

United States Department of Agriculture

Food Safety and Inspection Service

Washington, D.C. 20250

JAN 3 1 2006

Q.F.B. Amada Vélez Méndez Director 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) Municipio Libre 377 Piso 7 Ala "B" Santa Cruz Atoyac México, D.F. C.P. 03310 México

Dear Ms. Vélez:

The Food Safety and Inspection Service (FSIS) conducted an on-site audit of Mexico's meat and processed poultry inspection system June 28 through July 14, 2005. Enclosed is a copy of the FSIS final audit report. Your comments regarding the information in the FSIS draft final audit report are included as an addendum to the 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.

Sincerely,

Sally White JD 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 Barbara McNiff, Director, FSIS CODEX Programs Staff, OIA, FSIS Country File (Mexico)

FINAL

JAN - 5 2006

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

JUNE 28, 2005 THROUGH JULY 14, 2005

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ABBREVIATIONS AND SPECIAL TERMS USED IN THE REPORT

BSE Bovine Spongiform Encephalopathy

SENASICA 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

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 June 28 through July 14, 2005.

An opening meeting was held on June 28, 2005 in Mexico City with the Central Competent Authority (CCA). At this meeting, the audit team confirmed the objective and scope of the audit, the auditors' itineraries, and requested additional information needed to complete the audit of Mexico's meat and processed poultry inspection system.

The auditors were accompanied during the entire audit by representatives from the CCA, the Servicio Nacional de Sanidad Inocuidad y Calidad Agroalimentaria (SENASICA) and/or representatives from the 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 products to the United States.

In pursuit of the objective, the following sites were visited: one SENASICA state office, and fourteen meat and/or processed poultry processing establishments.

Competent Authority Visits			Comments
Competent Authority	Central	1	
	State	1	Nuevo Leon State Office
Laboratories		0	
Meat Slaughter Establishm	ents	5	Establishments
Meat/Poultry Processing E	stablishments	9	producing beef, pork and/or poultry products

3. PROTOCOL

This on-site audit was conducted in three parts. One part involved visits with the CCA 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 or regional offices. The third part involved on-site visits to five slaughter/processing and nine 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, (2) animal disease controls, (3) slaughter/processing controls, including the implementation and operation of HACCP programs and a testing program for generic *E. coli*, (4) residue controls, and (5) enforcement controls, including testing programs for *Salmonella* and *Listeria monocytogenes*.

During all on-site establishment visits, the auditors evaluated the nature, extent and degree to which findings impacted on food safety and public health. The auditors also assessed how inspection services are carried out by 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 auditors 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, testing for generic *E. coli* and *Salmonella* in raw products, and testing for *Listeria monocytogenes* and *Salmonella* in ready-to-eat products.

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 testing.

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.usda.gov/Regulations_&_Policies/Foreign_Audit_Reports/index.asp

During the FSIS audit of Mexico's inspection system conducted in November 2004, the following deficiencies were noted:

- Two establishments were cited for inadequate implementation of SSOP requirements.
- One establishment was cited for inadequate sanitation.
- One establishment received a Notice of Intent to Delist (NOID).
- One establishment was cited for animal disease control.
- One establishment was cited for inadequate humane slaughter.

- Nine establishments were cited for inadequate implementation of HACCP requirements.
- Nine establishments were cited for inadequate government enforcement.

During the FSIS audit of Mexico's inspection system conducted in March 2005, the following deficiencies were noted:

- Two establishments received a Notice of Intent to Delist (NOID).
- Six establishments were cited for inadequate government enforcement of inspection requirements.
- One establishment was cited for inadequate sanitation performance standards (SPS).
- Two establishments were cited for not documenting all four parts of corrective actions (especially to prevent recurrence) for SSOP deviations.
- Five establishments were cited for inadequate implementation of HACCP requirements.
- One establishment was cited for not using a government certified laboratory for its *Listeria monocytogenes* and *Salmonella* testing.
- One establishment was cited for not conducting Salmonella testing of its RTE product.
- One establishment was cited for not including sanitation measures as required by establishments adopting Alternative 3 to address *Listeria monocytogenes*.

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 either conducted in TIF establishments or municipal establishments. SENASICA has authority only over TIF establishments whereas Mexico's Department of Health has authority 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 audit of the CCA control systems included the following documents reviews during on-site visits to SENISICA office:

- Supervisory visits to establishments that were certified to export to the United States.
- New laws and implementation documents such as regulations, notices, directives and guidelines.
- 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.
- National residue control program and monitoring results.
- Enforcement records including examples of criminal prosecutions, consumer complaints, recalls, seizures and control of noncompliant product, and withholding, suspending, withdrawing inspection services from or delisting an establishment that is certified to export product to the United States.

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 an 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 an official inspector, 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. Limited resources have restricted SENASICA's ability to conduct sufficient training for its inspection personnel. However, since the April-May 2004 FSIS audit, Mexico has provided three training courses for its inspection personnel regarding implementation and oversight of the U.S. import inspection requirements. Additional training regarding HACCP requirements is scheduled for its inspection personnel.

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. However, additional personnel at SENASICA headquarters' office would enhance Mexico's ability to ensure continued compliance of the U.S. inspection requirements.

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 auditors 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.
- Enforcement records, including examples of criminal prosecution, consumer complaints, recalls, seizure and control of noncompliant product, and withholding, suspending, withdrawing inspection services from or delisting an establishment that is certified to export product to the United States.

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

7. ESTABLISHMENT AUDITS

The FSIS auditors visited a total of 14 slaughter/processing and processing establishments. None of the establishments audited were de-listed by Mexico. One establishment received a Notice of Intent to Delist (NOID) from Mexico's inspection officials due to inadequate implementation of HACCP and SSOP requirements.

This establishment may retain its certification for export to the United States provided that they correct all deficiencies noted during the audit within 30 days of the date the establishment was reviewed.

Specific deficiencies are noted on the attached foreign establishment audit checklists.

8. RESIDUE AND MICROBIOLOGY LABORATORY AUDITS

No laboratories conducting residue and microbiological testing were audited during this audit.

9. SANITATION CONTROLS

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

Based on the on-site audits of establishments, and except as noted below, 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. Of the 14 establishments audited, there was inadequate implementation of SSOP requirements in six establishments.

SSOP implementation deficiencies are noted on the attached foreign establishment audit checklists.

9.2 Sanitation

The following deficiencies were noted:

- Rust and/or beaded condensation was observed on the entire drive chain of the slaughter line and in carcass coolers in one establishment.
- Boxes containing packaging material were observed being stored on the floor in one establishment.
- Overhead structures above exposed product/equipment (mixer, stuffer, etc.) in several production areas had been neglected to varying degrees in two establishments, with rust, loose and flaking paint/sealer materials, dripping condensation, and holes in walls/ceilings in evidence.
- The documentation of corrective actions for SSOP deficiencies was incomplete in five establishments.
- Water from an overhead pipe was leaking onto carcasses in one establishment.

10. ANIMAL DISEASE CONTROLS

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

procedures for sanitary handling of returned and reconditioned product. The auditors determined that Mexico's inspection system had adequate controls in place. No deficiencies were noted.

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 auditors 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* and *E. coli* O157:H7 in slaughter establishments, *Listeria monocytogenes* in processing establishments, and the implementation of the BSE control measures.

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 fourteen establishments. Of these establishments, there was inadequate implementation of HACCP requirements in twelve establishments.

HACCP implementation deficiencies are noted on the attached foreign establishment audit checklists.

11.3 Testing for Generic E. coli

• One establishment had not developed a Statistical Process Control chart.

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.

Deficiencies identified by the FSIS auditors are noted on the attached foreign establishment audit checklists.

• One establishment had not validated the frequency of *Listeria monocytogenes* testing.

12. RESIDUE CONTROLS

No residue laboratory was reviewed.

13. ENFORCEMENT CONTROLS

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

Specific deficiencies identified by FSIS auditors are noted on the attached foreign establishment audit checklists.

13.1 Daily Inspection in Establishments

Inspection was being conducted daily in all slaughter/processing and 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. The FSIS auditors 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 establishments visited, monthly supervisory reviews of certified establishments were being performed and documented as required.

13.5 Inspection System Controls

The 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, adequate controls were found to be in place for security items, products entering the establishments from outside sources, and shipment security with the exception of the following:

Government officials did not provide a uniform method for sample oversight, integrity, and security when shipping samples to the laboratory.

14. CLOSING MEETING

A closing meeting was held on July 14, 2005 in Mexico City with the SENASICA. At this meeting, the primary findings and conclusions from the audit were presented by the auditor.

Jary D. BelfaMW for Alins Khan SVM

The SENASICA understood and accepted the findings.

Dr. Alam Khan Program Auditor

15. ATTACHMENTS

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

United States Department of Agriculture Food Safety and Inspection Service

1. ESTABL Grupo k	ISHMENT NAME AND LOCATION	2. AUDIT DAT	Ê	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY	
	88 Carretera Inter, Mexico-Nogales	07/06/05		TIF 74	Mexico	
C.P. 858	800 Navojoa, Sonora, Mexico	5. NAME OF A	UD:TC	PR(S)	6. TYPE OF AUDIT	
		Jonathan	В. С	oleman DVM	X ON-SITE AUDIT DOCUME	ENT AUDIT
Place ar	n X in the Audit Results block to ind	icate nonco	amn	liance with requirem		
Part A - S	anitation Standard Operating Procedures (S	CODY	Audit		ort D - Continued	
	Basic Requirements	, , , , , , , , , , , , , , , , , , ,	Results	ł	onomic Sampling	Audit Results
7. Written				33. Scheduled Sample		
8. Record	s documenting implementation.			34. Species Testing		
	and dated SSOP, by on-site or overall authority.			35. Residue		
	on Standard Operating Procedures (SSOP) Ongoing Requirements			Part E -	Other Requirements	
	nentation of SSOP's, including monitoring of implement	ation.		36. Export		
	enance and evaluation of the effectiveness of SSOP's.			37. Import		
	tive action when the SSOPs have faled to prevent direct contamination or adulteration.	ct		38. Establishment Grounds	and Pest Control	
13. Daily r	ecords document item 10, 11 and 12 above.			39. Establishment Construc	tion/Maintenance	
Part Point	B - Hazard Analysis and Critical Control (HACCP) Systems - Basic Requirements			40. Light		
	oped and implemented a written HACCP plan .			41. Ventilation		
15 Conter critical	nts of the HACCP list the food safety hazards, control points, critical limits, procedures, corrective actions.	ons.		42. Plumbing and Sewage		
16. Record	is documenting implementation and monitoring of the P plan.			43. Water Supply		-
17. The H	ACCP plan is signed and dated by the responsible shment individual.			44. Dressing Rooms/Lavato		-
	ard Analysis and Critical Control Point CCP) Systems - Ongoing Requirements			45. Equipment and Utensils 46. Sanitary Operations		
	ring of HACCP plan.					
19. Verifica	ation and validation of HACCP plan.			47. Employee Hygiene		
	tive action written in HACCP plan.			48. Condemned Product Co.	ntrol	
	essed adequacy of the HACCP plan.	× ×		Part F - In	spection Requirements	
22. Record	s documenting: the written HACCP plan, monitoring of	the X		49. Government Staffing	Special Requirements	
Chtical	control points, dates and times of specific event occurred Part C - Economic / Wholesomeness	ences.				
23. Labelin	g - Product Standards			50. Daily Inspection Coverag	ge	
	g - Net Weights			51. Enforcement		X
25. Genera				52. Humane Handling		
	od Standards/Boneless (Defects/AQL/Pork Skins/Moist	ure)				
	Part D - Sampling			53. Animal Identification		
	Generic E. coli Testing			54. Ante Mortem Inspection		
27. Written	Procedures			55. Post Mortem Inspection		
28. Sample	Collection/Analysis					-
29. Records	3			Part G - Other Regula	atory Oversight Requirements	
Salmon	ella Performance Standards - Basic Requirer	nents		56. European Community Dre	ectives	
30. Correcti	ve Actions			57. Monthly Review) i
31. Reesses	ssment			58.		
32. Written	Assurance			59.		

July 6, 2005: Establishment TIF 74 - Grupo Kowi, KM 1788 Carretera Inter, Mexico-Nogales, C.P. 85800 Navojoa, Sonora, Mexico

Type of Operation: Pork Slaughter and Simple Processing Facility

20/51 Corrective measures taken for deviations from the critical limit of CCP 1 of the establishment's HACCP plan for Slaughter did not meet all of the regulatory requirements. [9 CFR 417.3a]

22/51 The following HACCP recordkeeping non-compliances were observed.

- The HACCP records associated with the establishment's HACCP plans for Slaughter and Raw not ground did not record the actual times, temperatures or other quantifiable values of the results of the establishment's monitoring activities. Each entry made on these records did not include the signature or initials of the establishment employee who made them. [9 CFR 417.5]
- The HACCP records associated with the establishment's HACCP plans for Slaughter and Raw – not ground did not contain the results of the verification activities performed. [9 CFR 417.5a3]

SAGARPA officials initiated control actions for all HACCP non-compliances identified on the day of the audit and proposed a plan of actions to ensure that the establishment complies with all appropriate FSIS regulations.

61. NAME OF AUDITOR

Jonathan B. Coleman. DVM

G2. AUDITOR SIGNATURE AND DATE

JONATHAN B. Coleman. DVM

O7. 06. 05

United States Department of Agriculture Food Safety and Inspection Service

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CPR 80149 Cutiscus, Sin. Mexico Jonathan B. Coleman DVM X on SITEAUDIT DOCUMENT AUDIT			5. NAME OF		R(S)	6. TYPE OF AUDIT	
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July 8, 2005: Establishment TIF N. 89 and TIF N. 169 - Productos Chata, S.A. de C.V., Camino Real No.5 Col. Bachigualato, C.P. 80140 Culiacan, Sin. Mexico Type of Operation: Thermal Processing (Canning) Facility

22/51 The HACCP records associated with the establishment's HACCP plans for Thermally processed-commercially sterile products did not contain the results of the verification activities performed. [9 CFR 417.5a3]

The SAGARPA officials initiated control actions and proposed a plan of action to ensure that the establishment complies with all appropriate FSIS regulations.

United States Department of Agriculture Food Safety and Inspection Service

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT D.	DATE 3. ESTABLISHMENT NO.		4. NAME OF COUNTRY		
Grupo Bafar	07/02/05		TIF 90	Mexico		
Km. 7.5 Carr. A Cuauhtemoc Col. Las Animas C. P. 31450	5. NAME OF	AUDITO	R(S)	6. TYPE OF AUDIT		
Chihuahua, CHIH. Mexico	Tonath	 m R C	B. Coleman DVM X ON-SITE AUDIT DOG			
Place an X in the Audit Results block to ind		compl				
Part A - Sanitation Standard Operating Procedures (S Basic Requirements	SSOP)	Audit Results		ort D - Continued conomic Sampling	Audit Results	
7. Written SSOP			33. Scheduled Sample	one management	 	
Records documenting implementation.			34. Species Testing			
Signed and dated SSOP, by on-site or overall authority.			35. Residue			
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements				Other Requirements		
10. Implementation of SSOP's, including monitoring of implemen	ntation.	X	36. Export			
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import			
 Corrective action when the SSOPs have falled to prevent dir product contamination or adulteration. 	ect	Х	38. Establishment Grounds	and Pest Control		
13. Daily records document item 10, 11 and 12 above.			39. Establishment Construc	ction/Maintenance	X	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light			
14. Developed and implemented a written HACCP plan .			41. Ventilation		ļ	
 Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective ac 	tions.		42. Plumbing and Sewage	·		
 Records documenting implementation and monitoring of the HACCP plan. 			43. Water Supply 44. Dressing Rooms/Lavato	orige.		
 The HACCP plan is signed and dated by the responsible establishment individual. 			45. Equipment and Utensils			
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			46. Sanitary Operations			
18. Monitoring of HACCP plan.			- '		-	
19. Verification and validation of HACCP plan.			47. Employee Hygiene 48. Condemned Product Co	ontrol		
20. Corrective action written in HACCP plan.						
21. Reassessed adequacy of the HACCP plan.			Part F - Ir	nspection Requirements		
22. Records documenting: the written HACCP plan, monitoring of critical control points, dates and times of specific event occur	of the irrences.	X	49. Government Staffing			
Part C - Economic / Wholesomeness			50. Daily Inspection Covera	age		
23. Labeling - Product Standards		-	51, Enforcement		X	
24. Labeling - Net Weights			52. Humane Handling			
25. General Labeling			32. Trumane tranumig		0	
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moi	sture)	.,	53. Animal Identification		0	
Part D - Sampling Generic <i>E. coli</i> Testing			54. Ante Mortem Inspection		0	
27. Written Procedures		0	55. Post Mortem Inspection		0	
28. Sample Collection/Analysis		0	- 10 01 -			
29. Records		0	Part G - Other Regu	latory Oversight Requirements		
Salmonella Performance Standards - Basic Requir	rements		56. European Community Di	rectives	0	
30. Corrective Actions		0	57. Monthly Review			
31. Reassessment		0	58.			
32. Written Assurance		0	59.			

July 2, 2005: Establishment TIF 90 - Grupo Bafar, Km. 7.5 Carr. A Cuauhtemoc Col. Las Animas C. P. 31450, Chihuahua, CHIH. Mexico Type of Operation: Complex Processing

10 In the hot dog peeling area, a plant employee was observed manually removing a string of cooked hot dogs that were on the floor, disposing of them then returning to handle product on contact surfaces without restoring sanitation to his gloved hands. [9 CFR 416.13]

12/51 Corrective measures taken because of incidences of direct product contamination or adulteration of product did not include preventative measures. [9 CFR 416.15]

22/51 The HACCP records associated with the establishment's HACCP plans for Fully cooked product – not shelf stable and Heat treated but not fully cooked – not shelf stable did not contain the results of the verification activities performed. [9 CFR 417.5a3]

39 There was an accumulation of flaking rust on an air vent above the sausage and ham cooking vats in the product cooking room. [9 CFR 416.4]

SAGARPA officials initiated control actions for all SSOP and HACCP noncompliances identified on the day of the audit and proposed a plan of actions to ensure that the establishment complies with all appropriate FSIS regulations.

62. AUDITOR SIGNATURE AND DATE

162. AUDITOR SIGNATURE AND DATE

162. AUDITOR SIGNATURE AND DATE

DR. LOWATHAW B COLGHAN

United States Department of Agriculture Food Safety and Inspection Service

	ESTABLISHMENT NAME AND LOCATION	2. AUDIT D	ATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY	
	Union Sanitaria de Productos Alimenticios, S.A. de C.V.	06/29/05		TIF 95	Mexico	
	Calle J.M. Salvatierro y A. Humbolt No. 17538 Fracc.	5. NAME OF AUDITO		R(S)	S. TYPE OF AUDIT	
	Garita de Otay	Longth	an B. C.	oleman DVM	X ON-SITE AUDIT DOCUME	
	Tijuanna, Baja California, Mexico C.P. 22500					NT AUDIT
	ace an X in the Audit Results block to inc		ncompl			•
Pa	rt A - Sanitation Standard Operating Procedures (Basic Requirements	SSOP)	Audit Results	1	art 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		
S	anitation Standard Operating Procedures (SSOP) Ongoing Requirements			Part E -	- Other Requirements	
10	. Implementation of SSOP's, including monitoring of implemen	ntation.		36. Export		
11	. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import		
12	. Corrective action when the SSOPs have falled to prevent di product contamination or adulteration.	rect		38. Establishment Grounds	and Pest Control	
13	. Daily records document item 10, 11 and 12 above.			39. Establishment Construc	otion/Maintenance	
	Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		-
14	. Developed and implemented a written HACCP plan .			41. Ventilation		
15	. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective ac	tions.		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/Lavato 45. Equipment and Utensils		
	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	ontrol	
20	Corrective action written in HACCP plan.					
21	Reassessed adequacy of the HACCP plan.			Part F - Ir	nspection Requirements	
22	. Records documenting: the written HACCP plan, monitoring of critical control points, dates and times of specific event occur		Х	49. Government Staffing		
	Part C - Economic / Wholesomeness			50. Daily Inspection Covera	age	
23.	Labeling - Product Standards			51. Enforcement		37
24.	Labeling - Net Weights					X
25.	General Labeling			52. Humane Handling		0
26	Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Mo	isture)		53. Animal Identification		0
	Part D - Sampling Generic <i>E. coli</i> Testing			54. Ante Mortem Inspection		0
27.	Written Procedures			55. Post Mortem Inspection		0
28.	Sample Collection/Analysis			D (D O () D	1. 0	
29.	Records			Part G - Other Regu	latory Oversight Requirements	
;	Salmonella Performance Standards - Basic Requi	rements		56. European Community Di	rectives	0
30.	Corrective Actions			57. Monthly Review		
31.	Reassessment			58.		
32.	Writen Assurance			59.		
_						

June 29, 2005: Establishment TIF 95 - Union Sanitaria de Productos Alimenticios, S.A. de C.V. Calle J.M. Salvatierro y A. Humbolt No. 17538 Fracc. Garita de Otay, Tijuanna, Baja California, Mexico C.P. 22500

Type of Operation: Simple Processing

22/51 The following HACCP recordkeeping noncompliances were observed:

- The establishment could not produce decision-making documents to support the selection and development of CCP2 and CCP3 in the establishment's HAACP plan for raw product not ground. The establishment has elected to set critical limits for the temperature of ambient air in the cold storage rooms at two different steps (CCP2 and CCP3) in the production process as their standards for determining product safety and demonstrating control of products produced under this HACCP plan; however there were no documents available to support this decision. [9 CFR 417.5a2]
- The HACCP records did not document the results of all verification activities performed. [9 CFR 417.5a3]

SAGARPA officials documented the noncompliances on the day of the audit and proposed a plan of actions to ensure that the establishment complies with all appropriate FSIS regulations.

United States Department of Agriculture Food Safety and Inspedion Service

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT D	ATE	3, ESTABLISHMENT NO.	4. NAME OF COUNTRY	
Ganaderia Integral S.K. S.A. de C.V.	07/08/200	5	TIF 105	Mexico	
Libramiento Noreste Km. 25, s/n Carretera	5. NAME OF AUDITO		R(S) 6. TYPE OF AUDIT		
Laredo Saltillo, Escobedo	Tom A1.	am Khai	n	X ONLSITE AUDIT	
Nuevo Leon, Mexico	1			DOCUMENT DOCUMENT	IT AUDIT
Place an X in the Audit Results block to inc					
Part A - Sanitation Standard Operating Procedures (Basic Requirements	SSOP)	Audit Results		art D - Continued onomic Sampling	Audit Results
7. Written SSOP		results	33. Scheduled Sample	onomic Sampling	1
Records documenting implementation.	<u> </u>		34. Species Testing		
9. Signed and dated SSOP, by on-site or overall authority.			35. Residue		-
Sanitation Standard Operating Procedures (SSOP)	'			Other Requirements	
Ongoing Requirements				- Other Requirements	ļ
10. Implementation of SSOP's, including monitoring of implementation of SSOP's and SSOP		X	36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. import		<u> </u>
 Corrective action when the SSOPs have faled to prevent di product contamination or adulteration. 	irect		38. Establishment Grounds	and Pest Control	
13. Daily records document item 10, 11 and 12 above.		X	39. Establishment Constru	ction/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		ļ <u>.</u>
 Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective ac 	dions.		42. Plumbing and Sewage		
 Records documenting implementation and monitoring of the HACCP plan. 	e		43. Water Supply		
 The HACCP plan is signed and dated by the responsible establishment individual. 			44. Dressing Rooms/Lavate		<u> </u>
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 C	ontrol	
20. Corrective action written in HACCP plan.					
21. Reæsessed adequacy of the HACCP plan.			Part F - I	nspection Requirements	
Records documenting: the written HACCP plan, monitoring critical control points, dates and times of specific event occ			49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Cover	age	
Labeling - Product Standards Labeling - Net Weights			51. Enforcement		X
25. General Labeling	-		52. Humane Handling		
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Mo	pisture)		53. Animal Identification		
Part D - Sampling Generic <i>E. coli</i> Testing			54. Ante Mortem Inspection	า	
27. Written Procedures			55. Post Mortem Inspection	า	
28. Sample Collection/Analysis			Part G - Other Regi	ulatory Oversight Requirements	
29. Records			ruit o other regu		
Salmonella Performance Standards - Basic Requi	irements		56. European Community D	Prectives	0
30. Corrective Actions			57. Monthly Review		
31. Reassessment			58.		<u> </u>
32. Written Assurance			59.		

Est.#: TIF 105 Slaughter/ Processing (Raw Not Ground)

City and Country: Escobedo, NL, Mexico

Date: 07/08/2005

- 10/51 Water was observed dripping from an overhead leaking pipe at the zero-tolerance check station onto the passing beef carcasses. The SAGARPA official leading the audit retained the carcasses on the rail and also those from the entire production shift in the cooler, and ordered an immediate corrective action from the management, {9CFR part 416.13}.
- 13/51 Some of the SSOP records did include preventive measures. The SAGARPA officials assured the auditors of prompt compliance by the management. [9CFR 416.15(b)(3)]

THE DVIL

61. NAME OF AUDITOR

Dr. Alam Khan

62 AUDITOR SIGNATURE AND DATE

ALAM KHAN 07/08/05

United States Department of Agriculture Food Safety and Inspection Service

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT D	ATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY	
SuKarne	06/30/05		TIF 120	Mexico	
13.5 Carreterra a Tijuana Pobladao La Rosita	5, NAME O	F AUDITOI	R(S)	6. TYPE OF AUDIT	
Mexicali, Baja California	Y .1	D. C.	-1 D77M		
			oleman DVM		NT AUDIT
Place an X in the Audit Results block to inc		ncompl	iance with requiren	nents. Use O if not applicable	•
Part A - Sanitation Standard Operating Procedures ((SSOP)	Audit		art D - Continued conomic Sampling	Audit Results
Basic Requirements		Results	33. Scheduled Sample	conomic Sampling	-
7. Written SSOP					-
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	}		Part E	- Other Requirements	
10. Implementation of SSOP's, including monitoring of impleme	entation.		36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's			37. Import		
 Corrective action when the SSOPs have falled to prevent of product contamination or adulteration. 	firect		38. Establishment Ground	is and Pest Control	
13. Daily records document item 10, 11 and 12 above.			39, Establishment Constr	uction/Maintenance	
Part B - Hazard Analysis and Critical Control			40. Light		
Point (HACCP) Systems - Basic Requirements 14. Developed and implemented a written HACCP plan.			41. Ventilation		
15 Contents of the HACCP list the food safety hazards.			42. Plumbing and Sewage	e	
aitical control points, critical limits, procedures, corrective a			43. Water Supply		
HACCP plan.			44. Dressing Rooms/Lave	atories	
The HACCP plan is signed and dated by the responsible establishment individual. Hazard Analysis and Critical Control Point			45. Equipment and Utens	ils	
(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	Control	
20. Corrective action written in HACCP plan.		X	Dorf E	Inspection Requirements	
21. Reassessed adequacy of the HACCP plan.			Pattr-	Inspecton requirements	
 Records documenting: the written HACCP plan, monitoring critical control points, dates and times of specific event oc 	of the currences.		49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Cove	erage	
23. Labeling - Product Standards			51. Enforcement		х
24. Labeling - Net Weights			52. Humane-Handling		
25. General Labeling					
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pock Skins/N	Noisture)		53. Animal Identification		
Part D - Sampling Generic <i>E. coli</i> Testing			54. Ante Mortem Inspecti	ion	
27. Written Procedures			55. Post Mortem Inspecti	ion	
28. Sample Collection/Analysis				Life On the Landscape of the Control	
29. Records			Part G - Other Re	gulatory Oversight Requirements	
Salmonella Performance Standards - Basic Requ	uirements		56. European Community	Directives	0
30. Corrective Actions			57. Monthly Review		
31. Reassessment			58.		
32. Writen Assurance		1	59.		
		1	1		

June 30, 2005: Establishment TIF 120 - SuKarne, 13.5 Carreterra a Tijuana Pobladao La Rosita, Mexicali,

Baja California, Mexico

Type of operation: Beef Slaughter and Simple Processing

20/51 Corrective actions taken in response to deviation from the critical limit for CCP 3b, which occurred on June 28, 2005, were not recorded in the establishment's HACCP records for their HACCP plan for Slaughter. [9CFR 417.3(a)]

SAGARPA officials documented the noncompliances on the day of the audit and proposed a plan of actions to ensure that the establishment complies with all appropriate FSIS regulations.

United States Department of Agriculture Food Safety and Inspection Service

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT E	DATE	3. E	STABLISHMENT NO.	4. NAME OF COUNTRY		
Keken	07/04/05	07/04/05		IF 152	Mexico		
Comercializadora Porcicola Mexicana Km. 3.5 Carret. Uman – Poxila Uman	5. NAME O	5. NAME OF AUDITO		R(S) 6. TYPE OF AUDIT			
Yucatan, Mexico	Jonath	Jonathan B. C		Coleman DVM X ON-SITE AUDIT		NT AUDIT	
	indicate no						
Place an X in the Audit Results block to Part A - Sanitation Standard Operating Procedur		1	nano		art D - Continued		
Basic Requirements	€ (330F)	Audit Results			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.		<u> </u>	+	Residue			
Sanitation Standard Operating Procedures (SS	OP)			Part F	- Other Requirements		
Ongoing Requirements			-		- Cinci Requirements	_	
10. Implementation of SSOP's, including monitoring of impl		ļ		Export			
11. Maintenance and evaluation of the effectiveness of SSC			37.	Import			
 Corrective action when the SSOPs have falled to preve product contamination or adulteration. 	nt direct	Х	38.	Establishment Grounds	and Pest Control		
13. Daily records document item 10, 11 and 12 above.			39.	Establishment Construc	ction/Maintenance		
Part B - Hazard Analysis and Critical Contro Point (HACCP) Systems - Basic Requirement			-	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, correcti	ve actions.		42.	Plumbing and Sewage			
 Records documenting implementation and monitoring of HACCP plan. 	f the		-	Water Supply			
The HACCP plan is signed and dated by the responsible establishment individual.	e		\vdash	Dressing Rcoms/Lavato			
Hazard Analysis and Critical Control Point (HACCP) Systems - Ongoing Requirements			-	Sanitary Operations			
18. Monitoring of HACCP plan.		X	╁				
19. Verification and validation of HACCP plan.		<u> </u>	1	Employee Hygiene			
	t variable and a second	X	48.	Condemned Product Co	ontral		
Corrective action written in HACCP plan. Reassessed adequacy of the HACCP plan.		<u> </u>	1	Part F - I	nspection Requirements		
Records documenting: the written HACCP plan, monito critical control points, dates and times of specific event		Х	49.	Government Staffing			
Part C - Economic / Wholesomeness		1	50.	Daily Inspection Covers	age		
23. Labeling - Product Standards			-	T-5		<u> </u>	
24. Labeling - Net Weights			51.	Enforcement		X	
25. General Labeling			52.	Humane Handling			
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skin	s/Moisture)		53.	Animal Identification			
Part D - Sampling Generic <i>E. coli</i> Testing			54.	Ante Mortem Inspection	1		
27. Written Procedures	* ***		55.	Post Mortem Inspection			
28. Sample Collection/Analysis			1				
29. Records				Part G - Other Regu	llatory Oversight Requirements		
Salmonella Performance Standards - Basic Re	equirements		56.	European Community D	rectives		
30. Corrective Actions			57.	Manthly Review			
31. Reassessment			58.		NOID	X	
32. Written Assurance			59.			İ	
			-				

July 4, 2005: Establishment TIF 152 – Keken, Comercializadora Porcicola Mexicana Km. 3.5 Carret. Uman – Poxila Uman, Yucatan, Mexico

Type of operation: Pork slaughter and simple processing

12/51 The corrective actions in the establishment's SSOP records in response to noncompliances identified by the establishment did not include preventive measures. [9 CFR 416.15]

18/51 The monitor for the establishment's CCP 1 (Food Safety Standard – 'Zero tolerance') was not performing monitoring procedures for this CCP as described in the HACCP plan for Slaughter. [9 CFR 417.2]

20/51 Corrective actions documented in the records associated with the establishment's HACCP plans for Slaughter and raw-not-ground products did not meet the requirements. [9 CFR 417.3a]

22/51 The following findings did not meet the requirements of 9 CFR 417.5:

- The establishment could not provide documents to support their decision to establish the critical limits for the CCPs of their HACCP plan for raw-not-ground products.
- The monitoring records for the establishment's slaughter HACCP plan did not include the actual times when the monitor performed the monitoring activities or the results from the monitoring activities.
- The HACCP records associated with the establishment's HACCP plans for Slaughter and raw-not-ground products did not include the results of verification activities that were performed, the actual times that these specific events occurred, or the initials of the individual responsible for performing these verification activities.
- The pre-shipment records did not include documentation that demonstrates the completeness of
 measures taken by establishment to ensure that all critical limits were met and that corrective
 actions taken for deviations were appropriate.

39/51 Rust was observed throughout the entire length of the overhead drive chains for the slaughter line, and in three carcass chilling coolers. [9 CFR 416.2]

41/51 Beaded and dripping condensation was observed on the ceilings of three carcass coolers and on the ceiling, overhead pipes, two turn wheels for the drive chain, and other overhead structures that were in an adjacent hallway and in close proximity to the entrances of these coolers. [9 CFR 416.2]

The SAGARPA officials took immediate action on the finding listed under number 41. The SAGARPA officials plan to issue a NOID to this establishment in response to the Sanitation, SSOP and HACCP noncompliances identified on the day of the audit.

62 AUDITOR SIGNATURE AND DATE

THE STORY OF 104 0

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DA	ATE	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY	
Sigma Alimentos Centro S.A. de C.V.	06/29/20	005	TIF-158	Mexico	
Planta Atitalaquia	5. NAME OF	AUDITO	R(S)	6. TYPE OF AUDIT	
Atitalaquia, Hidalgo	T	771			
	Dr. Ala	ım Kha	n 	X ON-SITE AUDIT DOCUMEN	IT AUDIT
Place an X in the Audit Results block to inc	dicate non	compl	iance with requirem	nents. Use O if not applicable.	
Part A - Sanitation Standard Operating Procedures (SSOP)	Audit		art D - Continued	Audit
Basic Requirements		Results		onomic Sampling	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		<u> </u>
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements			Part E	- Other Requirements	
10. Implementation of SSOP's, including monitoring of implementation of statement and	ntation.		36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import		
 Corrective action when the SSOPs have falled to prevent di product contamination or adulteration. 	rect		38. Establishment Grounds	and Pest Control	
13. Daily records document item 10, 11 and 12 above.		X	39. Establishment Constru	ction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		
14. Developed and implemented a written HACCP plan .			41. Ventilation		
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective ac	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/Lavat		
Hazard Analysis and Critical Control Point			45, Equipment and Otensii	5	ļ
(HACCP) Systems - Ongoing Requirements			46. Sanitary Operations		X
18. Monitoring of HACCP plan.			47. Employee Hygiene		
19. Verification and validation of HACCP plan.			48. Condemned Product C	ontrol	
20. Corrective action written in HACCP plan.					1
21. Reassessed adequacy of the HACCP plan.			Part F - I	nspection Requirements	
22. Records documenting: the written HACCP plan, monitoring of critical control points, dates and times of specific event occur.		Х	49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Cover	age	
23. Labeling - Product Standards			51. Enforcement		
24. Labeling - Net Weights					X
25. General Labeling			52. Humane Handling		
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Mo	isture)		53. Animal Identification		
Part D - Sampling Generic <i>E. coli</i> Testing			54. Ante Mortem Inspection	1	
27. Written Procedures		0	55. Post Mortem Inspection	1	1
28. Sample Collection/Analysis		0			
29. Records		0 1	Part G - Other Regu	ulatory Oversight Requirements	
Salmonella Performance Standards - Basic Requi	rements		56. European Community D	rectives	0
30. Corrective Actions		0	57. Monthly Review		
31. Reassessment		0	58.		i
32. Written Assurance		0	59.		

Est.#: TIF 158 Sigma Alimentos Centro Processing (Raw Not Ground)

City and Country: Atitalaquia, Hidalgo, Mexico

Date: 06/29/2005

- 13/51. The SSOP corrective action records did not include preventive measures. [9CFR part 416.15]
- The calibration records did not include the times of the events and some entries were not initialed. [9CFR part 417.5(b)]
- Several boxes of packaging material were stored on the floor in the cooler room. The Mexican Inspection officials rejected the boxes and requested immediate action by the plant management. [9CFR part 416.4]
- Condensate was dripping from a short black rubber hose into a container with approximately 10 -15 packages of hot dogs for rework. No product was exposed to the condensation. A PVC pipe running over the same area was covered with a layer of dust approximately ¼ inch thick. The SAGARPA officials requested the plant to condemn the product and the plant complied. [9CFR part 416.4 and 416.13(c)]

61. NAME OF AUDITOR

Dr. Alam Khan

62 AUDITOR SIGNATURE AND DATE

FOR DR. KHAN

06/29/05

United States Department of Agriculture Food Safety and Inspection Service

1. ESTABLISHMENT NAME AND LOCATION	· 2. AUDIT D	ATE	3, ESTABLISHMENT NO.	4. NAME OF COUNTRY	
Sigma Alimentos Congelados S.A. de C.V.	07/07/200	5	TIF 209	MEXICO	
Industria Alimenticia No. 760, Parque Industrial, 67735 Linares	5. NAME OF	AUDITO	R(S)	6. TYPE OF AUDIT	
Nuevo Leon, Mexico	D- 41	. 1/1			
·	Dr. Alan	n Knan		X ON-SITE AUDIT DOCUME	NT AUDIT
Place an X in the Audit Results block to inc	dicate non	compl	iance with requirem	ents. Use O if not applicable	
Part A - Sanitation Standard Operating Procedures (SSOP)	Audit	1	rt D - Continued	Audit
Basic Requirements		Results		onomic Sampling	Results
7. Written SSOP			33. Scheduled Sample		<u> </u>
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				,	
10. Implementation of SSOP's, including monitoring of implementation of SSOP's and including monitoring of implementation of SSOP's and including monitoring of implementation of SSOP's and including monitoring of implementation of the social order orde			36. Export		-
11. Maintenance and evaluation of the effectiveness of SSOP's.			37. Import		
 Corrective action when the SSOPs have failed to prevent di product contamination or adulteration. 	rect		38. Establishment Grounds	and Pest Control	-
13. Daily records document item 10, 11 and 12 above.			39. Establishment Construc	ction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		
14. Developed and implemented a written HACCP plan .			41. Ventilation		
15. Contents of the HACCP list the food safety hozards, critical control points, critical limits, procedures, corrective ac	ctions.		42. Plumbing and Sewage		
16. Records documenting implementation and monitoring of the			43. Water Supply		
HACCP plan. 17. The HACCP plan is signed and dated by the responsible			44. Dressing Rooms/Lavato	pries	
establishment individual. Hazard Analysis and Critical Control Point			45. Equipment and Utensils		X
(HACCP) Systems - Ongoing Requirements			46. Sanitary Operations		
18. Monitoring of HACCP plan.			47. Employee Hygiene		
19. Verification and validation of HACCP plan.		Х	48. Condemned Product Co	ontrol	
20. Corrective action written in HACCP plan.					
21. Reassessed adequacy of the HACCP plan.			Part F - Ir	nspection Requirements	-
22. Records documenting: the written HACCP plan, monitoring of critical control points, dates and times of specific event occur.	of the urrences.	X	49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Covera	ge	
23. Labeling - Product Standards			51. Enforcement		X
24. Labeling - Net Weights					
25. General Labeling			52. Humane Handling		0
26. Fin. Prod. Standards/Boneless (Defects/AQL/Park Skins/Mo	isture)		53. Animal Identification	•	0
Part D - Sampling Generic <i>E. coli</i> Testing			54. Ante Mortem Inspection		0
27. Written Procedures		0	55. Post Mortem Inspection		
28. Sample Collection/Analysis		0			
29. Records		0	Part G - Other Regu	latory Oversight Requirements	
Salmonella Performance Standards - Basic Requi	rements		56. European Community Di	rectives	0
30. Corrective Actions		0	57. Monthly Review	THE STATE OF THE S	
31. Reassessment		0	58.	· · · · · · · · · · · · · · · · · · ·	
32. Written Assurance		0	59.		

Est. #: TIF 209

Operation: Fully cooked not shelf stable (RTE)

City and Country: Linares, NL, Mexico

Date: 07/07/2005

- 46/51 1) The equipment washroom did not have a distinct separation between clean and unclean pieces of equipment.
 - 2) Two of the hand-wash stations had neither hand towels nor trash receptacles. The management corrected the deficiency immediately [9CFR 416.4(d)].
- 19/51 1) The sampling methodology identified in the documentation did not support the sampling methodology being used in the analysis for Salmonella in RTE products as part of their on-going verification procedures.
 - 2) The establishment had chosen Alternative 3 to control Listeria monocytogenes through its sanitation program and testing of food contact surface, however the program did not explain why test frequency is sufficient, although they are sampling daily according to records.
- 22/51 Some HACCP verification records had missing entries [9CFR 417.5(b)].

Either all findings were corrected on the day of the audit or SENASICA officials indicated they would initiate a plan of actions to ensure that the establishment complies with all appropriate USDA FSIS regulations.

61. NAME OF AUDITOR

Dr. Alam Khan

62 AUDITOR SIGNATURE AND DATE

DE DE DR. KHAR

OFLOTION

United States Department of Agriculture Food Safety and Inspection Service

1. ESTABLISHMENT NAME AND LOCATION	i 2. AUDIT DATE			TABLISHMENT NO.	4. NAME OF COUNTRY	
Especialidades Tipicas Mexicans S.A. de	06/30/2005		TIF 281 Mexico			
C.V. Camino a Rancho Blanco, KM 2 Para	5. NAME OF AUDITO		DR(S)		6. TYPE OF AUDIT	
je Las Verduras Esprititu Santo Jilitzingo Edo De Mexico	Dr. Alam					DOCUMENT AUDIT
Place an X in the Audit Results block to inc	dicate nonce	ompli	anc	e with requirem	ents. Use O if not app	olicable.
Part A - Sanitation Standard Operating Procedures (Basic Requirements	SSOP)	Audit Results		Pa	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			36	Export		
10. Implementation of SSOP's, including monitoring of impleme			<u> </u>	Import		
11. Maintenance and evaluation of the effectiveness of SSOP's		X				
 Corrective action when the SSOPs have failed to prevent d product contamination or adulteration. 	illect		ļ	Establishment Grounds		
13. Daily records document item 10, 11 and 12 above.			39.	Establishment Constru	ction/Maintenance	
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements				Light Ventilation		
14. Developed and implemented a written HACCP plan .			41.	Ventuation		
 Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective a 	actions.		-	Plumbing and Sewage		
 Records documenting implementation and monitoring of th HACCP plan. 	e		 	Water Supply	ories	X
The HACCP plan is signed and dated by the responsible establishment individual.			├ ─	Dressing Rooms/Lavat Equipment and Utensil		12
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.			1	Condemned Product C	ontroi	
20. Corrective action written in HACCP plan.						
21. Reassessed adequacy of the HACCP plan.]	Part F -	Inspection Requirements	
Records documenting: the written HACCP plan, monitoring critical control points, dates and times of specific event oc	of the currences.	X	49.	Government Staffing		
Part C - Economic / Wholesomeness			50.	Daily Inspection Cover	age	
23. Labeling - Product Standards			51.	Enforcement		X
24. Labeling - Net Weights			-			
25. General Labeling			52.	Humane Handling		
26. Fin. Prod Standards/Boneless (Defects/AQL/Pork Skins/M	loisture)		53.	Animal Identification		
Part D - Sampling Generic <i>E. coli</i> Testing			54.	Ante Mortem Inspection	n	
27. Written Procedures		0	55.	Post Mortem Inspection	on	
28. Sample Collection/Analysis		0	 		- Line Control of the	nonte.
29. Records		0		Part G - Other Reg	ulatory Oversight Requiren	nents
Salmonella Performance Standards - Basic Requ	uirements		56.	European Community	Directives	0
30. Corrective Actions		0	57.	Monthly Review		
31. Reassessment		0	58.			
32. Wržten Assurance		0	59.			

Est.#: TIF 281 Especialidades Tipicas Mexicanas - Thermally Processed, Commercially Sterile (Canned Product)

City and Country: Las Verduras Esprititu Santo Jilitzingo Edo De Mexico

Date: 06/30/2005

The establishment was currently not producing any product for export to the US.

- 22/51 Corrective actions associated with CCP for can specifications as stated in HACCP plan did not address all four parts of 9 CFR 417.3(a).
- Ball valves at the bottom of the cooking and receiving vessels, which also connected the containers via rubber hose, were cleaned utilizing a clean-in-place (CIP) cleaning procedure. The establishment management stated that they disassemble the pipes every 6 months for visual examination. Neither the CIP procedure nor the visual inspection were included in the written SSOP program {9CFR 416.14 and 416.4(a)}.
- The lavatories for employees were not provided with toilet paper rolls {9CFR 416.2(h)}.

61. NAME OF AUDITOR

Dr. Alam Khan

62 AUDITOR SIGNATURE AND DATE

THE TOR DR ALAM KHA

CK 13-105

United States Department of Agriculture Food Safety and Inspection Service

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE	3. ES	TABLISHMENT NO.	4. NAMÉ OF COUNTRY	
Master Meat, S.A. de C.V.	07/04/2005	T	IF 300	Mexico	
	5. NAME OF AUDIT	OR(S)		6. TYPE OF AUDIT	
Col. Centro, C.P. 67100	D- Alam Vh	02		X ON SITE AUDIT DOCUMEN	UT ALIDIT
Guadelupe, N.L. Mexico	Dr. Alam Kh			ON-SITE ADDIT	TIDUA TV
Place an X in the Audit Results block to indi		oliano	e with requirem	nents. Use U if not applicable	
Part A - Sanitation Standard Operating Procedures (SS Basic Requirements	SOP) Audit Results	5		art 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) Ongoing Requirements			Part E	- Other Requirements	
10. Implementation of SSOP's, including monitoring of implement	ation.	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	s and Pest Control	-
13. Daily records document item 10, 11 and 12 above.		39.	Establishment Constru	ction/Maintenance	1
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			Light		
14. Developed and implemented a written HACCP plan.		41.	Ventilation		-
15 Contents of the HACCP list the food safety hazards.		42.	Plumbing and Sewage		
critical control points, critical limits, procedures, corrective act	ions.	43.	Water Supply		
HACCP plan.		44.	Dressing Rooms/Lava	tories	
The HACCP plan is signed and dated by the responsible establishment individual. Hazard Analysis and Critical Control Point		45.	Equipment and Utensi	ils	
(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 (Control	
20. Corrective action written in HACCP plan.				l	
21. Reæssessed adequacy of the HACCP plan.			Part F -	Inspection Requirements	
22. Records documenting: the written HACCP plan, monitoring o critical control points, dates and times of specific event occur	of the X	49	Government Staffing		
Part C - Economic / Wholesomeness		50	Daily Inspection Cove	erage	
23. Labeling - Product Standards		51	Enforcement		x
24. Labeling - Net Weights		-	. Humane Handling		
25. General Labeling		32	. Trumane Handing		
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/Moi	isture)	53	. Animal Identification		
Part D - Sampling Generic <i>E. coli</i> Testing	i mente de constitución de con	54	. Ante Mortem Inspection	on	
27. Written Procedures	0	55	. Post Mortem Inspection	on	
28. Sample Collection/Analysis	0				
29. Records	0	7	Part G - Other Reg	gulatory Oversight Requirements	
			European Community	Directives	0
Salmonella Performance Standards - Basic Requi	rements			Diectives	
30. Corrective Actions	0	57	. Manthly Review 		
31. Reassessment	0	58			
32. Written Assurance	0	59			

United States Department of Agriculture Food Safety and Inspection Service

Foreign Establishment Audit Checklist

		1	3. ESTABLISHMENT NO.	4. NAME OF COUNTRY		
1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE			Mexico		
Elaboradora La Esperanza, S.A. de C.V.	07/05/2005		TIF 304			
Euloglo Reyes No. 435	5. NAME OF AUDIT		₹(S)	6. TYPE OF AUDIT		
Bellavista, C.P. 65270 Sabinas Hilalgo Nuevo Leon, Mexico	Dr. Ala	am Khar	ı	X ON-SITE AUDIT DOCUME	TIDUA TI	
Place an X in the Audit Results block to ind	icate non	compli	ance with require	ements. Use O if not applicable.		
Place an X in the Audit Results block to ind	Cate Hot	,	41100 141111111111111111111111111111111	Part D - Continued	Audit	
Part A - Sanitation Standard Operating Procedures (SSOP) Basic Requirements		Audit Results	Economic Sampling 33. Scheduled Sample		Results	
7. Written SSOP						
Records documenting implementation.			34. Species Testing			
Records documenting implementation. Signed and dated SSOP, by on-site or overall authority.			35. Residue			
9. Signed and dated SSOP, by directed overlain administration Standard Operating Procedures (SSOP)			Part E - Other Requirements			
Ongoing Requirements						
10. Implementation of SSOP's, including monitoring of implementation.			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.			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			40. Light			
Point (HACCP) Systems - Basic Requirements 14. Developed and implemented a written HACCP plan.			41. Ventilation			
45 Contents of the HACCP list the food safety hazards.	tions	-	42. Plumbing and Sewage			
16. Records documenting implementation and monitoring of the 17. The second security implementation and monitoring of the second security in the second security is security in the second security in the second security in the second security is security in the second security in the second security is security in the second security in the second security is security in the second security in the second security is security in the second security in the second security is security in the second security in the second security is second security in the second security in the second security is securit	critical control points, critical limits, procedures, corrective actions.		43. Water Supply			
HACCP plan. 17. The HACCP plan is signed and dated by the responsible			44. Dressing Rooms/Lavatories			
establishment individual.			45. Equipment and Utensils			
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 Control			
20. Corrective action written in HACCP plan.			Part F - Inspection Requirements			
21. Reassessed adequacy of the HACCP plan.			Part F - Inspecton Requirements			
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.			49. Government Staffing			
Part C - Economic / Wholesomeness			50. Daily Inspection Coverage			
23. Labeling - Product Standards			51. Enforcement			
24. Labeling - Net Weights	24. Labeling - Net Weights		52. Humane Handling			
25. General Labeling	General Labeling					
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/M	oisture)		53. Animal Identificati	on		
Part D - Sampling Generic <i>E. coli</i> Testing			54. Ante Mortem Insp	ection		
27. Written Procedures		0	55. Post Mortem Insp	ection		
28. Sample Collection/Analysis	28. Sample Collection/Analysis		Part G - Other	Regulatory Oversight Requirements		
29. Records		0	Pair G 2 Other	regulatory evolety.		
Saimonella Performance Standards - Basic Requirements			56. European Commu	nity Directives	0	
30. Corrective Actions		0	57. Manthly Review			
31. Reassessment		0	58.			
32. Written Assurance		0	59.			
					-	

Est.#: TIF 300 Master Meat, Processing (Raw Not Ground)

City and Country: Guadalupe, Mexico

Date: 07/04/2005

The calibration records were missing several verification entries; the establishment attributed the finding to an unfilled position at the plant, {9CFR 417.4(a) (3)}.

Either all findings were corrected on the day of audit or SENASICA officials indicated they would initiate a plan of actions to ensure that the establishment complies with all appropriate USDA, FSIS regulations.

62. AUDITOR SIGNATURE AND DATE

tor Dr. KHAN

Est. TIF-304 - Processing Establishment

City and Country: Sabinas Hilalgo Nuevo Leon, Mexico

Date: 07/05/2005

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

61. NAME OF AUDITOR

Dr. Alam Khan

62 AUDITOR SIGNATURE AND DATE

United States Department of Agriculture Food Safety and Inspection Service

Foreign Establishment Audit Checklist

		I HAME OF COUNTRY		
I. ESTABLISHMENT WINE TO LOST THE	2. AUDIT DATE	3. ESTABLISHMENT NO. 4. NAME OF COUNTRY Mexico		
Mantequera San Jose S.A. de C.V.	07/06/2005	111 310		
	. NAME OF AUDITO	DR(S) 6. TYPE OF AUDIT		
Col. Scop, C.P. 67190	Dr. Alam Kha	an X ON-SITE AUDIT DOCU	MENT AUDIT	
Cd. Guadelupe, N.L. Mexico				
Place an X in the Audit Results block to indic	cate noncomp	liance with requirements. Use 0 if not applicat	Audit	
Part A - Sanitation Standard Operating Procedures (SSOP)		Economic Sampling	Results	
Basic Requirements 7. Written SSOP		33. Scheduled Sample		
		34. Species Testing		
8. Records documenting implementation.		35. Residue		
9. Signed and dated SSOP, by on-site or overall authority. Sanitation Standard Operating Procedures (SSOP)		Part E - Other Requirements		
Ongoing Requirements		Part E - Other Requirements		
10. Implementation of SSOP's, including monitoring of implementation.		36. Export		
11. Maintenance and evaluation of the effectiveness of SSOP's.		37. Import		
12. Corrective action when the SSOPs have falled 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		
Part B - Hazard Analysis and Critical Control		40. Light		
Point (HACCP) Systems - Basic Requirements 14. Developed and implemented a written HACCP plan.		41. Ventilation		
15 Contents of the HACCP list the food safety hazards.	X X	42. Plumbing and Sewage		
critical control points, critical limits, procedures, corrective active. 16. Records documenting implementation and monitoring of the	Ulis.	43. Water Supply		
HACCP plan. 17. The HACCP plan is signed and dated by the responsible		44. Dressing Rooms/Lavatories		
establishment individual.		45. Equipment and Utensils		
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 Control		
20. Corrective action written in HACCP plan.		Part F - Inspection Requirements		
21. Reæsessed adequacy of the HACCP plan.		Part F - Inspection Requirements		
 Records documenting: the written HACCP plan, monitoring of the oritical control points, dates and times of specific event occurrences. 		49. Government Staffing		
Part C - Economic / Wholesomeness		50. Daily Inspection Coverage		
23. Labeling - Product Standards		51. Enforcement	X	
24. Labeling - Net Weights		52. Humane Handling	0	
25. General Labeling				
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pαk Skins/Moi	sture)	53. Animal Identification	0	
Part D - Sampling Generic <i>E. coli</i> Testing	c) + special (see	54. Ante Mortem Inspection	0	
27. Written Procedures		55. Post Mortem Inspection	0	
28. Sample Collection/Analysis		Part G - Other Regulatory Oversight Requirements	s	
29. Records		Part G - Other Regulatory Oversign Programment		
Salmonella Performance Standards - Basic Requi	rements	56. European Community Directives	0	
30. Corrective Actions	0	57. Mathly Review	ļ	
31. Ræssessment	0	58.		
	0	59.	i	
32. Written Assurance				

Est. TIF-316 - Mantequera San Jose, Processing Establishment

City and Country: Guadelupe, N.L. Mexico

Date: 07/05/2005

- 15/51 1. Returned product was not included in the flow chart or considered in the hazard analysis, {9CFR 417.2 and 417.8}.
 - 2. The critical limit at CCP 1 for receiving raw meat products had been set for 4°C, however per HACCP plan, in case of deviation the affected product could reach a temperature as high as 7C°, before a corrective action would be employed to bring the CCP under compliance, {9CFR 417.3}.

SAGARPA officials leading the audit fully concurred with the findings and assured the auditor that the establishment complies with all appropriate regulations FSIS regulations.

61. NAME OF AUDITOR

Dr. Alam Khan

62. AUDITOR SIGNATURBAND DATE

FOR DIR ALIAM

KHAN

__ / _ | _ _ _ _

United States Department of Agriculture Food Safety and Inspection Service

Foreign Establishment Audit Checklist

1. ESTABLISHMENT NAME AND LOCATION	2. AUDIT DATE		3. ESTABLISHMENT NO.	4. NAME OF COUNTRY	
Master Meat, S.A. de C.V.	07/01/2005		TIF 367	Mexico	
Rastro	5. NAME OF	AUDITO	₹(\$)	6. TYPE OF AUDIT	
CADEREYTA, JIMNEZ	72 41	771	_	X ON SITE AUDIT DOCUMEN	· · · · · · · · · · · · · · · · · · ·
N.L MEXICO CP 67450	Dr. Ala		ON-SITE ADDIT		
Place an X in the Audit Results block to in		compli	ance with requirem	nents. 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		
Records documenting implementation.			34. Species Testing		0
9. Signed and dated SSOP, by on-site or overall authority.			35. Residue		ļ
Sanitation Standard Operating Procedures (SSOP) Ongoing Requirements			Part E - Other Requirements		
10. Implementation of SSOP's, including monitoring of implementation	entation.		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.			38. Establishment Grounds and Pest Control		
13. Daily records document item 10, 11 and 12 above.		X	39. Establishment Construction/Maintenance		
Part B - Hazard Analysis and Critical Control Point (HACCP) Systems - Basic Requirements			40. Light		
14. Developed and implemented a written HACCP plan .			41. Ventilation		
15. Contents of the HACCP list the food safety hazards, critical control points, critical limits, procedures, corrective actions.		Х	42. Plumbing and Sewage		
Records documenting implementation and monitoring of the HACCP plan.			43. Water Supply 44. Dressing Rooms/Lavatories		
The HACCP plan is signed and dated by the responsible establishment individual.			45. Equipment and Utensils		
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 Control		
20. Corrective action written in HACCP plan.			Dort E. Increation Possimments		
21. Reassessed adequacy of the HACCP plan.			Part F - Inspection Requirements		
22. Records documenting: the written HACCP plan, monitoring of the critical control points, dates and times of specific event occurrences.			49. Government Staffing		
Part C - Economic / Wholesomeness			50. Daily Inspection Coverage		
23. Labeling - Product Standards			51. Enforcement		x
24. Labeling - Net Weights			52. Humane Handling		
25. General Labeling			52. Humane Handing		
26. Fin. Prod. Standards/Boneless (Defects/AQL/Pork Skins/N	Moisture)		53. Animal Identification		
Part D - Sampling Generic <i>E. coli</i> Testing			54. Ante Mortem Inspection	on	
27. Written Procedures			55. Post Morten Inspection		
28. Sample Collection/Analysis		Х			
29. Records			Part G - Other Reg	gulatory Oversight Requirements	
Salmonella Performance Standards - Basic Requirements			56. European Community	Directives	0
30. Corrective Actions		:	57. Monthly Review		<u> </u>
31. Reassessment			58.		
32. Written Assurance		:	59.		<u> </u>

Est.#: TIF 367 Master Meat

Operation: Slaughter Caprine/Ovine

City and Country: Cadereyta Jimenez, NL Mexico

Date: 07/01/2005

- 15/51 1) The establishment is using an FDA approved anti-microbial intervention step prior to the carcasses being placed in the cooler. This step was not included in the flow chart or hazard analysis. {9CFR 417.2(a) (1) & (2)}.
 - 2) Returned product was not included in the flow chart or considered in the hazard analysis, {9CFR 417.2(a)(1)&(2)}. The establishment will reassess the HACCP plan to correct the noncompliance.
- The establishment is conducting generic *E. coli* testing as outlined in CFR 310.25, except for developing a statistical process control (SPC), although the plant did have all test results that had been conducted for the last several months. 9 CFR 310.25 (a)(2)(ii). The establishment management assured the SAGARPA official that they develop the SPC immediately.
- Non-dripping beaded condensate was observed in the cooler over the caprine carcasses. The SAGARPA officials leading the audit retained all products and rejected the cooler. The management corrected the noncompliance while the audit was still in progress. No product was affected {9 CFR 416.4(d) and 416.14}.
- Corrective action records did not included all three parts of corrective action for some deficiencies documented in the records. 9CFR. 416.15(b). The establishment assured compliance to SAGARPA officials.

61. NAME OF AUDITOR

Dr. Alam Khan

62. AUDITOR SIGNATURE AND DATE

Too De-ALAM

07/01/05

[SEAL]
United States of Mexico
Ministry of Agriculture, Livestock, Fish, and Food Products

National Agri-Food Health and Quality Service General Safety Office for of Agriculture and Food Production, Aquaculture, and Fisheries

Memorandum BOO.04.00.01.01

6024

Mexico City, November 30 of 2005

Ms. Sally White,
Director
International Equivalence Staff
Office of International Affairs
1400 Independence Avenue, SW
20250 Washington, D.C.

I am writing in reference to the final audit report for the System Type Federal Inspection (TIF), which was carried out, from June 28 to July 14, 2005 by the Food Safety and Inspection Service (FSIS) of the United States Department of Agriculture (USDA).

In that regard, I would like to inform you of the measures taken in response to the comments described in the "Draft Final Audit Report" applied to each one of the audited establishments:

TIF Establishment No. 74 "Frigorifico Kowl, S.A. de C.V."

Comment

20/51 The corrective measures taken after the deviation in a PCC of the HACCP slaughtering plan for the establishment do not comply with all the requirements of 9 CFR 417.3a.

Response

Upon receiving this comment, the changes to the matrix were made, incorporating the four actions mentioned in 9 CFR 417.3, and the staff were trained.

Comment

22/51 The following violations were found in the HACCP logs:

-Real times, temperatures, or other quantifiable variables for results of monitoring activities are not recorded. None of the entries for these logs includes the signature or initials of the establishment employee that made it. (9 CFR 417.5)

Response

Upon receiving this comment, the changes were made to the logs, incorporating the actions mentioned in 9 CFR 417.5, (a) 3, and the staff was trained.

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TIF Establishment No. 89 "Productos Chata, S.A. de C.V."

Comment

22/51 The logs do not contain the results for the completed activities described in 9 CFR 417.5 a 3

Response

The logs for product sterilization were modified to reinforce monitoring of critical control points, information, and times at when specific events occurred.

TIF Establishment No. 90 "Intercarnes, S.A. de C.V."

Comment

10 In the sausage packing area, a cleaning employee was discovered who had been picking up the casing in which the sausage had been cooked from the floor, and then touching contact surfaces (bag in which reprocessed material is disposed of) 9 CFR 416.13

Response

Feedback was given to staff on Manufacturing Best Practices for their particular areas of work.

Comment

12/51 Corrective measures focused on the handling of products contaminated by cleaning to prevent product contamination and adulteration.

Response

Preventive measures are included in the follow-up and implementation logs for the Standard Sanitization Operations Program (POES).

Comment

22/51 A request was made to establish a method for recording dates and times related to the verification activities regarding the revision of monitoring logs 9 CFR 417.5 a.

Response

The time of revision was attached to the monitoring format by the verifying party, and the verification format includes comments or observations arising from the verification.

Comment

39 Deteriorated steam extraction ducts for the ham and sausage cooking pans Response

They were cleaned and the establishment will avoid the accumulation of detritus.

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TIF Establishment No. 95 "Unión Sanitaria de Productos Alimenticios, S.A. de C.V."

Comment

22/51 The establishment could not make the decision or document the selection of the PCC for raw non-ground product. The establishment selected the critical limit for the ambient temperature for the warehouse room in two different steps (PCC2 and PCC3). Therefore, there was no documentation to support this decision.

-The HACCP logs do not document the results for all the 9 CFR 417.5 a 3 activities carried out.

Response

The company's HACCP plan was modified in the following manner: Flowchart, Master sheet, risk analysis and PCC monitoring formats taking into account the 9 CFR 417.5 a 3.

TIF Establishment No. 105 "Ganaderia Integral SK, S.A. de C.V."

Comment

10/51 Water was observed leaking from a pipe in the roof above the inspection area and the zero tolerance station over a carcass that was passing through this area. The SAGARPA official carrying out the audit stopped the carcass on the rail and also the carcasses for the whole shift that were in the cooling chamber, and gave instructions for the company to take immediate corrective measures.

Response

The water leak was repaired the same day, and all the carcasses of that shift up until the time of the deviation were inspected properly and sanitized completely and were then released by official SAGARPA personnel. A program of inspection and replacement of all the pipes in the processing area was carried out as well.

Comment

13/51 Some POES logs do not include preventive measures. The SAGARPA officials ensured the auditors that the company would shortly be in compliance.

Response

The immediate corrective action taken was the description of the preventive measures in the logs and training of staff regarding the importance of these measures.

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TIF Establishment No. 120 "Sukarno Producción, S.A. de C.V."

Comment

20/51 The corrective measures taken at the deviation from the PCC3 b critical limit, which occurred on June 28 2005, were not written down in the HACCP logs of the establishment's HACCP slaughter plan.

Response

As a preventive measure, the following phrase appears in the PCC3 b monitoring log: "When a temperature in excess of 39.2 F is recorded within a period of less than one hour, describe the cause in the log's comment section; in the event that this temperature does not decrease, implement the corresponding corrective measure and attach to this log the report for the corrective measure, and staff were trained.

TIF Establishment No. 152 "Grupo Porcicola Mexicano, S.A. de C.V."

Comment

12/51 The corrective measures in the establishment's POES logs in response to violations identified do not include preventive measures. 9 CFR 416.15

Response

The format was modified to comply with the requirements 9 CFR 416.15

Comment

18/51 The PCC 1 monitoring (0 tolerance) was not carrying out the monitoring procedure for this PCC in the manner described in the HACCP slaughter plan 9 CFR 417.2 Response

The person responsible for monitoring was trained in carcass inspection techniques, and the platform utilized to inspect carcasses was modified to facilitate inspection of the complete carcass.

Comment

20/51 The corrective measures documented in the logs associated with the establishment's HACCP slaughter and non-ground raw product plan did not comply with the requirements. 9 CFR 417.3

Response

The format was modified to comply with the requirements 9 CFR 417.3

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Comment

22/51 The following findings did not comply with the 9 CFR 417.5 requirements:

- -The establishment was not able to provide documents to support its decision to establish critical limits for the PCC of its HACCP plan for non-ground raw products.
- -The establishment's monitoring logs for the HACCP slaughter plan do not include the real time when the monitor or the result of the monitoring activity.
- -The logs associated with the establishment's HACCP plan for non-ground raw products did not include the results for verification activities carried out, the real times at which these specific events occurred, or the initials of the persons responsible for carrying out such verification activities.
- -The pre-shipping logs did not include documentation that showed the conclusion of the measures taken at the establishment to ensure that all critical limits were met and that all corrective measures taken were adequate.

Response

- -The PCC were redefined according to 9 CFR 417.5 and the critical limits were supported with the corresponding scientific literature available.
- -Staff was trained to record the real time of the monitoring activity.
- -The formats were modified to include the results of verification activities, real times, and initials of the responsible parties.
- -The format was modified to include the documentation that shows the conclusion of the measures taken to ensure that critical limits are met, and that the corrective measures taken are adequate.

Comment

39/51 Rust was noted along the upper chain of the slaughter line and in the three carcass chambers. 9 CFR 416.2

Response

The chamber and carcass chain was cleaned and rustproofed, and on the slaughter line the chain was replaced with a new one.

Comment

41/51 Condensation was noted on the roof of the three carcass chambers, ceiling, aerial tubing, two parts of the chain and in another structure above an adjacent corridor next to the entrance of these chambers. 9 CFR 416.2

Response

Fans were installed in order to generate ventilation sufficient to reduce the condensation. Thermal insulation of some refrigeration pipes was replaced. Heating elements were installed in the evaporation pans of the carcass chambers. The frequency of condensation removal was increased through use of a sanitized sponge.

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TIF Establishment No. 158 "Sigma Alimentos Centro, S.A. de C.V." (Atitalaquia Plant) Comment

13/51 The logs for the POES corrective measures do not include the 9 CFR 416.15 preventive measures

Response

The cleaning log format was updated to include preventive measures.

Comment

22/51 The calibration logs do not include the event dates and some fields are not initialed 9 CFR 417.5 b

Response

The thermometer verification procedure was modified.

Comment

46 Boxes of packing material stored on the floor of the refrigeration chamber. The official SAGARPA inspectors rejected the boxes and requested that plant administration take immediate action. 9 CFR 415.4.

Response

They were immediately removed; the packing material that had been in direct contact with the floor was discarded in the trash. The procedure was modified, indicating the corresponding activity.

Comment

46/51 Condensation was noted dripping from a hose towards a box that contained approximately 10 to 15 packages of sausage for re-processing. There was no product exposed to the condensation. A PVC tube that runs along the upper portion of the same area was covered with a layer of dust measuring approximately ¼ " thick. 9 CFR 416.4 and 416.13.

Response

The tubing, walls, and ceilings in the pasteurizing area were cleaned.

TIF Establishment No. 209 "Alimentos Sigma Conagra Foods, S.A. de C.V."

48/51 –1) The equipment cleaning area does not have a separation distinguishing between clean and unclean equipment pieces.

2) Two of the hand-washing stations do not have paper towel or trash receptacles. The management corrected this deficiency immediately. Response

- 1) The clean equipment area was clearly marked separate from the dirty equipment.
- 2) Immediate corrective measures.

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Comment

19/51 1) The sampling methodology identified in the documentation does not support the sampling methodology used in Salmonella analysis for RTE products as part of the verification procedures.

2) The establishment chose alternative 3 to control Lm through a program of sanitization and testing of the surfaces in contact with the food product.

Nevertheless, the program does not explain why the frequency of testing is sufficient, although according to the logs they carry out sampling on a daily basis.

Response

- 1) The methodology described in the program was implemented
- 2) There is a microbiological analysis that supports and confirms the certainty afforded by complying with said procedures.

Comment

22/51 Some HACCP verification logs do not have log entries 417.5 b

Response

Verification personnel were retrained to assure there are no doubts as to the importance of the plan verification (review of logs, direct observation, and taking of measurements).

TIF Establishment No. 281 (Especialidades Típicas Mexicanas, S.A. de C.V."

22/51 The PCC corrective measures in the HACCP plan do not completely specify the four points in the 9 CFR 417.3 a.

Response

The log forms were corrected clearly and completely with the 3 corrective action activities described in the 9 CFR 417.3 a. Staff were trained regarding this point.

Comment

11/51The procedure for cleaning the tubing for the lard-dispensing pot, which is done every 6 months, is not specified, nor is the visual inspection in the POES program in accordance with the 9 CFR 416.14 and 416.4 (a).

Response

The POES includes the complete procedure for the lard-dispensing pot, which includes disassembling the tubing in order to perform the required cleaning, as well as including it on the inspection log when this procedure is carried out.

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TIF Establishment No. 300 "Carnes Viba, S.A. de C.V."

Comment

22/51 The calibration logs were losing several verification entries. The findings were attributed to the fact that they had been improperly filled out by the establishment 9 CFR 417.4 (a) 3.

Response

Staff in charge of verification was trained.

TIF Establishment No. 304 "Elaboradora la Esperanza, S.A. de C.V."

Comment

None.

TIF Establishment No. 316 "Mantequera San Jose, S.A. de C.V." Comment

15/51 1) The flow chart does not include product return and is not taken into consideration in the risk analysis. 9 CFR 417.2 and 417.8

- 2) The PCC 1 critical limit for receiving raw materials (raw meat) was 4 degrees
- C. However, according to the HACCP plan, in case of deviation the affected product may reach a temperature of as high as 7 degrees C before corrective measures are taken. 9 CFR 417.3.

Response

- 1) Product return was included in the flow chart and in the risk analysis.
- 2) The risk was analyzed and in our opinion it was not a PCC, only a PC.

TIF Establishment No. 367 "Master Meat, S.A. de C.V."

Comment

- 15/51 1) The establishment is using an anti-microbial product approved by the FDA to treat the carcasses prior to the refrigeration chambers. This step is not included in either the flow chart or the risk analysis.
 - 2) Product which has been returned is not included on either the flow chart or the analysis 9 CFR 417.2 (a) (1) and (2)

Response

- 1) The application of the anti-microbial to the carcasses before entering the refrigeration chambers has been included in both the flow chart and the risk analysis.
- 2) The return of product has been included in both the flow chart and the risk analysis.

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Comment

28/51 The establishment is conducting generic *E. coli* in accordance with CFR 310.25, except they still need to develop a control of the statistical process (SPC), even though the plan had all the results for the test that they had directed over the last few months. 9 CFR 310.25 (a) (2) (ii)

Response

The results for the generic *E. coli* sampling were incorporated into a statistical procedure control graph.

Comment

46 Condensation was noted above the caprine carcasses in the refrigerator. The establishment corrected the problem before the audit was finished. No product was affected. 9 CFR 416.4 (d) and 416.14

Response

Immediate corrective action regarding the condensation and the process was included in the risk analysis.

Comment

13/51 The logs recording corrective measures do not include the three parts mentioned 9 CFR 416.15 (b).

Response

The three parts mentioned in the 9 CFR 416.15 (b) were included in the logs, in the reports as well as the logs.

I would like to take this opportunity to send you my warmest regards.

SINCERELY

"EFFECTIVE SUFFAGE, NOT RE-ELECTION"

THE DIRECTOR GENERAL

[Signature]

QFB. AMADA VELEZ MENDEZ

[Seal: SENASICA, General Safety Office

for of Agriculture and Food Production, Aquaculture, and Fisheries, Dec. 6 2005

SENT

DOCUMENTATION IN TRANSIT MUNICIPALITY No. 372 BENITO JUAREZ, C.P.]

Cc: Dr. Javier Trujillo Arriaga, Director in Chief of SENASICA, [illegible] SENASICA C. Suzanne E. Heinen, Counsel Minister for Agriculture and Livestock Affairs MVZ. Gustavo Lara Herrera, Assistant Director for TIF Establishment Certification MVZ. Juan Manuel Moran Vazquez, TIF Establishment and Livestock Auction Supervisor in Hidalgo