

**Hazard Analysis and Critical Control Point (HACCP)  
Program  
Raw, Not Ground**

**by  
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proved:

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, Not Ground:</b> Beef Primals, Sub-primals, Retail Cuts and Variety Meats Pork Primals, Sub-primals, Retail Cuts and Variety Meats Lamb Primals, Sub-primals, Retail Cuts and Variety Meats Chicken Carcasses, parts and giblets Turkey Carcasses, parts and giblets The following areas need to be defined when developing the product category description:	
<b>1. Common Name/Description:</b>	
<b>Beef Retail Cuts</b> <b>Beef Primals and Sub Primals</b> and all IMPS cuts made from beef carcasses <b>Beef Variety Meats</b> <b>Pork Retail Cuts</b> <b>Pork Primals and Sub Primals</b> and all IMPS cuts made from pork carcasses	<b>Pork Variety Meats</b> <b>Lamb Retail Cuts</b> <b>Lamb Primals and Sub Primals</b> and all IMPS cuts made from lamb carcasses <b>Lamb Variety Meats</b> <b>Chicken Carcasses, Parts and Giblets</b> <b>Turkey Carcasses, Parts and Giblets</b>
<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: \_\_\_\_\_

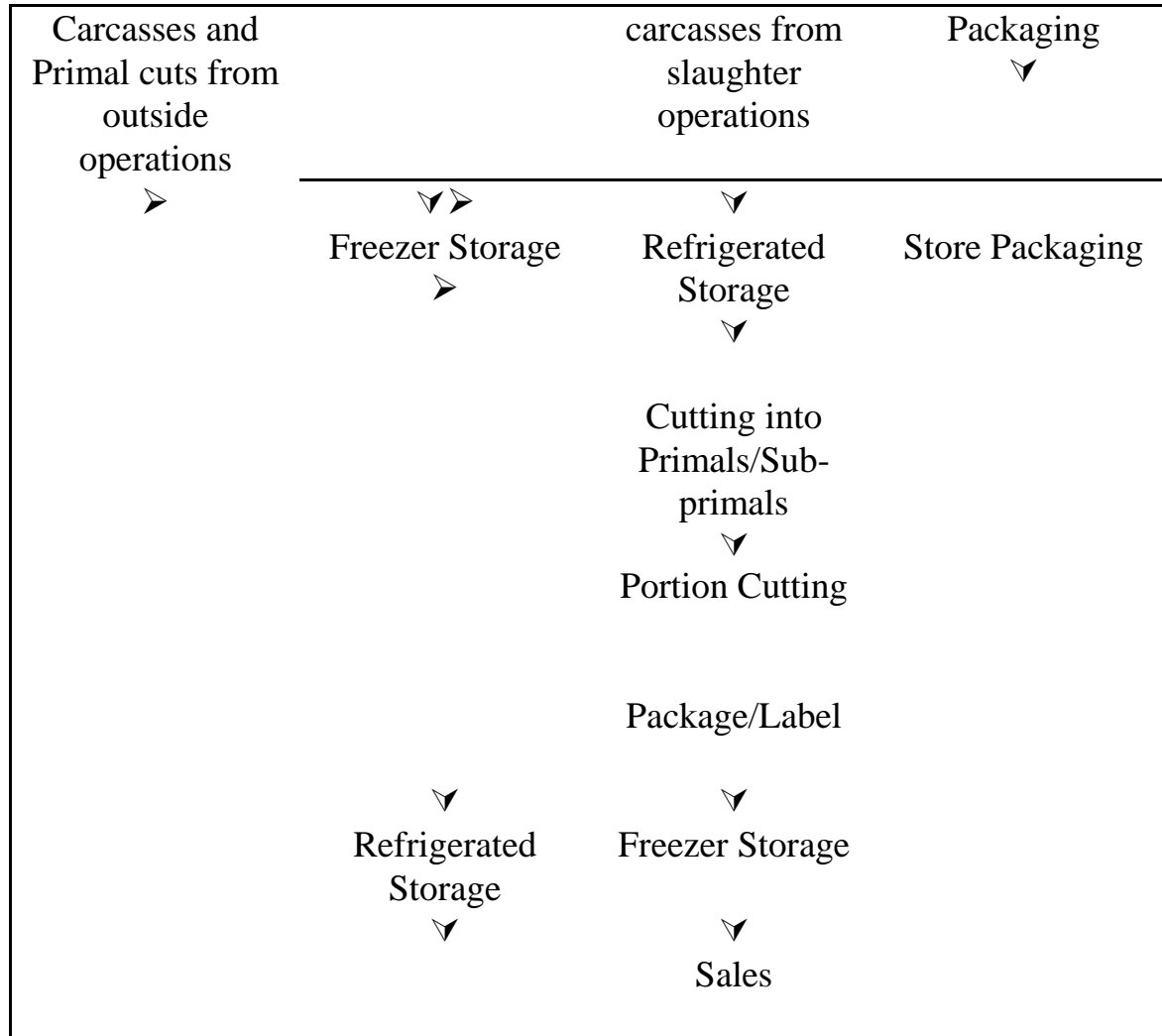
## Product and Ingredients

<b>Product:</b>	Raw, Not Ground - Beef Primals, Sub-primals, Retail Cuts and Variety Meats Raw, Not Ground Pork Primals, Sub-primals, Retail Cuts and Variety Meats Raw, Not Ground - Lamb Primals, Sub-primals, Retail Cuts and Variety Meats Raw, Not Ground - Chicken carcasses, parts and giblets Raw, Not Ground - Turkey carcasses, parts and giblets
<b>Meat Ingredients:</b>	Beef Carcasses, Beef Primals, Beef Sub-primals, Beef Variety Meats
	Pork Carcasses, Pork primals or Pork Sub-primals, Variety meats Lamb Carcasses, Lamb primals or Lamb Sub-primals, Lamb Variety Meats Chicken Carcasses, Parts and Giblets Turkey Carcasses, Parts and Giblets
<b>Non-Meat Ingredients:</b>	N/A
<b>Restricted Ingredients:</b>	N/A
<b>Packaging Materials:</b>	Butcher paper, vacuum bags, Plastic liners, bags and boxes
<b>Casing:</b>	N/A

## Process Flow Chart

**Product: Raw, Not Ground: Beef, Pork, Lamb, Chicken and Turkey**

Receiving of	Transfer of	Receive
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<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 Carcasses and Primal cuts 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 -Antibiotics	No	USDA monitoring indicates a very low occurrence	
	P -metal, bone, plastic	No	Low occurrence according to plant experience	
Transfer of carcasses from slaughter operations	B -Presence and growth of pathogens	No	Low occurrence as temperatures are controlled in slaughter HACCP plan	
	C - Antibiotics	No	USDA monitoring indicates a very low occurrence	

<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>
	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	
	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			

<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>
Cutting into Primals/Sub-primals	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			
Portion Cutting	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			

<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>
Packaging and labeling	B -Growth of Pathogens	Yes	Controlling temperature at this step will insure low meat temperatures throughout the process and reduce or prevent pathogen growth	Reduce meat temperature to prevent and reduce the growth of pathogens.
	C - None			
	P - None			
Receiving Packaging Material	B -None	No		
	C - None			
	P - None			
	B -None			

<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>
Storage of Packaging Material	C - None			
	P - Dirt and dust	No	Low severity and low occurrence	
Freezer Storage of packaged cuts	B -Growth of pathogens	No	Low occurrence as freezer units are maintained a low temperatures to prevent growth	
	C - None			
	P - None			
Refrigerated Storage of packaged cuts	B -Growth of pathogens	No	Low occurrence as freezer units are maintained a low temperatures to prevent growth	
	C - None			

<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>
	P - None			
Sales	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 Carcasses and Primal cuts from outside operations	B - Presence and growth of pathogens	Yes	Yes		Yes	CCP-1B
	C -					
	P -					
Cutting into Primals/Sub-primals	B -Growth of pathogens	Yes	Yes		No	
	C -					
	P -					
Portion Cutting	B -Growth of pathogens	Yes	Yes		No	
	C -					
	P -					

<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?	
Packaging and labeling	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 Carcasses and Primal cuts from outside operations	Meat temperature of less than 45°F	Who: Receiving operator What: Internal meat temperature or surface temperature of vacuum bagged product When: At receiving of each load How: A calibrated thermometer will be inserted into one carcass or cut 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.	<ol style="list-style-type: none"> <li>1. If temperature is above 45° F, notify supervisor for rejection of shipment.</li> <li>2. Determine if the problem was from trucking refrigeration or shipment of warm product by supplier.</li> <li>3. Notify supplier to correct problem.</li> <li>4. Notify shipping company</li> </ol> <p>In all other cases comply with guidelines in CFR Section 417.3.</p>
Packaging and labeling	Internal temperature of meat is less than 45°F	Who: Cutting room operator What: Internal temperature of meat prior to packaging for sale. When: Approximately every 2 hours	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

**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
		or at the end of cutting 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.	than 45°F in 2 hours. Dispose of product over 51°F 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.

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

**Product:**

Process Step/CCP	Records	Verification Procedures

<b>Principles 6 and 7 Verification and Record Keeping</b>		
<b>Product:</b>		
<b>Process Step/CCP</b>	<b>Records</b>	<b>Verification Procedures</b>
Receiving of Carcasses and Primal cuts 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>	<p>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.</p> <p>Audit of CCP monitoring activities and procedures by the HACCP manager approximately every 3 months.</p>
Packaging and labeling	<ol style="list-style-type: none"> <li>1. Primal temperature monitoring log.</li> <li>2. CCP deviations/corrective actions log.</li> <li>3. CCP monitoring activities audit report.</li> </ol>	<p>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.</p> <p>Audit of CCP monitoring activities and procedures by the HACCP manager</p>

<b>Principles 6 and 7 Verification and Record Keeping</b>		
<b>Product:</b>		
<b>Process Step/CCP</b>	<b>Records</b>	<b>Verification Procedures</b>
		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>							
Product: Raw, Ground Meat and Poultry							
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 carcasses and Primal cuts from outside operations	B- Presence and growth of pathogens	CCP-1B	Meat temperature of less than 45°F	Who: Receiving operator What: Internal temperature of meat prior to packaging for sale. When: Approximately every 2 hours or at the end of cutting 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 of product over 51°F 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.	1. Product receiving temperature monitoring log w/daily review initials: 2. CCP deviations/corrective actions log. 3. Audit report of CCP monitoring activities.	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. 3) Audit of CCP monitoring activities and procedures by the HACCP manager approximately every 3 months.
Packaging and labeling	Pathogen growth	CCP-2B	Meat temperature of less than 45°F	and packaging. Who: Cutting room operator	1. Discontinue processing, determine extent of product	1. Product receiving temperature monitoring log w/daily review	Daily review and initialing of the primal cut temperature

<b>HACCP Plan</b>							
Product: Raw, Ground Meat and Poultry							
Process Step	Hazard Description	CCP Description	Critical Limit	Monitoring Procedures/ Frequency/ Person Responsible	Corrective Action/ Person Responsible	HACCP Records	Verification Procedures/ Person Responsible
				<p>What: Internal temperature of meat prior to packaging for sale.</p> <p>When: Approximately every 2 hours or at the end of cutting before packaging if less than 2 hours since last measurement.</p> <p>How: A calibrated thermometer will be inserted into three randomly selected meat cuts that are ready for storage and packaging.</p>	<p>effected by checking additional temperatures, hold product and evaluate to determine disposition. If product is less than or equal to 50oIF re-chill to less than 45°F in 2 hours. Dispose of product over 51°F.</p> <p>2. Check fresh meat cooler temperatures.</p> <p>3. Make necessary repairs and adjustments to refrigeration if necessary.</p> <p>4. Replace refrigeration equipment if necessary.</p> <p>5. In all other cases comply with guidelines in CFR Section 417.3.</p>	<p>initials:</p> <p>2. CCP deviations/corrective actions log.</p> <p>3. Audit report of CCP monitoring activities.</p>	<p>monitoring log CCP-1B (including any corrective actions taken) and thermometer calibration log by the HACCP manager.</p> <p>4) Audit of CCP monitoring activities and procedures by the HACCP manager approximately every 3 months.</p>