

**Hazard Analysis and Critical Control Point (HACCP)  
Program  
PLAN - D Raw, Ground Meat and Poultry**

**by  
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Approved:

Signed: \_\_\_\_\_  
Name: \_\_\_\_\_  
Implementation Date: \_\_\_\_\_  
Revision, Date: \_\_\_\_\_

**Trade Secret/Confidential Commercial Information:**

This document contains trade secret/confidential commercial information pursuant to 5 U.S.C. 552 (b)(4).

**Product Category Description**

<b>Product: Raw, Ground: Beef, Pork, Lamb, Chicken, Turkey</b>		
<b>1. Common Name/Description:</b>		
<b>Beef</b> Beef Patties Ground Beef	<b>Pork</b> Pork Patties Ground Pork Pork Sausage Pork Sausage Patties Pork Sausage links	<b>Lamb</b> Lamb Patties Ground Lamb <b>Chicken</b> Ground Chicken <b>Turkey</b> Ground Turkey Turkey Sausage
<b>2. How is it to be used?</b> For further processing or for cooked meat items in home or food service meals		
<b>3. Type of Package?</b>		
Butcher freezer paper		
Vacuum packaged Plastic liners in boxes		
<b>4. Length of Shelf Life; at what temperature?</b> _18 months, frozen at _-10°F		
<b>5. Where will it be sold?</b>		
Loeffel Meat Lab to general public		
<b>6. Labeling instructions:</b>		
Safe handling instructions, Keep Frozen or Keep Refrigerated		
<b>7. Is special distribution control needed?</b> Frozen or refrigerated distribution		

Date: \_\_\_\_\_ Approved by: \_\_\_\_\_

## Product and Ingredients

<b>Product:</b>	<b>Raw, Ground:</b> Beef, Pork, Lamb, Chicken, Turkey
<b>Meat Ingredients:</b>	Beef, Pork, Lamb, Chicken, Turkey Carcasses, Primals or Parts, and Trim
<b>Non-Meat Ingredients:</b>	Water, Salt, Sugar, Spices, Flavorings, Proteins, Flours, Cereals, Starches, Acidulants, Lactates, Liquid Smoke Products, and other food ingredients [GRAS].
<b>Restricted Ingredients:</b>	Phosphates, BHA, BHT, and others not listed here but approved and GRAS
<b>Packaging Materials:</b>	Butcher Paper, Vacuum Bags, Plastic Bags & liners, boxes and other Containers approved for food container use.
<b>Casing:</b>	Natural casings, cellulose and collagen, plastic and others not listed here but approved.



<b>Hazard Analysis</b>				
<b>Product: Raw, Other</b>				
<b>Process Step</b>	<b>Potential hazard introduced, controlled or enhanced at this step B= Biological C= Chemical P= Physical</b>	<b>Does this potential hazard need to be addressed in the HACCP plan? (Yes or No)</b>	<b>Justification for decision made in previous column</b>	<b>What control measures can be applied to prevent, eliminate or reduce the hazards being addressed in the HACCP plan?</b>
Receiving of lean trim or subprimals from outside operations	B - Presence and growth of pathogens	Yes	Meat is a known source of pathogens and growth of pathogens could cause sever illness	Reduce temperatures to prevent growth of pathogenic bacteria
	C -None			
	P -metal, bone, plastic	No	Low occurrence according to plant experience	
Transfer of trim from fabrication operations	B -Presence and growth of pathogens	No	Low occurrence as temperatures are controlled in fresh meat not ground HACCP plan	
	C - None			
	P -Metal	No	Low occurrence according to plant experience	
Refrigerated Storage	B -Growth of pathogens	No	Low occurrence as refrigeration units are maintained a low temperatures to prevent growth	

<b>Hazard Analysis</b>				
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	C - None			
	P - None			
Freezer Storage	B -Growth of pathogens	No	Low occurrence as freezer units are maintained a low temperatures to prevent growth	
	C - None			
	P - None			
Formulation and grinding	B -Growth of pathogens	Yes	Bacterial pathogens could grow to levels with potential for moderate severity	Maintain low temperature of meat to prevent pathogen growth.
	C - Sanitizer residue	No	Low occurrence as plant has SSOP's	
	P - None			
Mixing	B -Growth of pathogens	Yes	Bacterial pathogens could grow to levels with potential for moderate severity	Maintain low temperature of meat to prevent pathogen growth.

<b>Hazard Analysis</b>				
<b>Product: Raw, Other</b>				
<b>Process Step</b>	<b>Potential hazard introduced, controlled or enhanced at this step B= Biological C= Chemical P= Physical</b>	<b>Does this potential hazard need to be addressed in the HACCP plan? (Yes or No)</b>	<b>Justification for decision made in previous column</b>	<b>What control measures can be applied to prevent, eliminate or reduce the hazards being addressed in the HACCP plan?</b>
	C - Sanitizer residue	No	Low occurrence as plant has SSOP's	
	P - None			
Package / Label	B -Cross Contamination with pathogens	No	Low occurrence as plant has SSOP's	
	C - None			
	P - None			
Freezer Storage	B -Growth of pathogens	No	Low occurrence as freezer units are maintained a low temperatures to prevent growth	
	C - None			
	P - None			
Refrigerated Storage	B -Growth of pathogens	No	Low occurrence as refrigeration units are maintained a low temperatures to prevent growth	

<b>Hazard Analysis</b>				
<b>Product: Raw, Other</b>				
<b>Process Step</b>	<b>Potential hazard introduced, controlled or enhanced at this step B= Biological C= Chemical P= Physical</b>	<b>Does this potential hazard need to be addressed in the HACCP plan? (Yes or No)</b>	<b>Justification for decision made in previous column</b>	<b>What control measures can be applied to prevent, eliminate or reduce the hazards being addressed in the HACCP plan?</b>
	C - None			
	P - None			
Sales	B -None			
	C - None			
	P - Dirt and dust	No	Low severity and low occurrence	
Receiving of non-meat ingredients	B -Pathogens	No	Low occurrence as indicated by spice supplier.	
	C - None			
	P - None			
Storage of non-meat ingredients	B -None			
	C - None			
	P - None			
Weighing	B -None			

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and formulation of non-meat ingredients	C - None			
	P - None			
Receive Packaging	B -None			
	C - None			
	P - None			
Store Packaging	B -None			
	C - None			
	P - None			

<p align="center"><b>Principle 2 - CCP Determination</b></p> <p><b>Product:</b> A critical control point is defined as a point, step or procedure at which control can be applied and a food safety hazard can be prevented, eliminated or reduced to acceptable levels.</p>						
Process step	Hazard Biological = B Chemical = C Physical = P	Q1. Does this step involve a hazard of sufficient risk and severity to warrant its control?	Q2. Does a preventive measure for the hazard exist at this step?	If Q2. is no: Is control at this step necessary for safety?	Q3. Is control at this step necessary to prevent, eliminate or reduce the risk of the hazard to consumers?	
Receiving of lean trim or subprimals from outside operations	B - Presence and growth of pathogens	Yes	Yes		Yes	CCP-1B
	C -					
	P -					
Formulation and grinding	B -Growth of pathogens	Yes	Yes		No	
	C -					
	P -					
Mixing	B -Growth of pathogens	Yes	Yes		No	
	C -					
	P -					
Package / Label	B -Growth of pathogens	Yes	Yes		Yes	CCP-2B
	C -					
	P -					



**Principles 3, 4 and 5  
Critical Limits, Monitoring and Corrective Actions**

**Product:**

Process Step/ CCP	Critical Limits	Monitoring Procedures (Who/What/When/How)	Corrective Actions
Receiving of lean trim or subprimals from outside operations	Meat temperature of less than 45°F	Who: Receiving operator What: Internal meat temperature or surface temperature of lean trim. When: At receiving of each load How: A calibrated thermometer will be inserted into box located near the rear of the truck on each load <b>or</b> a calibrated thermometer will be placed between two vacuum packaged cuts from one box near the rear of the truck on each load to measure temperature.	1. If temperature is above 45° F, notify supervisor for rejection of shipment. 2. Determine if the problem was from trucking refrigeration or shipment of warm product by supplier. 3. Notify supplier to correct problem. 4. Notify shipping company  In all other cases comply with guidelines in CFR Section 417.3.
Package / Label	Internal temperature of meat is less than 45°F	Who: Grinding room operator What: Internal temperature of meat prior to packaging for sale. When: Approximately every 2 hours or at the end of grinding before packaging if less than 2 hours since last measurement. How: A calibrated thermometer will be inserted into three randomly selected meat cuts that are ready for storage and packaging.	1) Discontinue processing, determine extent of product effected by checking additional temperatures, hold product and evaluate to determine disposition. If product is less than or equal to 50°F re-chill to less than 45°F in 2 hours. Dispose or redirect product over 51°F after review by Process Authority. 2) Check fresh meat cooler temperature and processing room temperatures. 3) Make repairs and adjustments to refrigeration if necessary. 4) Replace refrigeration equipment if necessary.

**Principles 3, 4 and 5  
Critical Limits, Monitoring and Corrective Actions**

**Product:**

Process Step/ CCP	Critical Limits	Monitoring Procedures (Who/What/When/How)	Corrective Actions
			5) In all other cases comply with guidelines in CFR Section 417.3.

**Principles 6 and 7  
Verification and Record Keeping**

**Product:**

Process Step/CCP	Records	Verification Procedures
Receiving of lean trim or subprimals from outside operations	<ol style="list-style-type: none"> <li>1. Product receiving temperature monitoring log w/daily review initials:</li> <li>2. CCP deviations/corrective actions log.</li> <li>3. Audit report of CCP monitoring activities.</li> </ol>	Daily review and initialing of the product receiving temperature monitoring log CCP-1B (including any corrective actions taken) and thermometer calibration log by the HACCP manager. Audit of CCP monitoring activities and procedures by the HACCP manager approximately every 3 months.
	<ol style="list-style-type: none"> <li>1. Ground meat temperature monitoring log.</li> </ol>	

**Principles 6 and 7  
Verification and Record Keeping**

**Product:**

<b>Process Step/CCP</b>	<b>Records</b>	<b>Verification Procedures</b>
Package / Label	2. CCP deviations/corrective actions log. 3. CCP monitoring activities audit report.	Daily review and initialing of the primal cut temperature monitoring log CCP-1B (including any corrective actions taken) and thermometer calibration log by the HACCP manager. Audit of CCP monitoring activities and procedures by the HACCP manager approximately every 3 months.
Overall plan	Thermometer Calibration log	Daily calibration of thermometers used to monitor CCP's by a designated employee.  Annual review of HACCP plan.

<b>HACCP Plan</b>							
<b>Product:</b>							
Process Step	Hazard Description	CCP Description	Critical Limit	Monitoring Procedures/ Frequency/ Person Responsible	Corrective Action/ Person Responsible	HACCP Records	Verification Procedures/ Person Responsible
Receiving of lean trim or subprimals from outside operations	B - Presence and growth of pathogens	CCP-1B	Meat temperature of less than 45°F	Who: Receiving operator What: Internal meat temperature or surface temperature of lean trim. When: At receiving of each load How: A calibrated thermometer will be inserted into box located near the rear of the truck on each load <b>or</b> a calibrated thermometer will be placed between two vacuum packaged cuts from one box near the rear of the truck on each load to measure temperature.	1. If temperature is above 45° F, notify supervisor for rejection of shipment. 2. Determine if the problem was from trucking refrigeration or shipment of warm product by supplier. 3. Notify supplier to correct problem. 4. Notify shipping company  In all other cases comply with guidelines in CFR Section 417.3.	1. Product receiving temperature monitoring log w/daily review initials: 2. CCP deviations/corrective actions log. 3. Audit report of CCP monitoring activities.	3) Daily review and initialing of the product receiving temperature monitoring log CCP-1B (including any corrective actions taken) and thermometer calibration log by the HACCP manager. 4) Audit of CCP monitoring activities and procedures by the HACCP manager approximately every 3 months.
Package / Label	B- Pathogen Growth	CCP-2B	Internal temperature of meat is less than 45°F	Who: Grinding room operator What: Internal temperature of meat prior to packaging for sale. When: Approximately every 2 hours or at the end of grinding before packaging if less than 2 hours since last measurement. How: A calibrated	1) Discontinue processing, determine extent of product affected by checking additional temperatures, hold product and evaluate to determine disposition. If product is less than or equal to 50oF re-chill to less than 45oF in 2 hours. Dispose or redirect	1. Ground meat temperature monitoring log. 2. CCP deviations/corrective actions log. 3. CCP monitoring activities audit report.	1) Daily review and initialing of the primal cut temperature monitoring log CCP-1B (including any corrective actions taken) and thermometer calibration log by the HACCP manager. 2) Audit of CCP monitoring activities and procedures by

<b>HACCP Plan</b>							
<b>Product:</b>							
Process Step	Hazard Description	CCP Description	Critical Limit	Monitoring Procedures/ Frequency/ Person Responsible	Corrective Action/ Person Responsible	HACCP Records	Verification Procedures/ Person Responsible
				thermometer will be inserted into three randomly selected meat cuts that are ready for storage and packaging.	product over 51oF after review by Process Authority. 2) Check fresh meat cooler temperature and processing room temperatures. 3) Make repairs and adjustments to refrigeration if necessary. 4) Replace refrigeration equipment if necessary. 5) In all other cases comply with guidelines in CFR Section 417.3.		the HACCP manager approximately every 4 months.