



Meat Messenger

North Dakota State Meat and Poultry Inspection Program

2013 Quarter 1

Cooperative Interstate Shipment Program

North Dakota is the second state to reach an agreement with the USDA's Food Safety Inspection Service (FSIS) that allows certain state-inspected meat and poultry establishments to sell inspected products across state lines.

These establishments are called "selected establishments" under this new program.

Bridgemart Meats of Wyndmere is the first North Dakota company to qualify for the new program.

Under the cooperative interstate shipment program (CISP), state inspection staff performs the day-to-day inspection activities with oversight from an FSIS



employee, known as the "selected establishment coordinator."

The products bear a federal inspection legend with the designation "SEND" after the establishment number to distinguish it from federally inspected products.

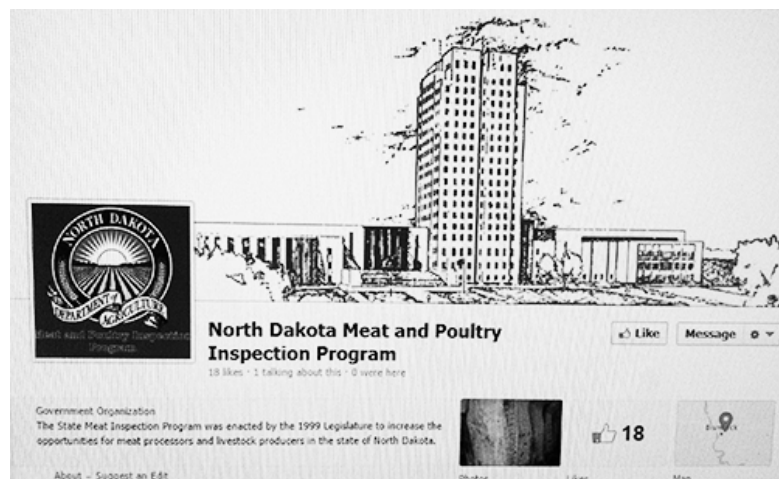
Agriculture Commissioner Doug Goehring and the staff of the North Dakota Meat and Poultry Inspection Program hope the

CISP will provide new opportunities for our state-inspected establishments and encourage establishments interested in the CISP to contact the inspection program.

The North Dakota Meat and Poultry Inspection Program is now on Facebook

The new 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 new page and feel free to ask a question by signing into Facebook and searching for North Dakota Meat and Poultry Inspection Program.



The new Meat and Poultry Inspection Program Facebook Page

Meat Messenger

is published by the
North Dakota
Department of Agriculture

Commissioner
Doug Goehring

Livestock Services Program Manager
Wayne Carlson

Director of Meat Inspection
Andrea Grondahl, DVM

Administrative Assistant
Becky Rienstra

Senior Meat Inspectors
Cody Kreft
Shaun Quissell

Compliance Officer/Meat Inspector
Dave Slack

Scientific Information Coordinator
Jerry Sauter

Meat Inspectors
Shawn Steffen
Heather Andersen
Cami Metzger *Certified Grader
Doug Tobkin
Joshua Epperly
Whitney Vogel
Joslyn Roadstrom

Assistant/Relief Inspector
Julie Nilges *Certified Grader



Please address all correspondence to:

State Meat Inspection
North Dakota Dept. of Agriculture
600 E. Boulevard Ave., Dept. 602
Bismarck, ND 58505-0020
(701) 328-2231
(800) 242-7535
FAX: (701) 328-4567

www.nd.gov/ndda
ndda@nd.gov

Regulation Reminder

North Dakota Administrative Code
Chapter 7-13-02-01: Registration required



7-13-02-01. Registration required. Any slaughtering establishment, meat processing establishment, or custom-exempt plant that is required to be inspected pursuant to North Dakota Century Code chapter 36-24 to operate under this chapter must register annually with the Department of Agriculture on forms approved by the commissioner.

What this regulation means:

Anyone who engages in any of the following intrastate businesses must fill out an annual registration form:

- Meat broker
- Renderer
- Animal food manufacturer
- Wholesaler of animal carcasses, carcass parts or products of carcasses, intended for human food or other purposes
- Public warehouse operator storing carcasses or parts of carcasses of animals in or for intrastate commerce
- Buyer, seller, or transporter of dead, dying, disabled, or diseased animals, or parts of the carcasses of animals that died other than by slaughter

Written Recall Plan Reminder

Small and very small official establishments are required to prepare and maintain written recall procedures by May 8, 2013 (Federal Register - Vol. 77, No. 89; May 8, 2012).

The North Dakota Meat and Poultry Inspection Program (NDMPIP) has created a guide for producing a written recall plan and an example of a completed plan.

Please contact NDMPIP for copies of these documents.

HACCP Pre-requisite Programs

By Jerry Sauter, ND Meat Inspection Scientific Information Coordinator

Pre-requisite programs are designed to prevent hazards from occurring in food safety systems. If they fail, the whole system is affected.

Pre-requisite programs are not meant to eliminate all critical control points (CCPs) in a hazard analysis critical control point (HACCP) plan; they are designed to prevent possible hazards.

When a hazard is identified in the hazard analysis, there are two choices:

Declare the hazard

(1) “not reasonably likely to occur”

or

(2) “reasonably likely to occur”.

Pre-requisite programs enable some of the hazards initially deemed reasonably likely to occur to be deemed not reasonably likely to occur.

For example, a hazard analysis for raw pork products may have initially identified the biological hazard of Salmonella growth as reasonably likely to occur at receiving raw pork products. The establishment implements a pre-requisite program for taking a temperature on all incoming pork lots and not accepting products at temperatures that would allow Salmonella growth.

This pre-requisite program would allow the establishment to claim the biological hazard of Salmonella growth is not reasonably likely to occur at receiving because of the pre-requisite program.

To design and implement a pre-requisite program, first identify all potential hazards in the hazard analysis and determine which are reasonably likely to occur. If it is a step in the process where critical parameters are vital to food safety (a cooking/cooling step in fully cooked products or the warmest point(s) in a raw process) this should be a CCP(s).

If the hazard is at a point where parameters are not deemed critical but control/prevention is needed to ensure food safety, a pre-requisite program will work. Write a pre-requisite program to prevent the hazard, implement it, and maintain records.

Pre-requisite programs are the foundation of the food safety system and support decisions made in the hazard analysis.



If you have a pre-requisite program in place and you forget to do it once, it is generally accepted that this is not grounds for a non-compliance record, and inspection staff will discuss the failure with you.

Repeat failures to execute the pre-requisite program will mean decisions in the hazard analysis are not supported, resulting in an inadequate HACCP system. An inadequate HACCP system can lead to a suspension of inspection.

FSIS Announces Effective Date for Hold and Test

As of Feb. 8, 2013, the Food Safety Inspection Service (FSIS) will require official establishments to hold products being tested by FSIS for adulterants until negative results are available and received by the establishment.

FSIS previously allowed products tested for adulterants to bear the mark of inspection and enter commerce even when test results had not been received. FSIS asked, but did not require, official establishments to maintain control of products tested for adulterants pending test results. Because FSIS establishments did not consistently maintain control of product, adulterated product was entering commerce.



Product affected

The new FSIS policy covers non-intact raw beef products (ground, mechanically tenderized, etc.) and intact raw beef products intended for non-intact use (trim, etc.), if tested for E. coli O157:H7 or non-O157 STECs. The policy also covers any ready-to-eat products tested for or that passed over food contact surfaces that have been tested for *Listeria monocytogenes*, *E. coli* O157:H7, or *Salmonella*. Except for poultry, the policy also applies to livestock carcasses that FSIS tests for veterinary drug residues. Additionally, FSIS testing that indicates product is economically adulterated would be subject to the actions outlined in this document, and, therefore, establishments will be required to control such products from entering commerce. The policy does not apply to raw meat or poultry products tested for *Salmonella* or other pathogens that FSIS has not designated as adulterants in those products.

Small and very small establishments

FSIS intends to provide small and very small establishments with instructions on properly producing representative small batches of product. This will help these smaller establishments reduce their lot size on days when FSIS collects samples.

Thus, for products with short shelf-life, a firm may produce and hold a lot subject to FSIS sampling that is demonstrated by the establishment to be microbiologically independent from other production lots, conduct a clean-up, and then produce other like product eligible to be shipped into commerce. FSIS will consider reducing frequency of sampling at small and very small establishments that have proactive programs in place, such as purchase specifications that address controls for pathogens in incoming product and food contact surface verification testing.

Controls

Establishments must have effective controls to prevent product that FSIS has tested for adulterants from entering commerce before results become available. Controls should include, but are not limited to: not completing pre-shipment review and not allowing ownership of the product to change. FSIS has stated in documents (e.g., in FSIS directives, notices, and questions and answers post of the FSIS web page) that establishments may move product off-site pending final test results if they do not complete pre-shipment review or transfer ownership of the product to another entity.

FSIS recognizes that the mark of inspection is pre-printed on the package label of many products, and that it is most efficient to allow the product to be packaged and labeled with the printed mark of inspection as part of the production process (76 FR 19955). FSIS will continue to allow meat and poultry establishments to package and label products sampled and tested for adulterants with the mark of inspection. However, such product will not be eligible for shipment into commerce until negative test results for adulterants are available.

At this time, the policy will apply only to product that FSIS tests for adulterants. However, FSIS will monitor the situation to track how often establishments release product into commerce before establishment test results for adulterants become available. If an establishment tests its product for an adulterant, releases the product into commerce, and results are

continued on page 5

continued from page 4

positive, FSIS will request that the establishment recall the product.

FSIS is aware of the impact of establishment verification testing on resources, particularly related to storage and handling and product shelf-life. Nonetheless, establishments should design their food safety system within their available resources to take all necessary and practical steps to ensure that only safe product enters commerce.

Enforcement

When this policy becomes effective, FSIS will follow its regulations at 9 CFR part 500, Rules of Practice. If an establishment fails to prevent products tested by FSIS for adulterants from entering commerce before negative test results are received, the establishment may have produced and shipped adulterated or

uninspected product. In this situation, the Office of Field Operations would take appropriate enforcement action (e.g., immediately suspending inspection or issuing a Notice of Intended Enforcement Action). Also, FSIS will request a voluntary recall of product, detain the product in commerce, or institute other product control actions if necessary. FSIS will consider additional enforcement actions or sanctions when necessary.

The North Dakota Meat and Poultry Inspection Program (NDMPIP) will follow FSIS policy on hold and test.

For details and more information, see www.fsis.usda.gov/Frame/FrameRedirect.asp?main=http://www.fsis.usda.gov/OPPDE/rdad/FRPubs/2005-0044FN.htm

Troubleshooting

Pathogens 101: Controlling Toxoplasma in Pork

By Dr. Dolores Hill on 2/13/2012

It doesn't carry the regulatory weight of *E. coli*, and it hasn't grabbed headlines the way *Salmonella* has, but *Toxoplasma* in pork – and the illness *Toxoplasmosis* – is a growing threat, the third leading cause of death from foodborne illness worldwide. A parasite with properties similar to *Trichinella spiralis* (*trichinae*), it can cause havoc in certain processed meats that have little thermal processing, but it is particular a threat to fresh meats.

The route of transmission to humans

Toxoplasma gondii infection in humans and animals is common, resulting from the parasite's ability to infect warm-blooded hosts by several transmission routes. Environmental contamination occurs easily through fecal matter. Post-natal infection in humans frequently occurs through inadvertant consumption of the infective oocyst stage in contaminated water, soil, or food, or through consumption of improperly prepared meat containing tissue cysts.

Consumption of oocysts or tissue cysts by food animals, including pigs, leads to infection of the animal, rendering its meat infectious to humans if improperly prepared for eating – similarly to other pathogens such

as *Salmonella*. It's so easily transmissible that just the handling of raw infected meat alone may lead to human infection.

Who's at risk

Previous studies have suggested that consumption of undercooked meat products containing *T. gondii* tissue cysts may account for a significant proportion of *Toxoplasma* infections in humans in the U.S.

There is an elevated risk of acquiring toxoplasmosis in people who consumed raw or undercooked beef and lamb as well as locally produced processed meats – as well those who reported working with meat. However, in a recent nationwide survey of fresh retail chicken, beef and pork in the U.S., only pork was found to harbor viable *Toxoplasma* tissue cysts. Viable tissue cysts were isolated from .38 percent of pork samples, and .57 percent of samples had antibodies to *Toxoplasma*.

Modern biosecurity management practices on swine farms, including restriction of human entry into pig barns, stringent rodent control, secure feed and exclusion of cats and other wildlife, have resulted in reduced levels of *Toxoplasma* infection in confinement raised

continued on page 6

continued from page 5

swine over the last 20 years to 2.7 percent from 23 percent in the United States. High rates of infection in “naturally raised” pigs. Although *Toxoplasma* infection in confinement raised market pigs has decreased significantly, infection levels in pigs with access to the outdoors can be quite high, reaching 50-90 percent in recent studies.

In the U.S. national meat survey mentioned above, two of seven *Toxoplasma*-positive pork samples were derived from “naturally raised” pigs. An upsurge in consumer demand for ‘organically raised,’ ‘humanely raised’ and ‘free range’ pork products has resulted in increasing numbers of hogs being raised in non-confinement systems. Swine producers have been recruited to produce animals for the organic market to fulfill a consumer demand that has increased 20 percent annually in sales since 1990. National Organic Program (NOP) standards now require that all organically raised animals must have access to the outdoors. Though ‘humanely raised’ and ‘free range’ products have standards that are less stringently defined, outdoor access is also considered a requirement for labeling.

Few studies have determined the prevalence of *Toxoplasma* infection in swine raised in organic management systems. In one study, 22 of 324 (6.8 percent) free-range pigs in North Carolina were seropositive for *Toxoplasma*, while just three of 292 conventionally raised pigs (1.1 percent) tested were seropositive.

In another study, not one of 621 conventionally raised pigs was seropositive for *Toxoplasma*, while 38 of 1,295 (2.9 percent) pigs raised in “animal-friendly” management systems were seropositive for *Toxoplasma*. Access to organic material contaminated with cat feces or to rodents or wildlife potentially infected with *Toxoplasma* during outdoor pasturage substantially increases the risk of exposure of pigs to *Toxoplasma*.

Traceability at the fore

These pigs enter the food chain because there is no national system of identifying individual pigs slaughtered in the United States. For practical purposes, it’s wise to consider that just about any commercial meat cut may therefore contain viable *T. gondii* tissue cysts. A single *T. gondii*-infected pig may be a source

of infection for many people, since one market-weight hog (100 kg or more) yields more than 600 individual servings of meat. Prevention of exposure is the only way to stop infection of pigs, since there is no vaccine or treatment available. Once infected, tissue cysts persist in pig tissues for the life of the hog.

Three ways to control T. gondii

Toxoplasma gondii organisms in meat may be killed several ways. One of the simplest is by exposure to extreme cold or heat. Meat of any animal should be heated throughout to 153°F, which kills tissue cysts, before consumption. Consumers, too, need to be ware that storage of meat at temperatures at or just below 32°F (standard meat case temperatures) for seven days kills tissue cysts, while cooling to 8°F kills tissue cysts instantly. *Toxoplasma* in tissue cysts also are killed by exposure to .5 kilorads of gamma irradiation. Retail meat cuts of pork are frequently enhanced with salt solutions to improve flavor, extend shelf life, reduce microbial contamination and improve tenderness.

Pumping solutions containing 2 percent sodium chloride or 1.4 percent potassium or sodium lactate is effective within eight hours of injection for killing *T. gondii* tissue cysts in pork loins. To prevent infection of human beings by *T. gondii*, the hands of people handling meat should be washed thoroughly with soap and water before they go to other tasks. All cutting boards, sink tops, knives and other materials coming in contact with uncooked meat should be washed with soap and water. Washing is effective because the stages of *T. gondii* in meat are killed by contact with soap and water.

Conclusion

Between changes made in both pig production and management systems over the last two decades, infections of pigs with *T. gondii* have reduced, although it remains prevalent in both human and animal populations and can still spread easily – and quickly – on the farm. Although plenty of advice can be given to consumers, both producers and processors need to know that since no vaccine to prevent toxoplasmosis in humans exists, responsibility for its prevention lies at all stages of the food chain.

www.meatingplace.com/Industry/TechnicalArticles/Details/31303

Classified Ads

We are always looking for industry related items to advertise in the Meat Messenger. We post sale and want ads FREE. If you would like to put something in the Meat Messenger classifieds contact Julie Nilges at 701-204-3248 or e-mail description with contact information to jnilges@nd.gov.

Offal (gut) cart: Made of galvanized steel, two wheels, good condition. Please contact Kelly for price and more information at 701-254-4950. Located in Linton.

Sipromac one truck smokehouse: Smokehouse has a Juno microprocessor and liquid smoke attachment. Included are two trucks and many sticks and screens. \$20,000, Please contact Calvin or Alex for more information at 701-743-4451. Located in Parshall.

True Brand cooler: Cooler has two sliding doors and was manufactured in 2001. \$1,000, Please contact Calvin or Alex for more information at 701-743-4451. Located in Parshall.

One-quart plastic containers with lids: Containers and lids are brand new, never been used. \$20 per lot of 50, Please contact Calvin or Alex for more information at 701-743-4451. Located in Parshall.

Prairie Packing Inc.: Slaughter and processing plant in Williston, ND. USDA #7644. 10.43 acres of land with 20,000 sq. ft. building and garage. 15,000 sq. ft. is leased. City sewer and water. Work is divided into 70% rancher/producer and 30% retail sales. 10 employees. Please contact Dave Slais for more information at dslais04@live.com.

Handtmann Stuffer VF 50: Very low hours, excellent condition. Linker, gear box, and several horns included. \$20,000, Please contact Wade for more information at 701-255-4534. Located in Bismarck.

Slaughter/processing business: Located near Maddock, 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 4 years. Very strong customer base. Please contact Denise for more information at: 701-438-2334.

Walk-in freezer and components: Three phase Copeland compressor Hp p62 Freon, new 2005. Model 4RA3-100A-TSK-800, serial 05A66497R.

Single phase Bohn cooling unit model 2402B serial DCD4540.

Larkin single phase outside evaporator.

Walk-in freezer with shelves/baskets, sharp freeze shelves & cooling unit, has 4-glass doors, free standing unit, walls snap together. Please contact Denise for more information at: 701-438-2334. Located in Esmond.

Berkel Commercial Meat Slicer: Newly reconditioned. For price or more information contact Larry Brenno at 701-996-2733. Located in Sheyenne.

In this Meat Messenger

- Cooperative Interstate Shipment Program
- ND Meat and Poultry Inspection Program is now on Facebook
 - Regulation Reminder
 - Written Recall Plan Reminder
 - HACCP Pre-requisite Programs
 - FSIS Announces Effective Date for Hold and Test
 - Pathogens 101: Controlling Toxoplasma in Pork
 - Classified Ads

“Equal Opportunity in Employment and Services”

www.nd.gov/ndda