing		
Part C - Economic / Wholesomeness			50 Doily Incomplies Co.		
23. Labeling - Product Standards		***********	50. Daily Inspection Coverage	9	X
24. Labeling - Net Weights			51. Enforcement		
25. General Labeling			52. Humane Handling		
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moiste	ure)		53. Animal Identification		-
Part D - Sampling Generic <i>E. coli</i> Testing			54. Ante Mortem Inspection		
27. Written Procedures			55. Post Mortem Inspection		
28. Sample Collection/Analysis		——L`			
29. Records			Part G - Other Regulat	tory Oversight Requirements	
Salmonella Performance Standards - Basic Requiren	nents	51	3. European Community Direc	tives	
30. Corrective Actions	िंह	·å 5	7. Monthly Review	• •	
11. Reassessment		5	В.		
2. Written Assurance		5	9.		

66. 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 SIGNATORE AND DATE

united States Decartment 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	
Compania Ganadera Vi-Ba Hermanos, S.A.	10/24/2005	TIF 299 Mexico	
de C.V.	5. NAME OF AUDIT	FOR(S) 6. TYPE OF AUDIT	
Carretera Antiqua A Padilla Santander Jimenez, Tamaulipas Mexico	Dr. Alam Kl	nan X ON-SITE AUDIT COCCIMI	
		OK SITE AODIT	ENT AUDIT
	200	pliance with requirements. Use O if not applicable	3.
Part A - Sanitation Standard Operating Procedures (SS Basic Requirements	SOP) Audit Resu't	Part D - Continued s Economic Sampling	Audit Results
7. Written SSOP		33. Scheduled Sample	
8. Records documenting implementation.		34. Species Testing	
9. Signed and daed SSOP, by on-site or overall authority.		35. Residue	
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements		Part E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation	ation.	36. Export	
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import	
 Corrective action when the SSOPs have falled to prevent direct product contamination or adulteration. 	ct	38. Establishment Grounds and Pest Control	
13. Daily records document item 10, 11 and 12 above.		39. Establishment Construction/Maintenance	ļ
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements		40. Light	
14. Developed and implemented a written HACCP plan.	(a-10)	41. Ventilation	<u> </u>
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective action	ons. X	42. Plumbing and Sewage	
16. Records documenting implementation and monitoring of the HACCP plan.		43. Water Supply	
The HACCP plan is signed and dated by the responsible establishment individual.		44. Dressing Rooms/Lavatories 45. Equipment and Utensils	
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements		46. Sanitary Operations	X
18. Monitoring of HACCP plan.		47. Employee Hygiene	
19. Verification and validation of HACCP plan.	X	48. Condemned Product Control	
20. Corrective action written in HACCP plan.		40. Condentiled Flodder Control	REPORT OF
21. Reassessed adequacy of the HACCP plan.		Part F - Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of t critical control points, dates and times of specific event occurre		49. Government Staffing	
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage	
23. Labeling - Product Standards		51. Enforcement	+
24. Labeling - Net Weights	ĺ		
25. General Labeling		52. Humane Handling	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moistr	ure)	53. Animal Identification	j
Part D - Sampling Generic <i>E. coli</i> Testing		54. Ante Mortem Inspection	
27. Written Procedures		55. Post Morten Inspection	X
28. Sample Collection/Analysis	X		
29. Records		Part G - Other Regulatory Oversight Requirements	
√ Salmonella Performance Standards - Basic Requiren	nents	56. European Community Directives	0
30 Corrective Actions		57. Manthly Review	
31. Reassessment		58. BSE	X
32. Written Assurance		59.	
= 0.0 = 0.00 (0.45 4/5005)			

80 Doservation 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.
- 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}.
- 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).
- 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)}.
- 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)}.
- The establishment did not maintain accurate records of the generic *E. coli* test results, in terms of CFU/cm², 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.

62. AUDITOR SIGNATURE AND DATE

61. NAME OF AUDITOR

Dr Alam Khan DVW

11/20/2005

united States Department of Agriculture Food Safety and Inspection Service

Foreign Establishment Audit Checklist

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	30. Corre	ofive Actions		0	57. N	onthly Review		
32. Written Assurance O SS.	31. Ress	sessment		0	58.			
	32. Write	n Assurance		0	55.			

80. Observation of the Establishment

Est. #: TIF 90 Processing Establishment City and Country: Chihuahua Mexico

Date: 11/17/2005

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.

et. NAME OF AUDITOR

Dr. Alam Khan DVM

62. AUDITOR SIGNATURE AND DATE

1/28/2005

United States Department of Agriculture Food Safety and inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT D	ATE	. 3. ESTABLISHMENT NO.	4. NAME OF COUNTRY	
Empacadora La Cabana, S.A. de C.V.	11/15/200	05	TIF 104	Mexico	
Hacienda Vieja la Nopalera S/N,	5. NAME OF AUDITOR(S)		 DR(S)	6. TYPE OF AUDIT	-
Congregacion Calles	D	771			
Montemorelos, Nuevo Leon, Mexico	1	am Kha		<u> </u>	MENT AUDIT
Place an X in the Audit Results block to inc		ncomp			le.
Part A - Sanitation Standard Operating Procedures (Sasic Requirements	SSOP)	Audit Results	1	rt D - Continued onomic 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		
Sanitation Standard Operating Procedures (SSOP)			Part E -	Other Requirements	
Ongoing Requirements	<u>.</u>				
10. Implementation of SSOP's, including monitoring of implement	ntation.		36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import		
Corrective action when the SSOPs have failed to prevent direction.	rect		38. Establishment Grounds	and Pest Control	
13. Daily records document item 10, 11 and 12 above.			39. Establishment Construc	tion/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		
14. Developed and implemented a written HACCP plan.			41. Ventilation		
 Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective ad 	tions.		42. Plumbing and Sewage		
 Records documenting implementation and monitoring of the HACCP plan. 			43. Water Supply		
The HACCP plan is signed and dated by the responsible establishment individual.			44. Dressing Rooms/Lavato 45. Equipment and Utensiis		
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			46. Sanitary Operations		
18. Monitoring of HACCP plan.			47. Employee Hygiene		
19. Verification and validation of HACCP plan.			48. Condemned Product Co	ntrol	
20. Corrective action written in HACCP plan.				,	
21. Reassessed adequacy of the HACCP plan.			Part F - In	spection Requirements	
22. Records documenting: the written HACCP plan, monitoring of critical control points, iddes and times of specific event occur	f the rremoes.	···	49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Coverag	ge	
23. Labeling - Product Standards			51. Enforcement		
24. Labeling - Net Weights					
25. General Labeling			52. Humane Handling		0
26. Fin. Prod. Standards/Boneless (Defects/AQL/Park Skins/Mois	sture)		53. Animal Identification		. 0
Part D - Sampling Generic <i>E. coli</i> Testing	All like to the state of the st		54. Ante Mortem Inspection		0
27. Written Procedures		0	55. Post Mortem Inspection		0
28. Sample Collection/Analysis		0	D (0 0)		
29. Records		0	Part G - Other Regul	atory Oversight Requirements	
Salmonella Performance Standards - Basic Require	ements		56. European Community Dire	ectives	0
30. Corrective Actions		0	57. Manthly Review		
31. Fæssessment		0	58.		!
32. Written Assurance		0	58.		ļ

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

162. AUDITOR SIGNATURE AND DATE

11/28/2005

United States Department of Agripulture Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DAT	7E 3	. ESTABLISHMENT N	IO. : 4. NAME OF COUNTRY	
KeKen	1 1/1 0/2005		TIF 152 Mexico		
Commercializadora Porcicola Mexicana	5. NAME OF AUDITO		(S)	6. TYPE OF AUDIT	
Km. 3.5 Carret. Uman – Poxila Uman	Dr. Alan	a Vho	n	X ON SITE AUDIT	
Yucatan, Mexico				ON-SITE ACCIT	TICUA THBM
Place an X in the Audit Results block to in		omplia	ince with requi		e.
Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements		Audit Results	Part D - Continued Economic Sampling		Audit Results
7. Written SSOP			33. Scheduled Sampl	e	
8. Records documenting implementation.			34. Species Testing		
9. Signed and dated SSOP, by on-site or overall authority.			35. Residue		
Sanitation Standard Operating Procedures (SSOP Ongoing Requirements)		Pa	rt E - Other Requirements	
10. Implementation of SSOP's, including monitoring of implement	entation.	Х	36. Export		F1000-400-500
11. Maintenance and evaluation of the effectiveness of SSOP's			37. Import		
Corrective action when the SSOPs have faled to prevent oppoduct contamination or adulteration.	direct		38. Establishment Grounds and Pest Control		
13. Daily records document item 10, 11 and 12 above.			39 Establishment Co	nstruction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		
14. Developed and implemented a written HACCP plan.			41. Ventilation		X
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective a	ctions.		42. Plumbing and Sev	vage	_
16. Records documenting implementation and monitoring of the HACCP plan.	9	-	43. Water Supply		
The HACCP plan is signed and dated by the responsible establishment individual.		.	44. Dressing Rooms/Lavatories 45. Equipment and Utensils		X
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			46. Sanitary Operations		
18. Monitoring of HACCP plan.		- A	· · · · · · · · · · · · · · · · · · ·		
19. Verification and validation of HACCP plan.			7. Employee Hygiene	9	
			8. Condemned Produ	ect Control	
Corrective action written in HACCP plan. Reassessed adequacy of the HACCP plan.			Part	F - Inspection Requirements	
	. (1)				
Records documenting: the written HACCP plan, monitoring critical control points, dates and times of specific event occurrence.	or the urrences.	4	9. Government Staffi	ng	
Part C - Economic / Wholesomeness		5	0. Daily Inspection Co	overage	
23. Labeling - Product Standards		5	1. Enforcement		\mathbf{x}
24. Labeling - Net Weights			2. Humane Handling		
25. General Labeling			·		
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pαk Skins/Mo	isture)	5	 Animal Identification 	on	
Part D - Sampling Generic <i>E. coli</i> Testing		5	4. Ante Mortem Inspe	ction	
27. Written Procedures		5	5. Post Mortem Inspe-	ction	
28. Sample Collection/Analysis					
29. Records			Part G - Other R	Regulatory Oversight Requirements	
Salmonella Performance Standards - Basic Requi	rements	56	. European Communi	ty Dřectives	0
30. Corrective Actions	207	प्र _व 57	'. Monthly Review		
31. Reassessment		58			
32. Written Assurance		59	,		

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.

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Country Response Not Received