Meat Messenger

North Dakota State Meat and Poultry Inspection Program 2016 Quarter 2

NDSU and USDA Food Safety Summit

NDSU and USDA are hosting a food safety summit inviting plant owners and industry leaders to enjoy educational sessions, share their experiences on handling regulatory expectations, and discuss current topics pertaining to the meat industry.

Understanding and implementing validation requirements for Hazard Analysis Critical Control Point (HACCP) will be the main discussion topic of this year. Speakers from academia, regulatory officials and those with industry experience will share how they approach validation and discuss the expectations involved.

With renewed interest in poultry slaughter, the afternoon session will cover poultry sanitary dressing and control measures for salmonella and campylobacter in raw poultry.

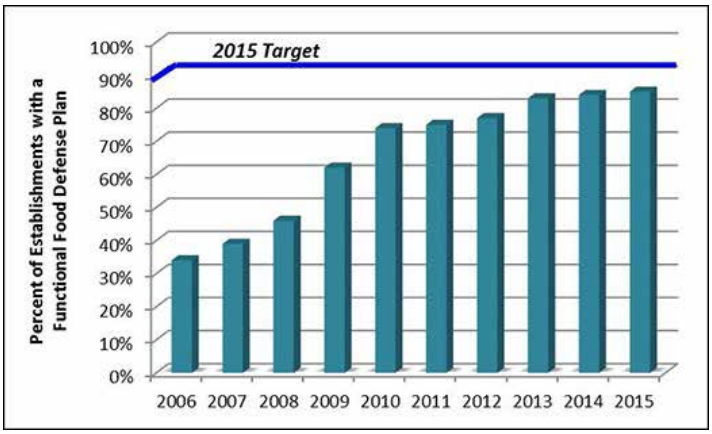
Please join us at the Wanzek Center for Scouting (4200 195th Ave S) in Fargo on May 19, 2016 from 8 a.m. – 3:30 p.m. Registration is $25 which includes lunch.

Sanitary poultry dressing methods, and controlling salmonella and campylobacter in raw poultry, are two topics that will be covered at the food safety summit.

Please register online as soon as possible at the website http://tinyurl.com/FoodSafetySummit.

Annual Food Defense Plan Survey Reminder

Inspection personnel will be conducting the Annual Food Defense Plan Survey in all official regulated establishments April 1 – May 31, 2016. The survey helps identify how many establishments are voluntarily adopting a functional food defense plan and therefore implementing security measures to protect against intentional adulteration. A functional food defense plan is one that is documented, implemented, tested and reviewed/maintained. Last year, 78% of very small meat and poultry establishments had food defense plans and the goal is to have 90% of all establishments implement a food defense plan.



We encourage industry to take advantage of the tools and resources to help implement food defense plans. These tools and resources can be accessed at www.fsis.usda.gov/fooddefense. Please discuss any questions regarding food defense or the survey with your inspector.

Meat Messenger

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Regulation Reminder

Final Rule by Food Safety and Inspection Services

Records To Be Kept by Official Establishments and Retail Stores That Grind Raw Beef Products

Docket No. FSIS-2009-2011
Effective Date June 20, 2016

9CFR-320
All stores that grind beef for retail sales will need to maintain records for each lot ground in store:

- All supplier lot numbers and production days
- Names of supplied materials (bench trim, 2 piece chuck, rounds), including all components and carry over materials from one lot to another
- Date and time each lot is produced
- Date and time when grinding equipment is cleaned and sanitized

https://federalregister.gov/a/2015-31795

All facilities that grind beef for sale as a raw product to the consumer will need to collect the above mentioned records for every lot of every production day. These records are intended to aid investigators during outbreak investigations, to identify and effectively recall all beef implicated in the event of a foodborne illness outbreak.

What would you like to read in the next issue?
The Meat Messenger is your newsletter. If you like the content, please feel free to share this issue with your employees, your livestock producers and customers. We welcome any questions, comments, or suggestions for future topics. Please contact **Nathan Kroh** at nkroh@nd.gov or 701-328-4767 or **Julie Nilges** at jnilges@nd.gov or 701-204-3248.

3rd Annual Snack Stick Challenge

The ND Department of Agriculture will be hosting the 3rd Annual Snack Stick Challenge at the State Fair in Minot on July 25, 2016, at the Pride of Dakota tent. The winner will earn bragging rights for the next year. The defending 2015 champion is Maple Valley Meats of Enderlin, ND.

Contest Winner Selection:
Each contestant will be assigned a colored toothpick and judging will be done by popular vote. An informational card will be handed out to patrons as they leave the voting table. The winner of the meat stick contest will be the contestant with the most votes.

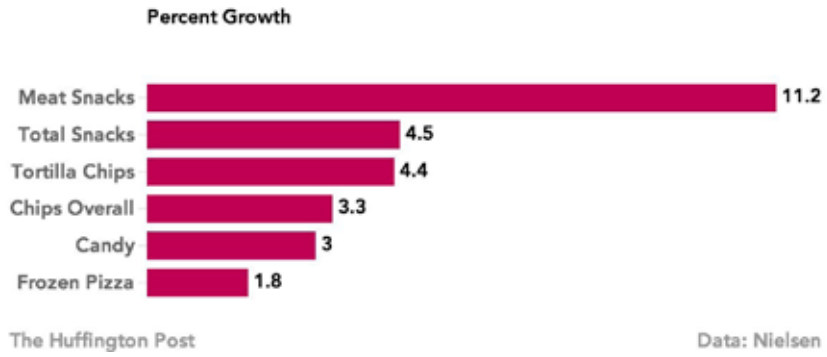
Who Can Enter?
Retail exempt meat shops may enter the contest, but an employee of the company must be present to represent their product. State or federally inspected companies can enter inspected snack sticks without representation by a company employee. No need to be a member of Pride of Dakota, but membership will allow access to a booth to sell your products directly to State Fair patrons and others at Pride of Dakota showcases. It will also allow you to put the highly respected Pride of Dakota label on your product.

Entrants Must Provide:
Each processor must provide evidence of proper cooking temperatures and cooling times for the lot of snack sticks provided. A proper list of ingredients must be provided to contest coordinators with full disclosure of allergenic ingredients. Samples (200 total) will be precut by processor to 1" in length, and sent to Pride of Dakota between July 18-21.

Registration:
We have a limited number of spots left in the contest, so don't delay! Call Jamie Good, Local Foods Specialist with the ND Department of Agriculture, at 701-328-2659 to register.

Meat Snacks Are More Popular Than Ever

Snacking has increased immensely in popularity, and the real star of the snacking scene is meat snacks, growing by 11.2%. Many shops now specialize in the art of fine gourmet dried meat snacks.



This chart shows the growth of several popular snack categories over the past year based on Nielsen data. Meat snacks are beating categories like chips and candy.

Berman, Jillian. "The Hottest Snack in America Right Now is Gourmet Dehydrated Meat." *HuffPost Business.* The Huffington Post, 25 October 2014. Web. 18 April 2015. <http://www.huffingtonpost.com/2014/10/14/meat-snacks-growth_n_5966866.html>.

Comments Encouraged on Proposed FSIS Rule

Adapted from release by: Congressional and Public Affairs Katherine Scheidt (202) 720-9113 Press@fsis.usda.gov, WASHINGTON, March 18, 2016 —

The Food Safety and Inspection Service (FSIS) is announcing a proposed rule that would consolidate and streamline existing regulations for meat and poultry products. The rule would eliminate redundant trichinae control requirements for pork and pork products during establishments production of products specified in 9 CFR 318.10(b)…certain pork products be treated to destroy trichinae, and consolidate regulations for thermally processed, commercially sterile meat and poultry products. This rule is a supplement to 2001 FSIS proposed rule that proposed to establish food safety performance standards for all ready-to-eat (RTE) and all partially heat-treated meat and poultry products.

Under this proposed rule, establishments will still be required to control for the risk of trichinae and other parasites. FSIS' HACCP regulations require every inspected establishment to identify and control food safety hazards that are reasonably likely to occur (9 CFR 417.2(a)), making prescriptive trichinae regulations no longer necessary. Regulations also require establishments to develop science-based controls for trichinae that are appropriate for the hazards identified for each specific establishment. Compliance with FSIS' HACCP guidelines has proven effective at eliminating trichinae, and *Trichinella* infection associated with commercial pork has decreased.

Should this supplemental proposed rule become final, FSIS has developed the compliance guide to help establishments, particularly small and very small establishments, in understanding the controls that are effective for the prevention and elimination of trichinae and other parasites in RTE and not ready-to-eat (NRTE) pork products. FSIS has posted this compliance guide on its Web page (http://www.fsis.usda.gov/wps/portal/fsis/topics/regulatory-compliance/compliance-guides-index). The guide contains risk comparisons, options for preventing and controlling *Trichinella* and critical operational parameters for methods used, just to name a few.

Additionally, FSIS is proposing to consolidate the regulations on thermally processed, commercially sterile meat and poultry products (i.e., canned food products containing meat or poultry) and make minor changes that improve the clarity of the regulations without any reduction in the existing public health protections.

Comments are due on or before May 27, 2016, and may be submitted online via the Federal eRulemaking Portal at http://www.regulations.gov, by mail sent to Docket Clerk, U.S. Department of Agriculture, Food Safety and Inspection Service, 1400 Independence Avenue SW., Mailstop 3782, Room 8-163A, Washington, DC 20250-3700, or by hand- or courier-delivery to Patriots Plaza 3, 355 E Street SW., Room 8-163A, Washington, DC 20250-3700. All items submitted by mail or electronic mail must include the Agency name and docket number FSIS 2015-0036.

Find us on Facebook

Our Facebook page benefits both consumers and processors with facts about inspection, rules for producers who want to direct market their products, and tips for safely preparing meat and poultry products.

Please check out our page or feel free to ask a question by signing into Facebook and searching for North Dakota Meat and Poultry Inspection Program.

The Meat and Poultry Inspection Program Facebook Page

Come-Up Time: Heating Meat Through the Temperature Danger Zone

Being able to cook meats in a low temp oven for a long period is the advantage that processors have over home cooks, but that advantage comes with risks. The major risk factor is the time it takes to raise the internal meat temperature between 50°F and 130°F, also known as come-up-time. This temperature window is the most dangerous, because pathogens can grow quickly and potentially develop toxins that may not cook away at higher temperatures.

Staphylococcus aureus is a pathogen that multiplies quickly and secretes a very potent toxin that is heat stable. Cooking may kill the bacteria itself, but the toxin left behind will make your customers sick if too much bacteria was to grow during the slow come-up-time. People get sick within 1-6 hours after ingesting the toxin, and may take 1-3 days to recover. According to the USDA, meat that dwells between 50°F and 130°F for more than 6 hours is viewed as especially dangerous.

If you have the ability to monitor product temperature, adjust your smokehouse cycle to ensure that your larger products, such as summer sausage and ham, do not take more than 6 hours to heat through the 50°F to 130°F temperature window. Your customers may not thank you for not making them sick, but would definitely not return if they did get sick.

"Bad Bug Book: Handbook of Foodborne Pathogenic Microorganisms and Natural Toxins." *FDA*. FDA, n.d. Web. 11 Feb. 2016. <http://www.fda.gov/downloads/Food/FoodborneIllnessContaminants/UCM297627.pdf>

"Appendix A: Compliance Guidelines for Meeting Lethality Performance Standards for Certain Meat and Poultry Products." *FSIS.* FSIS, January 1999. Web. 11 Feb. 2016. <http://www.fsis.usda.gov/OPPDE/rdad/FRPubs/95-033F/95-033F_Appendix_A.htm>

Keep Spices Separate from Curing Salts

Pre-packed seasoning blends are consistent and convenient and they come with the packet of cure perfectly measured. Wouldn't it be even easier to send one blend, with the curing salt mixed in? FDA regulations prohibit the premixing of curing agents with flavors or seasonings that contain amines (which is present in all proteins). In a similar way that sodium nitrite reacts with meat, the nitrites will react with the proteins in the spice blends. This reaction can create undesirable nitrosamines or use up the available nitrite, reducing the antimicrobial effect and preventing flavor and color development. Notably, black pepper and paprika are most likely to react with nitrites. Mixing the curing salts with the spices to save a little time is a step in the wrong direction.

Many recipes call for Morton Salt Tender Quick®, which is a combination of nitrites and nitrates. Tender Quick is designed for home meat cure, not for commercial use. Nitrates take time and warmer temperatures to convert into usable nitrite, so nitrates are used during longer, slower cure steps often observed during home-curing processes. Commercial sausage kitchens operate quickly under controlled temperatures using consistent meat blends so they need fast and reliable cure conversion. When making sausages, frankfurters and other small-diameter cured meats, blending in pink salts containing nitrite only is the best option for the most consistent color and flavor development.

Morton Salt: Consumer Affairs & Engagement (personal communications, April 16, 2015)
J. Cordray (personal communications, April 16, 2015)

Records to be Kept by All Stores That Grind Raw Beef

The Food Safety and Inspection Service (FSIS) is amending its recordkeeping regulations to require all official and retail stores that grind raw beef products maintain the following records:

1. Each company's establishment number for all source meat suppliers
2. The lot numbers and production dates of all source materials going into each lot of ground beef
3. The name of the supplied materials, including beef components and any materials carried over from one production lot to the next
4. The date and time each lot of raw ground beef product is produced
5. The date and time when grinding equipment and other related food-contact surfaces are cleaned and sanitized.

The requirements are also applied to raw beef products that are ground at an individual customer's request when new source materials are used. The records must be available at the grinding location for one year.

The reason for the amended regulations is to aid in timely and effective investigations into foodborne illnesses. Without such records, FSIS investigations are often stymied and the source materials causing illnesses may not be identified, which may pose an unnecessary risk to consumers.

The Beef Industry Food Safety Council National Cattlemen's Beef Association has developed a guideline called "Best Practices for Retail Operations Producing Raw Ground Beef." This guideline provides proven measures to provide the safest raw beef products possible, and recommends that retail operations adopt parts of the guideline to ensure optimal quality and food safety. The guideline is found at http://www.bifsco.org/CMDocs/BIFSCO/Best%20Practices/bestpracticesforretail4-05.pdf.

If every retail store that grinds beef had a solid food safety and sanitation plan and maintained mandatory grinding records, they would be able to aid in foodborne illness investigations and help stop an outbreak as quickly as possible.

For more information about the "Records To Be Kept by Official Establishments and Retail Stores That Grind Raw Beef Products," please refer to the Federal Register website and document number 2015-31795 at https://federalregister.gov/a/2015-31795.

Store Name
Store Address
Store City, State and Zip Code
FRESH GROUND BEEF PRODUCTION LOG/TRACKING LIST
Employee Name: *John Meatcutter* Today's Date: *2/3/16*

Date	Time of Grind	Manufacturer Name of Source Material Used for Product Produced	Supplier Lot #s, Product Code and/or Pack Date of Source Material Used	Est. Number(s) of Est. Providing Source Material	Date Grinder and Related Food Contact Surfaces Cleaned & Sanitized	Time Grinder and Related Food Contact Surfaces Cleaned & Sanitized	Comments
2/3/16	*09:00*	*Beef Clod IMPS/NAMP 114*	*011516A*	*19924*	*2/2/16*	*11:00*	
2/3/16	*15:00*	*Beef Clod 114, trim from Beef Brisket 120, Beef Rib 107*	*011516A & 011916C, 010416B, 011216A*	*19924, 38, 19924*	*2/3/16*	*16:00*	

Meat Manager *2/4/16*
Signature of Store Management Reviewer Date

Classified Ads

We are always looking for industry related items to advertise in the Meat Messenger. We post sale and want ads FREE. Contact Julie Nilges (701-204-3248) at jnilges@nd.gov or Nathan Kroh (701-328-4767) at nkroh@nd.gov with product description and contact information.

True Brand cooler: Cooler has two sliding doors and was manufactured in 2001 - $1,000;
New one-quart plastic containers with lids: $20 per lot of 50.
Please contact Calvin or Alex for more information at 701-743-4451. Located in Parshall.

Slaughter/processing business located in Esmond, ND. Fully operational meat processing facility, all equipment and supplies included. Currently custom-exempt, with option for retail and/or state inspected status, many equipment/facility upgrades last four years. Very strong customer base. Please contact Denise for more information at 701-438-2334 or 701-351-1231.
*Housing is available and the local area market is favorable for those interested.

Zuber Smokehouse: This smokehouse has 750 lb. capacity currently set up with liquid smoke delivery, but natural smoke generator may be included in sale.
Hobart Vacuum Packing Machine: Hobart double chamber vacuum packer (model H-210G-2) asking $2200.
Vacuum Pouches (3 mil): 3 cases of 14"x24", 1 case of 10"x22", and 1 case of 6"x8". Very reasonably priced.
Please call Keith for more information and pricing at 701-256-2116. Located in Langdon, ND.

Mark your calendars: The NDSU and USDA Food Safety Summit is May 19, 2016 at the Wanzek Scouting Center in Fargo. Designed to help the small meat processor, the summit will provide the opportunity for industry and regulators to discuss several issues impacting both.

FSIS Recalls & Alerts Count

Jan - Mar 2016

Potential presence of foreign material		6
Made without benefit of inspection, lack of import inspection		6
Misbranding (undeclared pork, sheep casing, MSG)		6
Undeclared allergens (whey, coconut, peanuts, soy, egg)		4
Bacterial contamination (*E.coli O157:H7, Listeria monocytogenes*)		3
Total Recalls in 1st Quarter 2016		25 recalls
Class 1 recalls - 15 Reasonable probability that eating the food will cause health problems or death	**Class 2 recalls - 8** Potential health hazard situation in which there is a remote probability of adverse health consequences from eating the food	**Class 3 recalls - 2** Situation in which eating the food will not cause adverse health consequences
More than 1,122,423 lbs. of meat and poultry implicated in recalls		

Further information on all current recalls and alerts can be found at: http://www.fsis.usda.gov/wps/portal/fsis/topics/recalls-and-public-health-alerts

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"Equal Opportunity in Employment and Services"

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