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Establishment M20575-P20575-V20575 NRs

Procedures: All Period: 11/01/1998 - 9/11/2013

NR#	Date	Proc.	Res.	Regs	ReportTo	Notified	Appeal	Description
10-2004-4790	12/29/2004	03C01	F		Steve Rains	Steve Rains		At approximately 0845 hours, this morning, while performing duties associated with the verification of compliance with regulatory requirements concerning records associated with raw-not ground product (03C01 Recordkeeping/Recordkeeping), I observed the following noncompliance. The times entered in the verification section were at least twenty minutes after the monitoring procedure had taken place. As the listed verification activity this date was direct observation (DO) of the monitoring procedure, this is a non-compliance with 9CFR 417.5 (3)(b), which requires that the entries be made at the time of the observation. The subsequent 03C02 procedure revealed that all critical limits had, indeed, been met for the most recently processed lot of inspected product. I first spoke with Mrs. Lori Baker (whose initials on the document indicated that she had been the employee conducting the verification activity) about the situation, then with Mr. Steve Rains. I was informed, by both parties, that the time listed on the paperwork was the time that the form had been completed, not the time that the observations had been made. I then reminded them of the aforementioned regulatory requirement. A review of NRs issued at this establishment reveals no NRs issued for similar cause. It is the opinion of this inspector that no further action is warranted at this time. However, repetitive non-compliance with regulatory requirements would support further regulatory and/or administrative actions. This document serves as written notification, to establishment management of their right to appeal.
1-	2/9/2005	01B02	C		Steve	Steve		At approximately 0900 hours this morning, while performing duties

2005-4790					Rains	Rains	<p>associated with hands-on verification of pre-operational sanitation procedures (01B02), I observed fat and a greasy residue on the weasand rod. As the surfaces on which these substances were found was a product contact surface, I immediately informed Mr. Steve Rains of the condition, and advised him that regulatory control action (rejection of this piece of equipment pending satisfactory re-inspection) would be initiated. The weasand rod was re-inspected and released at approximately 0910 hours. A review of establishment documentation concerning pre-operational sanitation revealed no similar finding. NR # 09-2004-4790 dated 10/28/2004 was issued for similar cause. Page 4 of your SSOP requires that all equipment be cleaned prior to the start of operations. 9CFR 416.13 (c) requires that the implementation of the pre-operational sanitation procedures be monitored. It is the opinion of this inspector that no further action is warranted in this matter. However, repetitive noncompliance with regulatory requirements would support further regulatory and/or administrative actions described in 9CFR 500. This document serves as written notification, to establishment management of their right to appeal.</p>
2-2005-4790	3/30/2005	03J01	E		Steve Rains	Steve Rains	<p>This morning, at approximately 0910 hours, while performing duties associated with the verification of slaughter activities (03J01), I observed the following situation; an entry had been made for the water temperature for variety meats washing at 0900 hours. However, no variety meats had yet been washed this date. 9CFR 417.5 (b) requires that entries on records be made at the time the event occurs. It is reasonable to conclude, from reading page 22 of the HACCP plan for slaughter that it requires the temperature of the water to be measured at the time the product is washed. Mr. Steve Rains was immediately informed of the situation, and that, since no product was involved as of yet, no regulatory action would be taken. A review of HACCP records revealed no other non-compliance. A review of NRs issued at this establishment within the last 12 months revealed no NRs issued for similar cause. The 03J02 procedure could not be performed until tomorrow due to the fact that chilling is a CCP at this establishment. In the opinion of this inspector no further action is warranted. However, repetitive non-compliance with regulatory requirements would support further regulatory and/or administrative actions described in 9CFR 500. This document serves as written notification, to establishment</p>

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4/13/2005

01C02 C

Steve
Rains

Steve
Rains

management, of their right to appeal.

At approximately 1115 hours this morning, while performing duties associated with verification of operational sanitation (01C02) I observed employee Mrs. Deena Hendricks wrapping meat while wearing an exposed wedding ring. The ring was not a band, but a ring with a set, therefore, it is potential source of product contamination (as the employee performing these duties is handling exposed product). Visual inspection of the ring revealed no missing sets, therefore no product action was deemed necessary. Mr. Steve Rains was immediately informed of the situation. Page 5 of the SSOP requires that product be processed in a sanitary environment. 9CFR 416.13 (c) requires the monitoring of the requirements of the SSOP. A review of operational sanitation records revealed no similar occurrences. A review of NRs issued at this establishment within the last 12 months revealed that NR # 8-2004-4790 dated 10/13/2004 was issued for similar cause. Due to the elapsed time between the two NRs, it is the opinion of this inspector that no further action is warranted at this time. However, repetitive non-compliance with regulatory requirements would support further regulatory and/or administrative actions described in 9CFR 500. This document serves as written notification, to establishment management, of their right to appeal.

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6/9/2005

01B01 E

Steve
Rains

Steve
Rains

This morning, at approximately 0910 hours, while reviewing records pertaining to preoperational sanitation of the processing floor (01B01), I observed the following; Preventive measures for a deficiency documented on the morning of 06/08/2005 were listed as "just overlooked". Having just completed a hands on preoperational sanitation inspection, finding no non-compliances, I immediately discussed these findings with Mr. Steve Rains and Mrs. Deena Hendricks. I advised them that 9CFR 416.5 (b) includes measures that prevent recurrence with corrective actions, and that 9CFR 416.6 (a) as well as page 4 of the SSOP require records of the implementation of the SSOP be maintained. A review of NRs issued at this establishment within the last 12 months revealed no similar NRs. The aforementioned hands on preoperational sanitation inspection (01B02) revealed no noncompliance. Therefore, it is the opinion of this inspector that no further action is warranted. However, repetitive noncompliance with regulatory requirements would support further regulatory and/or

5-2005-4790	8/3/2005	03B01	E		Steve Rains	Steve Rains	<p>administrative actions described in 9CFR 500. This document serves as written notification to establishment management of their right to appeal.</p> <p>This morning, at approximately 0900 hours while performing duties associated with the verification of the recordkeeping requirements of the Raw Ground plan (03B01), I discovered that the pages containing the descriptions of the critical control points (CCP's) were missing. The Raw Ground plan was the only plan with this deficiency. Subsequent 03B02 procedure revealed no deficiency. I immediately notified Mr. Steve Rains of the fact that the Raw Ground plan was out of compliance with 9CFR 417.2 (c)(3-7), which states specific requirements with respect to the inclusion of CCP description in every HACCP plan. I was informed that the establishment has each plan stored in the computer, and was shown that, in the computer, these pages are present. A review of NR's issued at this establishment within the last 12 months revealed no NR's issued for similar cause. In the opinion of this inspector no further action is required at this time. However, repetitive non-compliance with regulatory requirements would support further regulatory and/or administrative actions described in 9CFR 500. This document serves as written notification, to establishment management of their right to appeal.</p>
6-2005-4790	9/2/2005	06D01	L		Steve Rains	Steve Rains	<p>This morning, at approximately 0900 hours while performing duties associated with the verification of sanitation performance standards (06D01), specifically, with regard to the outside premises, I observed the following condition; Thick grass and weeds at least 2 feet tall were still growing outside the north end of the building. The grass around the rest of the building had been trimmed. However, the tall grass and weeds in this particular area interferes with the verification of pest control, and, in addition, may provide harborage for said pests. 9CFR 416.2 requires that establishment grounds be maintained in such a way as to prevent interference with inspection and harborage of pests. Mr. Steve Rains was immediately notified of the situation, and advised that the entire establishment would be inspected for evidence of pest and/or rodent activity as a result of this non-compliance. This inspection revealed no such evidence. A review of NRs issued at this establishment within the past twelve months revealed no NRs issued for similar cause. In the opinion of this inspector, no further action is</p>

7-2005-4790

9/20/2005

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David Rains

Steve Rains

warranted at this time. However, repetitive non-compliance with regulatory requirements would support further regulatory and/or administrative actions described in 9CFR 500. This document serves as written notification to establishment management of their right to appeal.

This morning, at approximately 0845 hours, while performing duties associated with the verification of operational sanitation (01C02), I observed the following condition. Employee Ricky Hendricks was cutting meat without a hair net on. He did have a ball cap on, but, in the opinion of this inspector, the length of his hair (to the base of the neck/top of the shoulders) does raise the risk of product contamination to an unacceptable level. Mr. Steve Rains was immediately notified of the situation, and that regulatory control action (not allowing Mr. Hendricks to handle product without a hair net) had been initiated per 9CFR 500.2(a)(1). Subsequent product inspection revealed no evidence of product contamination, therefore, no product action was deemed necessary. While the SSOP does not directly require the use of hair nets, page 4 of the SSOP requires that product be produced in an environment that will reduce the risk of product contamination. 9CFR 416.13 (c) requires the monitoring of the procedures defined in the SSOP. A review of establishment documentation relevant to operational sanitation revealed no similar occurrences. A review of NRs issued at this establishment within the last twelve months revealed that NR# 0003-2005-4790, dated 13/Apr./2005 was issued for similar cause. The amount of time elapsed in concert with the fact that different employees were involved lead this inspector to conclude that no further action is warranted at this time. However, repetitive non-compliance with regulatory requirements would support further regulatory and/or administrative actions described in 9CFR 500. This document serves as written notification, to establishment management of their right to appeal.

8-2005-4790

12/6/2005

01C02

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Steve Rains

Steve Rains

At approximately 1430 hours, this afternoon, while performing duties associated with verification of sanitation requirements associated with custom exempt production (06B01) I observed employee Rusty Hendricks performing custom slaughter operations without a hairnet. In the opinion of this inspector, the length of said employee's hair (to the middle of the neck) is such that it is reasonable to conclude that product contamination may take place.

9-2005-4790

12/20/2005

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416.13(c)

Steve Rains

Mr. Rusty Hendricks

Page 4 of the SSOP requires that product be processed in an environment that will reduce the risk of contamination. 9CFR 416.13 (c) requires the daily monitoring of the methods described in the SSOP. FSIS Directive 5930.1 (V)(A) requires that sanitary requirements for custom production be the same as inspected product. I immediately notified Mr. Steve Rains, as well as employee Hendricks of the situation. I was asked, by Mr. Hendricks if that rule applied to custom production. I replied that sanitary requirements for custom operations are identical to those of inspected production per FSIS Directive 5930.1. As the product being slaughtered was custom, and inspection does not have control authority over such product, the product was not inspected for evidence of contamination. A review of records associated with slaughter sanitation revealed no record of previous occurrences. A review of NRs issued at this establishment within the last 12 months revealed NR# 0007-2005-4790 issued on 09/20/2005 for similar cause. However, the incident recorded on that NR was dealing with inspected product in the processing area, and it is obvious to this inspector that the employee was not informed that custom operations must be conducted with identical emphasis on sanitation as inspected. Therefore, it is the opinion of this inspector that no further action is warranted at this time. However, repetitive noncompliance with regulatory requirements would support further regulatory and/or administrative actions described in 9CFR 500. This document serves as written notification, to establishment management of their right to appeal.

At approximately 0900 hours this morning, while conducting hands on verification of pre-operational sanitation (01B02), I observed fat and protein residue on the long hook/trolleys used on beef fore quarters. As these surfaces are product contact surfaces, I immediately notified establishment employee Mr. Rusty Hendricks that page 04 of this establishments SSOP requires that all tools and utensils to be used during operations are to be clean prior to operations. 9CFR 416.3(c) requires the daily monitoring of said procedures. In addition, Mr. Hendricks was advised that, per 9CFR 500.1(a) & 500.2(a)(1), the regulatory control action of rejection of the kill floor for unsanitary condition had been initiated pending the satisfactory re-inspection of the aforementioned hook/trolleys. As this condition was found prior to the start of operations, there was

1-2006-4790	4/6/2006	03B01	E	417.4(a)(3)	Steve Rains	Steve Rains
2-2006-4790	5/17/2006	06D01	L	416.2(a)	Steve Rains	Steve Rains

no product involved, and, therefore, no product action necessary. A review of establishment documentation relevant to pre-operational sanitation revealed no record of similar incidents. A review of NRs issued at this establishment within the last twelve months revealed that NR # 0001-2005-4790 was issued on 02/09/2005 for similar cause. Due to the amount of time elapsed, it is the opinion of this inspector that no further action is warranted. However, repetitive non-compliance with regulatory requirements would support further regulatory and/or administrative actions described in 9CFR 500. This document serves as written notification, to establishment management of their right to appeal.

This afternoon, at approximately 1300 hours, while performing duties associated with the verification of the recordkeeping component of the regulatory requirements with respect to raw not ground product (03B01), I observed the following deficiencies; Mrs. Lori Baker and Mrs. Delores Place were listed in the HACCP plan as co-HACCP records manager, and packaging manager, respectively. Mrs. Baker, very recently, left employment here, but Mrs. Place has been gone for some time. 9CFR 417.4(a)(3) requires that a reassessment of the HACCP plan take place upon changes that could affect and/or alter the HACCP plan. A change in personnel is listed as such a change. Upon further examination, it was demonstrated that the plan had been reassessed within the last twelve months. Mr. Steve Rains was immediately notified of the situation, and advised that all HACCP plans for this facility need to be kept current. A review of NRs issued at this facility within the last 12 months revealed no NRs issued for similar cause. Therefore, it is the opinion of this inspector that no further action is warranted. However, repetitive non-compliance with regulatory requirements would support further regulatory and/or administrative actions described in 9CFR 500. This document serves as written notification to establishment management of their right to appeal.

This morning, at approximately 0920 hours, while performing duties associated with the verification of sanitation performance standards (06D01) with regard to the outside premises and pest control, I observed tall grass and weeds, some in excess of one foot tall, around the holding pens. This condition is not only unsightly, but; 1) is a possible harborage and/or breeding area for pests, and 2) interferes with the verification of the effectiveness of the

3- 2006- 4839	8/2/2006	06D01	L	416.2(a)	Steve Rains	Steve Rains
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establishments pest control program. 9CFR 416.2 (a) requires that the grounds of a facility be maintained in a manner that does not result in either of the two aforementioned conditions. Mr. Steve Rains was immediately notified of the condition. Subsequent inspection of the rest of the facility revealed no evidence of pest infestation. Subsequent review of NRs issued at this establishment within the last 12 months revealed that NR # 0006-2005-4790 was issued for similar cause on 09/02/2005. Due to the amount of time elapsed between the two incidents, it is the opinion of this inspector that no further action is warranted at this time. However, repetitive non-compliance with regulatory requirements would support further regulatory and/or administrative actions described in 9CFR 500. This document serves as written notification, to establishment of their right to appeal.

At approximately 0800 when I arrived at the Establishment to conduct slaughter inspection, I noticed that the weeds on the west side of the building were 2-3 feet high. I informed Steve Rains that they needed to be mowed in order to prevent pest and rodent harborage. Regulation 416.2(a) states that "The grounds about an establishment must be maintained to prevent conditions that could lead to insanitary conditions, adulteration of product, or interfere with inspection by FSIS program employees."

4- 2006- 4790	10/6/2006	03C02	E	417.2(c)	Steve Rains	Steve Rains
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At approximately 0830 while performing unscheduled procedure task 03C02 I found the following noncompliance. The plant HACCP plan for Raw Not Ground, Process Step for Freezer Storage listed Critical Limits: "Internal product temperature is not to exceed 41 degrees F". Improper temperature recorded for freezer storage which should read 23 degrees F according to supporting documentation. The records generated for Hazard Description (B) Biological-Microbial Growth, CCP# 3B for monitoring and verification indicate no temperature exceeded 23 degrees F. The records generated all indicate proper freezer storage temperature and the 41 degrees F listing appears to be a typing error. No product was affected. Mr. Steve Rains and Deena Hendricks were notified of the situation, and advised to reassess the plan for correction. The last reassessment was documented on 4-06-2006. A review of NR's issued at this facility within the last 12 months revealed linkage to NR 01 dated 4-06-2006 for HACCP - Recordkeeping. As a result of this NR plant management response (further planned action)

5-2006-4790	10/27/2006	01B02	D	416.15(a)	Steve Rains	Steve Rains
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indicated closer attention would be paid to the HACCP plans' accuracy and periodic review (i.e. monthly) would be initiated. A repetitive non-compliance with regulatory requirements would support further regulatory and/or administrative actions described in 9CFR 500.

Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP) I. Pre-operational Sanitation - Equipment and Facility Cleaning, 1, b, e, f references equipment debris removal, rinsing and sanitizing daily for food production. The significance of having clean and sanitized equipment is to assure that residues of meat processes from the previous day production are removed from product contact areas and non product contact areas. Both incidents can be a growth medium for the bacteria which are known to be harmful to health. The company agreed to assume the responsibility to ensure their SSOP, as written would be effective in preventing these surface residues from remaining after a thorough clean up and sanitation process. However at approximately 0820 hours after plant pre-operational inspection and prior to start of production while performing procedure 01B02, I observed the following noncompliance. In the processing room: 1. The wrapping table had two 1/4" diameter pieces of meat and fat residue. 2. The stainless steel S hook used to lower sides onto breaking table observed with 50% of surface covered with product residue film. Both these items are direct product contact surfaces. 3. The cable pulley and hook used to hang the stainless steel S hook on was observed with a white film residue from fat. These items are not direct product contact surfaces, but they are directly above a product contact surface and are a source for cross contamination from employee handling the S hook and product. 4. Observed the knife, scraper and steels rack by the wash sink under window with product residue on frame work and hand tools. All hand tools had at least 30% of surface area of handles and product contact surface covered with meat residue film. The rack had product film buildup in and on 75% of indirect product contact surface. This area would lead to direct product contamination with hand tools coming into contact. All areas were placed under regulatory control with US rejected tag #B7730755. Ms. D. Hendricks was notified. Regulatory control was released in production area at 0845 following immediate recleaning and sanitizing. Plant pre-operational sanitation records indicate all

6-2006-4790	12/14/2006	01B02	D	416.15(a)	Steve Rains	Steve Rains, Deena Hendricks	<p>areas mentioned were acceptable. Monitoring during plant pre-op failed to identify these noncompliance issues. This type of unsanitary practice lends itself to possible harmful bacteria, LM species and such.</p>
1-2007-4790	1/17/2007	06D01	P	416.2(a)	Steve Rains	Steve Rains	<p>Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP) I. Pre-operational Sanitation - Equipment and Facility Cleaning, 1, b, e, f references equipment debris removal, rinsing and sanitizing daily for food production. The significance of having clean and sanitized equipment is to assure that residues of meat processes from the previous day production are removed from product contact areas and non product contact areas. Both incidents can be a growth medium for the bacteria which are known to be harmful to health. However at approximately 0810 hours after plant pre-operational inspection and prior to start of production while performing procedure 01B02, I observed the following noncompliance. In the processing room: 1. The cutting board table top on the east side had a 12" x 24" product contact cutting surface area with a brown product buildup that could be flaked off with a finger nail. 2. The well saw used on the breaking table observed with product residue at the base were the motor attaches to the blade. The residue was in approximately 3/4" diameter area. Both these items are direct product contact surfaces. All areas were placed under regulatory control with US rejected tag #B7730756. Ms. D. Hendricks was notified. Regulatory control was released in production area at 0825 following immediate recleaning and sanitizing. Plant pre-operational sanitation records indicate all areas mentioned were acceptable. Monitoring during plant pre-op failed to identify these noncompliance issues. This type of unsanitary practice lends itself to possible harmful bacteria, LM species and such.</p> <p>While performing a scheduled 06D01 procedure for establishment grounds and facilities standard I randomly selected the task for pest control. At approximately 1300 hours I observed the following non compliance. In the second story storage room on the west side in the north corner a pallet with a plywood top cover elevated off the floor by cement blocks had empty boxes stacked on it along with a electric grill. I observed several mice droppings (20 plus individual feces drops). Upon further investigation I found one other pallet in a similar condition with only 10 dropping on the east stud wall area</p>

2- 2007- 4790	2/7/2007	01B02	C	416.4(a)	Steve Rains	Steve Rains
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of the room. I investigated the entire second story and found no other evidence of droppings. I continued the task on the first floor and found mice droppings behind the southwest display freezer on the chair rail going around behind the freezer unit. These droppings totaled 9. I also observed a dried up plant vine in this area and dust. Ms. Deena Hendricks and Mr. Steve Rains were notified and shown the areas identified. These are the only areas observed in this condition. I found no production areas, products, product ingredients or packaging material affected. I observed bait stations in areas and maintained. I found no outside premises problems nesting or other destruction caused from infestation (gnawing, shredding material, etc...). No regulatory control was applied, because no product or product contact areas were affected. The evidence indicates mice have been present but no insanitary conditions or adulteration of product was found. . The plant has no written pest control plan. SSOP records for pre- and operational sanitation indicated no problems with pest.

Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP) I. Pre-operational Sanitation - Equipment and Facility Cleaning, 1, b, e, f references equipment debris removal, rinsing and sanitizing daily for food production. The significance of having clean and sanitized equipment is to assure that residues of meat processes from the previous day production are removed from product contact areas and non product contact areas. Both incidents can be a growth medium for the bacteria which are known to be harmful to health. The company agreed to assume the responsibility to ensure their SSOP, as written would be effective in preventing these surface residues from remaining after a thorough clean up and sanitation process. However at approximately 0805 hours after plant pre-operational inspection and prior to start of production while performing procedure 01B02, I observed the following SSOP failure for compliance. The processing room: 1. The double door on the right side leading into the processing room was observed with a product residue smears at the upper left corner and 12 inches down on the same side (both 1" x 3" surface area). This is a product contact surface with carcasses coming into contact with the door as they are pushed into the processing room. On the processing side of this door's surface 6 small particles of product residue were observed (1/16" up 1/8" diameter in the center to lower section).

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3-2007-4790	3/29/2007	06D01	K	416.2(b)(2)	Steve Rains	Steve Rains
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This is a non-product contact surface area. The kill room: 1. The splitting saw was observed with product residue on 7 saw blade teeth in the center section (1/16" diameter residue). 2. The weasand rod was found with 1" diameter fat residue. Each utensil is a direct product contact surface. All areas were placed under regulatory control with US rejected tag #B7730756. Ms. D. Hendricks was notified in the processing area. Mr. S. Rains was notified about the kill floor and the decision to document SSOP non-compliance. Regulatory control was released in all areas at 0820 following immediate recleaning and sanitizing. Plant pre-operational sanitation records indicate processing area had a problem with a table, but didn't mention the above non-compliance and kill floor identified above mentioned non-compliance with everything else acceptable. Monitoring during plant pre-op failed to identify these noncompliance issues. This type of unsanitary practice lends itself to possible harmful bacteria, LM species and such.

While performing an unscheduled 06D01 procedure for establishment standards I randomly selected construction. At approximately 0840 hours I found panels separating from a wall. The area is a section of wall just outside the east processing room door. The lower 18" of waterproof paneling have a gap opening allowing moisture and residues to go between wall and paneling. This could cause an unsanitary condition, because the area is no long impervious to moisture. Regulations require area such as this to be impervious to moisture to facilitate cleaning and sanitary conditions. No regulatory control was applied, because no product or product contact areas were affected. Mr. Steve Rains was notified and shown the area of concern.

4-2007-4790	4/4/2007	01B02	D	416.15(a)	Steve Rains	Steve Rains
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At approximately 0805 hours after plant pre-operational inspection and prior to start of production while performing scheduled procedure 01B02, I observed the following SSOP noncompliance. In the processing room: 1. The well saw used on the breaking table was observed with product residues on the handle, motor housing, and electrical cord. The residue ranged in size from 5 pieces 1/16" diameter, 3 pieces 1/4" diameter and several blood splatter areas with less than 1/2" diameter. 2. The breaking table top on the side where the well saw hangs was observed with product residue on the edge. This residue consisted of product meat residue 1/2" in diameter. 3. The bag covering the control for the hoist had 50 % of

5-2007-4790	4/25/2007	01B02	D	416.15(a)	Steve Rains	Steve Rains	<p>its surface cover with blood residue. 4. I found two meat trays on the table next to the breaking table with product residue consisting of fat on them. Each one had a 3/8" diameter piece. 5. The hand wash sink bowl had numerous particles of product residue inside around the drain. The particles ranged in size from 1/16" up to 1/2" diameter covering 30% the surface. Items 1, 2, & 4 are product contact surfaces. Item 3 is indirect product contact surface with operator cross contaminating by handling control and raw product. Item 5 is a non product contact surface. All areas were placed under regulatory control with US rejected tag #B7730759. Mr. R. Hendricks and Mr. S. Rains were notified. Regulatory control was released in production area at 0820 following immediate recleaning and sanitizing. Plant pre-operational sanitation records indicate all areas mentioned were acceptable.</p> <p>At approximately 0845 hours after plant pre-operational inspection and prior to start of slaughter while performing scheduled procedure 01B02, I observed the following SSOP noncompliance. In the slaughter room: 1. South wall area at the well saw I found product residue buildup. This area is an indirect product contact surface by contacting the well saw's product contact surface. If left alone a cross contamination issue would exist. The area of the wall of concern is 16" x 36" just below the hook used to hold the well saw. 2. The hand saw was observed with product residue buildup on one side of the saw blade and tip. The area consisted 1/2" x 24" product contact surface area. All areas were placed under regulatory control with US rejected tag #B7730760. Mr. S. Rains was notified. Regulatory control was released in the slaughter area at 0900 following immediate recleaning and sanitizing. Plant pre-operational sanitation records reflect the noncompliance with corrective action.</p>
6-2007-4790	6/13/2007	01B01	C	416.13(c)	Steve Rains	Steve Rains	<p>Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP) I. Pre-operational Sanitation - Equipment and Facility Cleaning, 1, b, e, f references equipment debris removal, rinsing and sanitizing daily for food production. However at approximately 0810 hours after plant pre-operational inspection and prior to start of production while performing scheduled procedure 01B01 for monitoring, I observed the following SSOP noncompliance. In the slaughter area: 1. The well saw used to split carcasses was observed with product residues on the handle, motor</p>

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7-2007-4790	6/26/2007	01B02	D	416.15(a)	Steve Rains	Steve Rains
8-2007-4790	8/15/2007	01B02	D	416.15(a)	Steve Rains	Steve Rains

housing, and electrical cord. The residue ranged in size from 3 pieces 1/16" diameter, 5 pieces 1/4" on product contact surface. 2. The hand saw had product residue on the handle and saw blade. The residue was product based buildup on 50% of product contact surface. 3. The hand wash sink and inspection table both had product based fat residue buildup. The inspection table is a product contact surface with 75% of the product contact surface affected. All areas were placed under regulatory control with US rejected tag #B7730761. Mr. S. Rains were notified. Regulatory control was released in production area at 0845 following immediate recleaning and sanitizing. Plant pre-operational sanitation records identified deficiencies and corrective action taken.

Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP) I. Pre-operational Sanitation - Equipment and Facility Cleaning, 1, b, e, f references equipment debris removal, rinsing and sanitizing daily for food production. However at approximately 0815 hours after plant pre-operational inspection and prior to start of production while performing scheduled procedure 01B02, I observed the following SSOP noncompliance. In the processing area, I observed the tenderizer with 1 piece of 1/8" diameter fat residue on product contact surface of a wire finger protecting the blades. Upon closer observation I found product buildup on 50% of the surface area on right side blade holder and the clear plastic guard covering the blades. The areas mentioned are product contact surfaces. The tenderizer was placed under regulatory control with US rejected tag #B7730762. Mr. S. Rains and Ms. D. Hendricks were notified. Regulatory control was released in production area at 0845 following immediate recleaning and sanitizing. No product was affected. Plant pre-operational sanitation records identified deficiencies and corrective action taken.

Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP) I. Pre-operational Sanitation - Equipment and Facility Cleaning, 1, b, e, f references equipment debris removal, rinsing and sanitizing daily for food production. However at approximately 0820 hours after plant pre-operational inspection and prior to start of production while performing scheduled procedure 01B02, I observed the following SSOP noncompliance. In the slaughter area, I observed the liver table with product residue

9-2007-4790	10/23/2007	06D01	K	416.3(a)	Steve Rains	Steve Rains
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buildup. The area consisted of a 2" x 2" square diameter product fat residue on product contact surface of table top. The liver table was removed from the slaughter area and placed under regulatory control with US rejected tag #B7730763. Mr. S. Rains was notified. The slaughter operation was permitted to start with the removal of the table. Regulatory control was released on the table at 0845 following recleaning and sanitizing in power washer area. The table was placed back in slaughter area. No product was affected. Plant pre-operational sanitation records identified deficiency and corrective action taken.

While performing a scheduled 06D01 procedure for establishment standards I randomly selected construction. At approximately 0840 hours I found the exhaust fan exterior cover missing in the carcass wash room. The cover provides a barrier between the outside environment when the fan is not being used. This could cause an unsanitary condition with no protection from dust and pest entering establishment. Regulations require equipment such as this to be maintained to facilitate cleaning and sanitary conditions. No regulatory control was applied, because no product or product contact areas were affected. Mr. Steve Rains was notified and shown the area of concern.

10-2007-4790	10/31/2007	03J01	E	417.5(b)	Steve Rains	Steve Rains
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While performing a scheduled 03J01 HACCP/Slaughter procedure, I found the following HACCP recordkeeping failure. The establishment had failed to document CCP 6B carcass and variety meat temperatures on Slaughter Log (form R-3) for beef slaughter on 10-24-2007. The HACCP Plan identifies CCP 6B as cooler temperature of carcasses and variety meat with guidelines of 41 degrees F. or less within 36 hours. I reviewed form R-2 which is HACCP CCP 2B for cooler and freezer monitoring and verification document. The documentation recorded on (form R-2) indicated monitoring of the front quarter at 0758 hours with a recorded a temperature of 36 degrees F. and at 1300 hours the hind quarter was monitored at 34 degrees F. all on 10-25-2007 for the carcass in question. The variety meat is stored in cooler 2 and it was checked on the same date at 0802 hours with a temperature reading of 32 degrees F. and 1304 hours with a temperature reading of 32 degrees F.. After reviewing these records I concluded that a failure in recordkeeping was the only noncompliance. No regulatory control was applied, because no product or product contact areas were

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11-2007-4790	11/8/2007	01B02	D	416.15(a)	Steve Rains	Deena Hendricks	<p>affected. Ms Deena Hendricks and Mr. Steve Rains were notified and shown the record.</p> <p>Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP) I. Pre-operational Sanitation - Equipment and Facility Cleaning, 1, b, e, f references equipment debris removal, rinsing and sanitizing daily for food production. However at approximately 0800 hours after plant pre-operational inspection and prior to start of production while performing unscheduled procedure 01B02, I observed the following SSOP noncompliance. In the processing room, I observed four rubber floor mats stacked in the corner by the east entrance door. Each mat had product residue over 30% of the surface area on top and bottom sides. Product residue consisted of pieces ranging in size from 1/4" in diameter to 1" in diameter and fat smears of 2" x 3" area. The mats are a non-product contact surface. They were removed from the processing room and placed under regulatory control with US rejected tag #B7730764. Ms. Deena Hendricks was notified. Regulatory control was released on the mats at 0830 following recleaning and sanitizing in power washer area. The mats were placed back in the processing room. No product was affected. Plant pre-operational sanitation records identified deficiency and corrective action taken.</p>
12-2007-4790	12/19/2007	01B02	D	416.15(a)	Steve Rains	Steve Rains	<p>Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP) I. Pre-operational Sanitation - Equipment and Facility Cleaning, 1, b, e, f references equipment debris removal, rinsing and sanitizing daily for food production. However at approximately 0800 hours after plant pre-operational inspection and prior to start of production while performing scheduled procedure 01B02, I observed the following SSOP noncompliance. In the slaughter area, I observed the power washer wand with product residue buildup on the handle. This is a non product contact item, but a source of cross contamination involving person washing and handling carcasses. I also found trolley hooks with deer hair and grease on the product contact surfaces. In the processing room, I observed product contact surfaces of 3 gray totes with metal rust stains, dried blood spot, and standing water. They were removed from production and recleaned. All items placed under regulatory control with US rejected tag #B7730765. Mr. S. Rains and Deena Hendricks were notified. Regulatory control was released at 0830 following recleaning and sanitizing. No product was affected. Plant</p>

1-2008-4790	1/30/2008	01B02	D	416.15(a)	Steve Rains	Steve Rains	<p>pre-operational sanitation records identified deficiency and corrective action taken.</p> <p>Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP) I. Pre-operational Sanitation - Equipment and Facility Cleaning, 1, b, e, f references equipment debris removal, rinsing and sanitizing daily for food production. However at approximately 0830 hours after plant pre-operational inspection and prior to start of production while performing scheduled procedure 01B02, I observed the following SSOP noncompliance. In the processing area, I observed the meat grinder with product residue buildup inside on bin seams (30% of surface area), inside of overhead cover lid (50% of surface area) and exit deflection shield (50% of surface area). These areas are product contact surfaces. The control buttons and power cord had product residue buildup too. These are non product contact item, but a source of cross contamination involving person operating equipment and handling product. I also found the meat tenderizer blades with a 3/16" diameter piece of meat resting between blades. This is a product contact surface. I observed product residue buildup on 70% of the outer surface of the tenderizer's stainless steel housing including the switch area. The outside is a non product contact surface, but a source of cross contamination involving person operating equipment and handling product. All items placed under regulatory control with US rejected tag #B7730766. Mr. S. Rains and Deena Hendricks were notified. Regulatory control was released at 0915 following recleaning and sanitizing. No product was affected. Plant pre-operational sanitation records identified deficiency and corrective action taken.</p>
2-2008-4790	3/5/2008	01C02	D	416.15(a)	Steve Rains	Deena Hendricks	<p>Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP) II Operational Sanitation - 2. Monitoring and Record Keeping, a Processing Manager ensuring sanitary product handling procedures and cleaning procedures are maintained during a production shift. However at approximately 1030 hours during operational inspection while performing scheduled procedure 01C02, I observed the following SSOP noncompliance. In the F-1 freezer, I observed a clear plastic bag containing pork fat trimming sitting on the freezer floor to the left of entrance door and at the end of the metal rack shelving. The product was labeled inspected pork trimming for deer. I picked the plastic bag up with the pork</p>

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3-2008-4790	3/21/2008	01C01	D	416.15(a)	Steve Rains	Steve Rains
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trimming and found the bag was torn open on the back side with product exposed. I observed 1" by 5" rectangle tear area in the bag with a 1/4" by 3" rectangle area of grayish color product contamination. The item was placed under regulatory control with US rejected tag #B7730767. Ms. Deena Hendricks was notified and shown the product. Ms. Hendricks immediately removed the bag containing the pork trimming and placed it in an inedible container. I released USDA regulatory control at 1045 when Ms. Hendricks condemned the product. I found no other products in this state in the F-1 freezer. I estimated the product condemned weighed 20 lbs. Plant operational sanitation records (FORM D-1) identified deficiency and corrective action taken on this product, but had all acceptable operations recorded on previous days for this week.

Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP) II Operational Sanitation - 2. Monitoring and Record Keeping, a Processing Manager ensuring sanitary product handling procedures and cleaning procedures are maintained during a production shift. However at approximately 1130 hours during operational inspection while performing scheduled procedure 01C01, I observed the following SSOP noncompliance. In the C-1 Cooler, I observed a metal catering pan full of meat juice from a catering job. The pan contained no meat product only cooked residue juices with out any label or identification. On 03-12-2008 this cooler was not functioning properly. The product in the cooler was removed except for the metal pan. At this time Mr. S. Rains informed me that this metal catering pan would be removed and placed in the trash. On 3-21-2008 at 1130 I noticed the same pan in the cooler. Deena Hendricks was notified and the pan was immediately removed and discarded. I found no other problems in the C-1 Cooler. Plant operational sanitation records (FORM D-1) had no failure recorded.

4-2008-4790	3/26/2008	06D01	K	416.2(b)(1)	Steve Rains	Steve Rains
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While performing a scheduled 06D01 procedure for establishment standards I randomly selected construction. At approximately 0830 hours I noticed the main stainless steel door between the main building and the addition housing the slaughter and custom cooler was not latching properly. The catch on the door frame is loose and needs adjustment. This door is a barrier for the heating and cooling of the main building in which carcass fabrication takes place. No regulatory control was applied, because no product, no product

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6-2008-4790	4/28/2008	03B02	E	417.5(a)(2)	Steve Rains	Steve Rains
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contact areas or unsanitary conditions exist at this time. With summer approaching this could lead to a regulatory control status if not corrected. Mr. Steve Rains was notified and shown the door of concern.

On April 23, 2008 during exit meeting Mr. Steve Rains was notified of record keeping HACCP failure. A comprehensive assessment of the execution and design of the establishments food safety systems revealed "monitoring" activities for the Raw not Ground, Raw Ground and Heat Treated not Fully Cooked-but not Shelf Stable HACCP plans, 2B and 3B Temperatures of coolers and freezers. The documentation reflects the time, date, results of the monitoring check and the initials of the monitor according to the frequencies specified in the plans. However, there was no support provided for the "monitoring" frequencies and procedures, because the records reflect a product temperature being recorded and not the ambient temperature of the coolers or freezers, which ambient temperature is identified as the critical limits. In providing no support for their decisions concerning the frequencies of the monitoring checks or their procedures including why weekends and holidays are not being recorded, since products are in the coolers and freezer on weekends and holidays does not meet the requirements of 9 CFR 417.5(a)(2). The "verification" activities for the Raw not Ground, Raw Ground and Heat Treated but not Fully Cooked-not Shelf Stable HACCP plans, 2B and 3B, reflect that results, time, date and initials of the verifier activities are being accomplished at the frequency described, this is for the Direct Observation and Records Review identified in their HACCP plan. The "verification" activity for the calibration of the monitoring devices according to the records reflect the time, date, initials and the results of the calibration requirements at the frequency described in their HACCP plans. However, the establishment provided no support for the "verification" activities frequencies and their procedures according to 9 CFR 417.5(a) (2).

5-2008-4790	4/28/2008	03J02	E	417.5(a)(3)	Steve Rains	Steve Rains
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On April 23, 2008 during exit meeting Mr. Steve Rains was notified of record keeping HACCP failure. A comprehensive assessment of the execution and design of the establishments food safety systems revealed there was no support provided for the frequencies and their procedures concerning the "monitoring" activities pertaining to the Slaughter HACCP plans, 4B and 5B which indicate that once per

7-2008-4839	5/22/2008	06D01	K	314.10 ,416.2 (d)	Steve Rains	David Rains
8-2008-	8/1/2008	06D01	L	416.2(a)	Steve Rains	Steve Rains

production day/one entry for the monitoring the observations of all carcasses pertaining to zero tolerance and the temperature of the Hot Water intervention. In addition, the HACCP plans 5B and 4B fail to describe that when the zero tolerance and temperature checks are accomplished and documented that variety meats are included in those checks. Therefore, the way the documentation of the results are applied, a failure for zero tolerance and the temperature check for the Intervention, would indicate that all carcasses and all of the variety meats would fail since there is only one entry for both carcasses and variety meats for the zero tolerance and Hot Water temperature intervention. In not providing support for their frequencies and procedures, the establishment has failed to fully comply with 9 CFR 417.5(a)(2). For the "verification" activities pertaining to the Slaughter HACCP plans, 4B, 5B and 6B, the establishments verification for the calibration of the monitoring devise provides time, date, results of the calibration and the initials of the verifier. The HACCP plans records for 4B, 5B and 6B indicates the Record Reviews are being accomplished, which include the date, time, results and initials of the verifier. However, the verification activities for direct observation of the monitor activities, has not been accomplished according to the documentation. In addition, the establishment has not provided support for their "verification" activities frequencies and procedures. This is not meeting the requirements of 9 CFR 417.4(a) (2) (ii) and 417.5(a) (2) (3).

While performing a non-scheduled 06D01 procedure at 0920 hours, I noticed condensation in cooler #2. At that time, the cooler contained three USDA slaughtered hog carcasses hanging on the rail along with several hearts and livers place on platters. The platters were located on a shelf near the door. I noticed drips of condensation on the floor. Less than 10% of the rail was affected, nearly all of the walls were moist, while the ceiling was not noticeably wet or moist. The three carcasses were removed from the cooler under regulatory control action and U.S. rejected tag # B3803552 was placed on the cooler door. No product was affected. The tag was removed the next day after the cooler was shut down and the plant stated their plan for corrective actions.

While performing an unscheduled 06D01 procedure for establishment standards, I randomly selected outside premises. At

12395								approximately 0830 hours, while inspecting the grounds, I noticed tall grass growing all along the back side of the establishment. This could be a harbor for rodents and other vermin. No product was affected, therefore no regulatory control action was applied. Mr. Steve Rains was notified and shown the untrimmed tall grass of concern.
9-2008-12395	8/22/2008	06D01	J	416.2(c)	Steve Rains	Steve Rains		While performing an unscheduled 06D01 procedure for establishment standards, I randomly selected lighting. At approximately 0900 hours, I found two burned out florescent bulbs located in the processing room causing the area to be poorly illuminated. I found conditions to be sanitary in the processing room earlier during pre-operational inspection. Since no product was affected and no unsanitary condition was created, no regulatory action was taken. However, conditions have been created that could lead to an unsanitary condition in the future. Mr. Steve Rains was notified.
10-2008-12395	10/15/2008	01B02	D	416.15(a)	Steve Rains	Steve Rains		At approximately 800 hours, in the course of performing an unscheduled 02B01 in the processing room and after plant pre-operational inspection, I observed the following noncompliance: 1) The nylon surface of the breaking-down table had numerous small particles of meat and fat from the previous day's production. 2) 70% of the surface area of the plastic bag covering the controls of the hoist was covered with blood and fat residue. 3) The nylon table top of the boning table was stained by residue from seasoning. All areas were placed under regulatory control with U.S. rejected tag # B38035525. Ms. Deena Hendricks was notified. Regulatory control was released in the processing area following recleaning and sanitizing.
11-2008-12395	12/10/2008	01B02	C	416.13(c)	Steve Rains	Steve Rains		At approximately 900 hours, after plant pre-operational inspection and prior to start of slaughter in the kill floor, I noticed the following noncompliance while performing a scheduled 01B02 procedure. The backsaw used to split carcasses had a buildup of fat residue on the base of the blade where it connects to the frame of the saw. Approximately 20% of the surface area of the shield covering the motor also had a fat residue buildup. The blade itself is a product contact surface. The backsaw was placed under regulatory control action with US rejected tag # B38035530. Mr. Steve Rains was notified and regulatory control action was released

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1- 2009- 12395	1/15/2009	06D01	K	416.2(b)(3)	Steve Rains	Steve Rains	<p>on the kill floor at 900 hours following immediate recleaning and sanitizing of the saw blade and its shield. No product was affected. Plant sanitation records indicated all areas mentioned were acceptable . Monitoring during plant pre-op failed to identify these noncompliance issues. Unsanitary equipment surfaces spread contamination to all product it comes in contact with.</p> <p>At approximately 900 hours, while performing an unscheduled 06D01 procedure for establishment construction standards, I noticed the following SPS failure. The exterior door located on the north side of the wash room has hinges that are not securely fastened and in disrepair. Also a small hole large enough for a mouse to crawl through exists at the base of the door where it attaches to the building. No regulatory control was applied as there is no immediate threat to consumer safety. Mr. Rains was notified and shown the door of concern. The establishment is required to maintain a facility of sound construction and kept in good repair.</p>
2- 2009- 12395	1/28/2009	01B02	C	416.13 (a),416.13(c)	David Rains	David Rains	<p>Establishment 21575 has a written Sanitation Standard Operating Procedure (SSOP) . I. Pre-operational Sanitation-Equipment and Facility Cleaning A. 1. b,e,f references equipment debris removal, rinsing, and sanitizing for food production. However, at approximately 0815 hours , after plant preoperational inspection and prior to start of production, I performed a scheduled 01B02 procedure and found the following noncompliance. In the processing room, I observed three blood spots approximately 1/4 inch in diameter on the wrapping table. I also found two blood spots approximately 1/4 inch diameter inside the grinder at the base near the auger. This is a product contact surface. Both items were placed under regulatory control action with US rejected tag #B38035529. Ms. Deena Hendricks was notified. Regulatory control action was released at 0835 hours following recleaning and sanitizing. No product was affected.</p>
3- 2009- 12395	3/4/2009	01B02	C	416.13(c)	Steve Rains	Steve Rains	<p>At approximately 8:20, after plant preoperational inspection and prior to the start of production, I performed a scheduled 01B02 procedure and found the following noncompliances. In the wash room of the kill floor, I observed fat particles and a film of fat residue on the conduit leading to the switch that controls the high pressure washer. I also observed a sawzall hung in the corner of the wash room, with fragments of bone on the blade. Establishment</p>

4- 2009- 12395	4/15/2009	01C02	C	416.4(b)	Steve Rains	Steve Rains	<p>21575 has a written Sanitation Standard Operation Procedure (SSOP). A.1.b,e,f references equipment debris removal, rinsing, and sanitation for food production. B. 1 & 2 references the cleaning of floors and walls. The wash room and sawzall were placed under regulatory control action with US rejected tag # B38035531. Mr. Steve Rains was notified. Mr. Rains responded that the sawzall was only used for sawing horns from cattle heads after slaughter. The saw was removed from the area and the conduit and wall was washed free of all contamination. Regulatory control action was released at 8:40. No product was affected.</p> <p>At approximately 1045 hours, while performing a scheduled 01C02 procedure for operational sanitation, I noticed the following noncompliance. The concrete floor of the kill floor was not kept sufficiently clean to maintain sanitary operations. A considerable amount of manure, blood, and trim remained on the floor from the slaughter of the first steer, while the slaughter of the second of two animals began. Upon discussion of this with Steve Rains, slaughter was stopped and the floor cleaned. Non-food contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product. No product was involved and no regulatory action was taken.</p>
5- 2009- 12395	4/22/2009	01B02	C	416.13(c)	Steve Rains	Steve Rains	<p>At approximately 800 hours, after plant preoperational sanitation inspection and prior to the start of production, I performed an unscheduled 01B02 and found the following noncompliances. The hand saw had meat and fat imbedded around the saw tip. The metal table located under the rail, had three 1/16 inch spots of meat and fat residue. Also, the S hook from the overhead trolley had multiple spots of residue left from the previous day's production. Each of these are product contact surfaces. All items were placed under regulatory control action with US rejected tag # B38035538 and Ms. Deena Hendricks was notified. Regulatory control action was released at 0820 hours following recleaning and sanitizing. No product was affected.</p>
6- 2009- 12395	6/3/2009	06D01	J	416.2(c)	Steve Rains	Steve Rains	<p>At approximately 840 hours, while performing a unscheduled 06D01 procedure for establishment standards, I observed the following noncompliance. At the east end of the processing room, located above the boning table, two florescent bulbs were burned</p>

7-2009-12395	7/15/2009	06D01	L	416.2(a)	Steve Rains	Steve Rains	<p>out. This caused the area to be poorly illuminated. I found the conditions in the processing room to be sanitary during pre-operational and operational sanitation inspections. Since no product was affected and no unsanitary condition was created, no regulatory action was taken. However, conditions have been created that could lead to an unsanitary condition in the future. Steve Rains was notified. Lighting of good quality and sufficient intensity to ensure that sanitary conditions are maintained and that product is not adulterated must be provided in areas where food is processed, handled, stored or examined.</p> <p>At approximately 1430 hours, while performing an unscheduled 06D01 procedure for establishment standards, I observed the following noncompliance. Grass and weeds had grown to a length about the perimeter of the establishment that could harbor rodents and other vermin. Regulation 416.2(a) states that the grounds about the establishment must be maintained to prevent conditions that could lead to insanitary conditions. No product was affected and no regulatory action was taken. Mr. Steve Rains was notified and shown the untrimmed tall grass about the perimeter of the establishment.</p>
8-2009-12395	7/16/2009	06D01	P	416.4 (b) ,416.5(b)	Steve Rains	Steve Rains	<p>At approximately 1130 hours, while performing an unscheduled 06D01 procedure, I observed the following noncompliance's. I found the newly delivered, unworn frocks hanging in the upstairs storage area to be soiled and unclean. I found dirt in many areas of the garment, but especially on the sleeves. I also found downstairs a plastic bag containing newly delivered, folded, unworn aprons and towels. Nearly each apron had dust on it. Regulatory action was taken and the frocks and aprons each were tagged with Tag #'s B38035541 and B38035544. Regulation 416.5(b) states that clothing , aprons, frocks and other outer clothing worn by persons who handle product must be of material that is disposable or readily cleaned . Clean garments must be worn at the start of the each working day and garments must be changed during the day as often as necessary. I brought this to the attention of Deena Hendricks. Further in my inspection inside the processing room, I observed the newly delivered replacement towel dispenser to be unsanitary. The outside cover was almost completely covered with a film of dirt and smudge marks. When I opened the towel dispenser, I found the inside to be covered with dust, which was contaminating the towel</p>

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9-2009-12395	7/30/2009	01B01	C	416.13(c)	Steve Rains	Steve Rains
10-2009-12395	9/16/2009	01B02	D	416.15(a)	Steve Rains	Steve Rains

inside and presenting an insanitary condition. Regulation 416.5(b) states that non-food contact surfaces of facilities, equipment and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. Deena Hendricks and Steve Rains were notified. Regulatory action was again taken and the towel dispenser was tagged with tag # B38035545. The tags were removed and regulatory action was released on 7-17-09 at approximately 1030 hours when Cintas replaced the tagged items with clean and sanitary frocks, aprons, and towel dispenser.

At approximately 800 hours, after plant preoperational sanitation inspection and prior to the start of production, I performed an unscheduled 01B02 procedure and found the following noncompliance's. The plastic bag that covers the controls for the overhead trolley, had blood stains on it from the previous days production. I further observed the interior surface of the sausage grinder, where I found multiple spots of meat and fat residue. The plastic bag is not a product contact surface, while the inside surface of the grinder is. The grinder was placed under regulatory control action with US rejected Tag # B38035546 and both items of concern were shown to Ms. Deena Hendricks. Regulatory control action was released at 815 hours following recleaning and sanitizing. No product was affected.

At approximately 8:45, while performing an unscheduled 01B02 procedure for pre-operational sanitation on the kill floor, I observed the following noncompliance. The trolleys to be used that day were rusted. Regulatory control action was taken and the rusted trolleys were rejected with tag # A6640320. Owner Steve Rains was notified. I then reviewed the records to see if this deficiency was noted in the records. "Rusty Trolleys" was noted properly in the Pre-operational Sanitation records. However, no corrective action was taken or noted in the records. Regulation 416.15(a) states that each official establishment shall take appropriate corrective action (s) when either the establishment or FSIS determines that the establishment's Sanitation SOP's or procedures specified therein, or the implementation or maintenance of the Sanitation SOP's, may have failed to prevent direct contamination or adulteration of product(s). The rust was removed from the trolleys with steel wool,

11-2009-12395	10/29/2009	01C01	E	416.16(a)	Steve Rains	Steve Rains	<p>they were then cleaned and oiled with white oil. At approximately 9:10 I removed the tag and regulatory action was released. No product was affected.</p> <p>While performing a scheduled 01C01 procedure, I found the following SSOP Recordkeeping failure. The Kill Floor SSOP Daily Operational Sanitation Log had no entries for the date of 10/28/09. Regulation 416.6 (a) states that each official establishment shall maintain daily records sufficient to document the implementation and monitoring of the Sanitation SOP's and any corrective Actions taken. The establishment employee(s) specified in the Sanitation SOP's as being responsible for the implementation and monitoring of the procedure(s) specified in the Sanitation SOP's shall authenticate these records with his or her initials and date. Steve Rains was notified of this noncompliance. Steve assured me that operational sanitation procedures were performed, just not documented. Since this was a recordkeeping noncompliance only, no product was affected and no regulatory action was taken.</p>
12-2009-12395	12/23/2009	01B02	C	416.13(c)	Steve Rains	Steve Rains	<p>At approximately 800 hours, after plant preoperational sanitation inspection and prior to the start of production, I performed an unscheduled 01B02 procedure and found the following noncompliances. Inside the processing room, the blade of the handsaw had meat and fat buildup along the cutting edge as well as at the saw tip . Also the clasp connected to the overhead trolley had multiple spots of meat and fat residue left over from the previous day's production. Both of these are food contact surfaces. All items were placed under regulatory control action with US rejected tag # B38035549 & B38035550 and Ms. Deena Hendricks was notified. Regulation 416.13 (c) states that each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's. Regulatory control action was released at 0815 hours following recleaning and sanitizing. No product was affected.</p>
1-2010-12395	2/1/2010	06D01	J	416.2(c)	Steve Rains	Steve Rains	<p>At approximately 1400 hours, while performing an unscheduled 06D01 procedure for lighting, I observed the following noncompliance. In the kill floor, one of the florescent light bulbs located at the east end of the room was burned out. This caused the area to be poorly illuminated. I found the conditions in the kill floor to be sanitary during pre-operational and operational sanitation inspections. Since no product was affected and no unsanitary</p>

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2- 2010- 17071	3/10/2010	01C01	E	416.16(a)	Steve Rains	Steve Rains	<p>condition was created, no regulatory action was taken. However, conditions have been created that could lead to an unsanitary conditions in the future. Steve Rains was notified. Lighting of good quality and sufficient intensity to insure that sanitary conditions are maintained and that product is not adulterated must be provided in areas where food is processed, handled, stored or examined.</p> <p>At approximately 1500 hours, while reviewing the Sanitation SOP Records, I observed the following noncompliance. The entries for period A and period B were absent in the Operational Sanitation Records for the date of 3-10-10. Regulation 416.16 (a) states that each official establishment shall maintain daily records sufficient to document the implementation and monitoring of the Sanitation SOP's and any corrective action taken. The establishment employee (s) specified in the Sanitation SOP's as being responsible for the implementation and monitoring of the procedure(s) specified in the Sanitation SOP's shall authenticate these records with his or her initials and the date. I was present to witness the establishments monitoring of these Operational Sanitation Procedures in question, although the results were not recorded. No product was affected. Therefore, no regulatory action was taken.</p>
3- 2010- 17071	4/14/2010	01B02	C	416.13(c)	Steve Rains	Steve Rains	<p>At approximately 835 hours, after plant preoperational sanitation inspection and prior to the start of production, I performed a scheduled 01B02 procedure for preoperational sanitation and found the following areas of noncompliance. Inside the wash room, on the east wall, I observed several areas where small pieces of fat residue remained from the previous days slaughter. I also observed fat residue and hair located under the handle of the switch to the high pressure washer. These surfaces are not food contact surfaces. However, splashback from these surfaces could readily contaminate carcasses while they are being washed. Regulatory action was taken and the areas in question were tagged with T# B38035553 and T# B38035554. Steve Rains was notified of this noncompliance. Regulation 416.13 (c) states that each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's. These two areas were recleaned and sanitized. Regulatory action was released at 855 hours. No product was affected.</p>
4-	4/21/2010	06D01	J	416.2(c)	Steve	Steve	<p>At approximately 815 hours, while performing an unscheduled</p>

2010-17071					Rains	Rains	06D01 procedure for lighting, I observed the following noncompliance. Inside the Inspected Cooler I found one of the three bulbs that illuminate the cooler, the one closest to the entrance, to be burned out. This caused a section of the rail where carcasses are hung and frequently examined to be poorly illuminated. I found the cooler to be clean and well kept and the carcasses to be maintained in a sanitary condition. Since no product was affected and no immediate unsanitary condition was created, no regulatory action was taken. However, conditions have been created that could lead to an unsanitary condition in the future. Steve Rains was notified. Regulation 416.2 (c) states that lighting of good quality and sufficient intensity to insure that sanitary conditions are maintained and that product is not adulterated must be provided in areas where food is processed, handled, stored, or examined. While reviewing the previous noncompliance records, I found another noncompliance record for lighting dated 2/01/10. This involved a burned out bulb on the kill floor. Since these two incidents were random and have no connection, these noncompliance records are not being linked.
5-2010-17071	6/9/2010	06D01	L	416.2(a)	David Rains	Steve Rains	At approximately 840 hours, I observed the following noncompliance while performing an unscheduled 06D01 procedure for establishment standards. Grass and weeds have grown to a length in excess of 12 inches tall in areas on the north side of the establishment that could harbor rodents and other vermin. These areas in question include the north perimeter of the establishment and areas between and around the two reefers stationed at the dock. Regulation 416.2(a) states that the grounds about the establishment must be maintained to prevent conditions that could lead to insanitary conditions. No product was affected and no regulatory action was taken. Mr. Steve Rains was notified and shown the untrimmed grass in question.
6-2010-17071	7/14/2010	01B02	D	416.15(a)	Steve Rains	Steve Rains	At approximately 830 hours, while performing a scheduled 01B02 procedure for preoperational sanitation, I observed the following noncompliance. While reviewing the preoperational sanitation records, I found an entry noting dust and rust on the rail leading from the wash room to the north cooler, yet no corrective action was noted. Upon further investigation, I found that indeed there was dust and rust on the rail with no corrective action taken. Regulatory action was taken and the portion of the rail in question was tagged

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7-2010-17071	8/31/2010	01B02	E	416.16(a)	Steve Rains	Steve Rains
8-2010-17071	11/1/2010	01C01	E	416.16(a)	Steve Rains	Steve Rains

with T #B38035547. Steve Rains was notified of this noncompliance. Regulation 416.15(a) states that each official establishment shall take appropriate corrective actions when either the establishment or FSIS determines that the establishment's Sanitation SOP's or the procedures specified therein, or the implementation or maintenance of the Sanitation SOP's, may have failed to prevent direct contamination or adulteration of product. The rail was cleaned and oiled with white oil. The records were noted to account for the corrective action taken. At approximately 1000 hours I removed the tag and regulatory action was released. No product was affected.

While performing a record review of the Sanitation SOP records at approximately 900 hours, I observed the following record keeping noncompliance. The initials, time and date of the "Sanitation Manager" were absent from the Daily Operational Sanitation Inspection Form D-1 for the dates of 8-26-10 and 8-27-10. Regulation 416.16 (a) states that each official establishment shall maintain daily records sufficient to document the implementation and monitoring of the Sanitation SOP's and any corrective action taken. The establishment employee(s) specified in the Sanitation SOP's shall authenticate these records with his or her initials, time and date. I brought this record keeping omission to Steve Rains' attention. Steve responded that the verification was performed as usual. However, the person designated to perform this verification forgot to record the results. Since no product was affected, no regulatory action was taken.

At approximately 1300 hours, while reviewing the Sanitation SOP Records, I observed the following noncompliance. The entries for Operational Sanitation, form D-1, were missing for periods A and B for the date of October 27. Regulation 416.16(a) states that each official establishment shall maintain daily records sufficient to document the implementation and monitoring of the Sanitation SOP's and any corrective action taken. The establishment employee (s) specified in the Sanitation SOP's shall authenticate these records with his or her initials and date. The Quality Control Manager, Drew Noblitt, was notified of this noncompliance, as well as Steve Rains, the owner. Drew assured me that although the results of this operational sanitation procedure was not recorded, it was performed. No product was affected and no regulatory action.

<p>9-2010-18499</p>	<p>12/22/2010</p>	<p>01B02</p>	<p>E</p>	<p>416.4(c)</p>	<p>Steve Rains</p>	<p>Steve Rains</p>	<p>While performing a Food Safety Assessment the EIAO noted the following noncompliance. Mr. Steve Rains , President stated to the EIAO that [REDACTED] are employed in the establishment. A [REDACTED] The [REDACTED] is used on slicers, grinders and other metal equipment and [REDACTED] is used on cutting boards and other non-metal equipment. When asked about sanitizer dilution, Mr. Rains (President) stated that for no rinse applications, the [REDACTED]. This concentration is safe without a rinse as documented by the label on the product container. Likewise for no rinse applications, the [REDACTED]. This concentration is safe without a rinse as documented by the label on the product container which is available for review by FSIS inspection personnel. Mr. Rains further stated that only he or another employee whom he has trained personally mixes the sanitizer solutions but there is no written record maintained recording these dilutions. This failure to maintain records substantiating the safety of a chemicals use (sanitizer concentration used) would not meet the requirements of 9 CFR 416.4(c).</p> <p>During the course of a Comprehensive Food Safety Assessment the EIAO noted the following non-compliance. This establishment predominantly grinds beef from cattle grown on their own farm and produced in its own slaughter and Raw Not Ground processes .Occasionally they do purchase boxed beef to grind when they do not have any of their own beef, approximately 944lbs in the preceding six months. For ground product made from boxed beef purchased from outside suppliers they have chosen to address the hazard posed by E. coli O157:H7 via purchase specification . FSIS Directive 10,010.1 rev. 3 chapter VI explains that if an establishment uses purchase specifications in a prerequisite program, FSIS expects the establishment to have: 1. a document (e.g., letter of guarantee) from each supplier that provides assurance that the supplier employs CCPs that address E. coli O157:H7 and describes those interventions. 2. certificates of analysis (COAs) (i.e., actual test results) and the sampling method used (e.g., N=60) 3. records that demonstrate that the receiving establishment is executing the program to achieve the first two conditions in a</p>
<p>12-2010-18499</p>	<p>12/22/2010</p>	<p>03B02</p>	<p>E</p>	<p>417.2(a) (1),417.5(a) (1)</p>	<p>Steve Rains</p>	<p>Steve Rains</p>	<p>(Continuation of text from the first row)</p>

11-2010-18499

12/22/2010

03C02

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417.2(a)
(1), 417.2(a)
(2)

Steve Rains

Steve Rains

consistent and effective manner. The supporting documentation for the meat receiving program for boxed beef does not meet the second condition because the supporting documentation does not include actual COAs or other evidence that the product was tested, test results or ongoing communication with the supplying establishment. The establishment only tests ground beef produced from their slaughter plan and there is no support on file for the sample collection method. FSIS methodology specifies that 325 gram test portions will be analyzed and the lab reports the establishment has on file from 2009 indicate that their laboratory only analyzed a 25 gram test portion. Results obtained from finished product tests using this small test portion size should not be used to support decisions in the Hazard Analysis and does not provide ongoing verification of the purchase specification to meet the requirements of 9 CFR 417.5(a)(1) and 417.2(a)(1). Due to the lack of on-going verification the implementation of the Meat Receiving Program does not adequately support the decision made in the Hazard Analysis that E. coli O157:H7 is NLTO in their process and does not meet the requirements of 9 CFR 417.5(a)(1), 417.2(a)(1).

During the course of the FSA the EIAO noted the following non-compliance. The establishment's stated intent is to prevent cattle 30 months or older from being received for slaughter. However the SSOP does contain provision for the removal of SRM materials from older cattle if they are inadvertently received and slaughtered. This SRM removal would take place during fabrication. The SSOP states that the vertebral column of cattle 30 months of age or older (excluding the vertebrae of the tail, the transverse processes of the thoracic, lumbar vertebrae, the wings of the sacrum) and the dorsal root ganglia will be removed. This is to be accomplished in a sanitary manner and placed in inedible barrels during processing. Since this SRM removal is to take place during fabrication this would appear to be a potential hazard that should be addressed in the Hazard Analysis at some step in the fabrication process. Since the Hazard Analysis does not include SRMs as a potential Hazard in Carcasses Received from the cooler the establishment has not met the requirements of 9 CFR 417.2(a)(1). The EIAO compared the Raw Not Ground and Raw Ground process to the flow diagram and hazard analysis and saw that the flow diagram contains one

10-2010-18499	12/22/2010	03J02	E	417.5(a)(3)	Steve Rains	Steve Rains	<p>Block labeled Meat Receiving, the Hazard Analysis contains two Meat Receiving Steps, one for Meat Receiving, fabrication trimmings from chilled carcasses and one for Meat Receiving, Boxed Boneless Meat. This design issue constitutes a failure to include all process steps in the flow diagram and does not meet the regulatory requirement of 9 CFR 417.2(a)(2). Similar non-compliance is noted with the 03B Category.</p> <p>While performing a Food Safety Assessment the EIAO noted the following noncompliance. The dates on calibration records from 11/15, 11/16, 11/17, 11/18, and 11/19 did not include the year. Because these records were stapled to other records dated 11/15/2010 the establishment was able to conclude the calibration had occurred for the week but this recordkeeping error fails to meet the requirements of 9 CFR 417.5(a)(3). This noncompliance pertains to the record keeping of calibration records for HACCP plans 03B, 03C and 03H as well.</p>
1-2011-18499	1/19/2011	03H02	E	417.5(a)(3)	Steve Rains	Steve Rains	<p>At approximately 1100 hours, while reviewing the HACCP records I observed the following recordkeeping noncompliance. The verification and preshipment review entries on Form R-2 for the days of Jan 17th & 18th were missing. The Quality Control Manager, Drew Noblit, was notified of this noncompliance. Drew assured me that although the results were missing, the verification procedure and preshipment review was performed. No product was affected and no regulatory action was taken. Regulation 417.5 (a) (3) states that the est shall maintain the following records documenting the monitoring of CCP's and their critical limits, including the recording of actual times, temperatures, or other quantifiable values, as prescribed in the establishment's HACCP plan: the calibration of processing and monitoring instruments, corrective actions, including all actions taken in response to a deviation, verification procedures and results. Each of these records shall include the date the record was made.</p>
2-2011-18499	3/4/2011	03J01	E	417.5(b)	Steve Rains	Steve Rains	<p>While performing a scheduled 03J01 procedure for recordkeeping, I found the following HACCP recordkeeping failure. The establishment failed to document CCP 6B carcass temperature on Form R-2 for beef slaughter on 3-2-2011. The HACCP Plan identifies CCP 6B as cooler temperature of one carcass with guidelines of 41 degrees F or less within 36 hours. The back quarter</p>

3-2011-18499	4/20/2011	06B01	P	416.4(d)	Steve Rains	Steve Rains	<p>temperature of 35 degrees F was recorded at 1312 hours as CCP 2B for cooler monitoring and verification on form R-2 for the carcass in question. It was apparent that the temperature was taken on the carcass in question was recorded under monitoring and verification for CCP 2B but not recorded to satisfy the HACCP requirements for 6B. Therefore, recordkeeping is my only noncompliance. Mr. Steve Rains and Drew Noblit were notified of this noncompliance.</p> <p>At approximately 840 hours, while performing an 06B01 procedure, I observed the following noncompliance. As I entered Freezer 1, I found plastic bags full of trim placed on the floor near the entrance. Regulation 416.4(d) states that product must be protected from adulteration during processing, handling, storage, and during transportation from the official establishment. Although the plastic bags were in tact and no product was affected, it poses a potential for the bags to be ripped and product to be adulterated. However, since no product was contaminated, no regulatory action was taken. Steve Rains was notified of the noncompliance.</p>
4-2011-18499	5/4/2011	01B02	C	416.4(b)	Steve Rains	Steve Rains	<p>At approximately 820 hours, while performing an 01B02 procedure for preoperational sanitation, I observed the following noncompliance. I found a buildup of dust on the rail in the wash room and kill floor. Regulatory action was taken and the rail in question was tagged with tag # B38035631 and #B38035632. Regulation 416.4(b) states that non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. I brought this to the attention of Steve Rains. After the rail was cleaned of the buildup of dust, regulatory action was released at approximately 840 hours.</p>
5-2011-18499	5/19/2011	01B02	C	416.4(a)	Steve Rains	Steve Rains	<p>At approximately 810 hours, after plant per-operational inspection and prior to start of production in the processing room, I observed the following noncompliance while performing a scheduled 01B02 procedure for Pre-operational Sanitation. The white plastic bag that covers the toggle switch to the overhead hoist was covered with blood from the previous day's production. I also found multiple pieces of product approximately 1/8 inch in diameter distributed on and throughout the inside of the bin, the lid, the shaft tube, and on the blades of the shaft of the meat grinder. I also found</p>

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8/24/2011

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Steve Rains

Steve Rains

approximately 30% of the inside surface area of the grinder bin to have a fat residue remaining. Establishment 20575 has a written Sanitation Standard Operating Procedure (SSOP). I. Pre-operational Sanitation - Equipment and Facility Cleaning 1,b,e,f references equipment debris removal, rinsing and sanitizing daily for food production. Regulation 416.4(a) states that all food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. Since the areas of the grinder fore mentioned are food contact surfaces, Regulatory Action was taken at 815 hours with US Rejected Tag # B38035633. Jeremy Faxon and Steve Rains were notified of the noncompliance. Regulatory Action was released at approximately 840 hours following recleaning and sanitizing. No product was affected. Plant per-operational sanitation records identified the deficiency and corrective actions taken.

While performing an unscheduled 05A02 procedure for determining compliance with regulatory requirements for generic E. coli testing, I found the following noncompliance. The establishment did not take a generic E. coli sample for the hogs slaughtered on 7-13-11. Regulation 310.25 states that very low volume establishments that collect by sponging shall collect at least one sample per week for every week of slaughter, starting the first full week of operation after June 1 of the following year and continue sampling at a minimum of one sample each week the establishment operates until June 1 of the following year or until 13 samples have been collected, whichever comes first. Owner Steve Rains was notified of the noncompliance. No regulatory action was taken.

7-2011-18499

9/20/2011

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416.16(a)

Steve Rains

Steve Rains

At approximately 900 hours, while reviewing the Sanitation SOP Records, I found the following noncompliance. The entries for Pre-operational Sanitation, form E-1, were missing for periods A & B for the dates of September 19 & 20, 2011. Regulation 416.16(a) states that each official establishment shall maintain daily records sufficient to document the implementation and monitoring of the Sanitation SOP's and any corrective action taken. The Quality Control Manager, Jeremy Faxon, and the owner, Steve Rains, were notified of the noncompliance. Jeremy assured me that although the

							results of this pre-operational sanitation procedure were not recorded, it was performed and the results were satisfactory. No product was affected and no regulatory action was taken.
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868=Second Floor
869=First Floor
870=Legends
871, 872, 873=Site Plan