



Beef Handling & Welfare Audit

FINAL SCORE **PASS / FAIL**

Plant Name: San Angelo Packing Co. Est. No.: 7209 - A Date: 6/12/2007

Auditor: Jarrod Miller Accompanied By: Robert Cope

	No. of Cattle in Question	Total Cattle Observed	Results
Electric Prodding	20 Prodded	100	20 % Prodded
Vocalization	0 Vocalized	50	0 % Vocalized
Slips and Falls	0 Fell 0 Slipped	50	0 % Fell 0 % Slipped
Stunning Accuracy	5 Double Stunned	100	5 % Double Stunned
Insensibility	0 Sensible	50	0 % Sensible

	Possible	Actual
Livestock Receiving	125	115
Condition of Livestock	75	75
Holding & Handling	250	225
Lead-Up and Stunning Area	475	455
Employee Training	75	75
Total	1000	945
		94.5 %

SCORES OF 90% OR BELOW RESULT IN AUTOMATIC FAILURE AND REQUIRE A RE-AUDIT IN 60 DAYS

	Guidelines	Observations	Score	
Livestock Receiving	Transporter expectations	Must have written expectations & humane guidelines for transporters.	Written Policy: Drivers are required to adhere to all company welfare policies. Drivers sign-off that they understand the policies.	25 / 25
	Animal spacing / load density	Must comply with NIAA recommendations: 1000# cattle = .6 cattle per running foot 1200# cattle = .5 cattle per running foot 1400# cattle = .4 cattle per running foot	Actual: 20-40 head per load depending on cow size and trailer type. Verification Records: Number of cattle per trailer is recorded on the check-in log.	25 / 25
	Trailer conditions: sanitation and maintenance	Trailers must be cleaned at least once each week to prevent heavy accumulation of feces. Manure should not surpass hooves. Trailers must have slip resistant floors, and no potential injury points (broken gates, sharp metal edges, etc.).	Actual: Trailers were in good condition. No injury points were noted. Verification Records: Not recorded.	15 / 25
	Ramps and unloading area conditions: sanitation and maintenance	Ramps, unloading area, scale should be slip resistant, $\leq 20^\circ$ slope, with no accumulated manure or standing water. Record all potential injury points (broken gates, sharp metal edges, etc.) in unloading area.	Actual: The ramp and unloading areas were in good condition. New unloading areas have been built and are going to be used. Slip proof floors. Verification Records: Management conducts walk throughs and reports any findings.	25 / 25
	Use of prods	Use of electric prods at unloading should be discouraged by plant. <5% of animals should be electrically prodded. Record what other prods are in use.	Actual: No prods were used. Verification Records: Not allowed per company policy.	25 / 25



	Guidelines		Observations	Score
Condition of Livestock	Non-ambulatory animals – receiving	Fallen stock from the producer are not to be loaded. The only non-ambulatory animals accepted are those injured in transport (injured stock). Injured stock numbers must be tracked.	Written Policy: Non-ambulatory animals are not allowed in the plant. Injured stock is euthanized prior to unloading. Records: Dead animals and non-ambulatory animals are recorded on a log.	25 / 25
	Non-ambulatory animals – movement	Non-ambulatory animals must be stunned prior to movement. Must have written procedures for handling non-ambulatory animals in the chute as well as in the pens.	Actual: None observed. Written Procedures: Animals must be rendered unconscious prior to movement. Animals in the chute are also addressed.	25 / 25
	Dead-on-arrival animals (DOAs)	Staging of dead carcasses should be out of public view. DOAs must be tracked.	Actual: Deads were stored behind the pens out of view. Records: Yard log records all dead animals.	25 / 25
Holding & Handling	Adequate protection from elements Adequate ventilation / cooling	Record observations, air temperature, & heat stress index or wind chill index. All pens must have water sprinklers / misters or covered pens. Must have written procedure for handling of over stressed, over heated, or long haul animals.	Actual: Pens were covered. Approximately 90°F. Verification Records: Management reviews. Written Procedure: No written procedures.	15 / 25
	Length of time animals held	Animals must be held a minimum of 1 hour after unloading	Written Policy: Animals are held at least 1 hour.	25 / 25
	Conditions of pens and alleyways: sanitation and maintenance, potential distractions	All pens must have slip resistant floors and be cleaned or bedded daily. Manure should not surpass the hoof of the animal and standing water should not be present. Record all potential injury points (broken gates, sharp metal edges, broken concrete, etc.) and potential animal distractions in alleys and pens (poor design, poor lighting / shadows, out of place objects, noises, debris, etc.)	Actual: One hay ring was broken leaving several possible injury points. Verification Records: Management review.	10 / 25
	Slips and falls	Determine number of slips and falls out of 50 head and record probable causes. Evaluate at the most probable area. Fall is determined if brisket or belly touches floor. Excellent = no slips or falls 100 pts Acceptable = slips by $\leq 3\%$ 90 pts Not acceptable = $\geq 1\%$ fall, $> 3\%$ slip 0 pts If unacceptable conditions are found in the first sample, the sample size must automatically be doubled to ensure a serious problem does not exist.	Actual: 0/50 Verification Records: Daily welfare audits.	100 / 100
	Escaped animals	Plant must have written procedure outlining humane handling of escaped cattle.	Written Procedure: A procedure was available for review.	25 / 25
	Animal spacing / pen stocking density: holding pens and crowd pen	Must allow for ease of mobility and access to water in holding pens. Crowd pen should be under $\frac{3}{4}$ full and crowd gate should not be used to push animals.	Actual: Animals had enough space. Crowd pens were also not crowded. Verification Records: Log sheet records number of animals in each pen.	25 / 25
	Accessibility to feed and water	All pens must have unrestricted access to potable water. Troughs should be regularly cleaned and water cannot be frozen. Animals must have access to feed if held over 24 hours.	Actual: Hay bales are available for animals held overnight. Each pen had water available. Verification Records: Daily management review checks water and feed availability in the yards.	25 / 25



		Guidelines	Observations	Score
Lead-Up & Stunning Area	Conditions of crowd pen, chute, restrainer, knock box area: sanitation and maintenance, potential distractions	Floors must be slip resistant and cleaned daily. Manure should not be excessive and standing water should not be present. Record all potential injury points (broken gates, sharp metal edges, etc.) and potential animal distractions (poor design, poor lighting / shadows, out of place objects, noises, debris, etc.) in crowd pen, chute, restrainer, knock box area. Guns should be torn down, cleaned, and inspected each shift. Rearing or struggling should be minimal. Must have a back-up stunner. Record type and brand of stunner and type of restrainer or knock box. Air injected stunners are prohibited.	Actual: Flooring was slip proof. Knock box was used. Animals were stunned with a Jarvis stunner. A captive bolt penetrating stunner was also used. No injury points were noted. Verification Records: Cleaned and inspected daily. Written PM Program: Daily, weekly and monthly work orders filled out on all Stun guns.	75 / 75
	Use of electric prods from crowd pen to restrainer / knock box	If chain speed is >200/hr., evaluate 100 animals. If speed is >100/hr., evaluate 75. If speed is <100/hr, evaluate 50 animals. Record percentage of animals electrically prodded and probable cause. Electric prods should only be used when necessary and not on the facial, anal, or genital regions. Other primary prods should be in use. Electric prods should not be used in holding area or crowd pen. Excellent = ≤5% prodded 100 pts Good = ≤15% prodded 95 pts Acceptable = ≤25% prodded 90 pts Not acceptable = >25% prodded 0 pts	Actual: 20/100 = 20% Prods were used correctly. Verification Records: Daily welfare audits.	90 / 100
	Vocalization from crowd pen to restrainer / knock box	If chain speed is >200/hr., evaluate 100 animals. If speed is >100/hr., evaluate 75. If speed is <100/hr, evaluate 50 animals. Record percentage of animals that vocalized and probable cause. Excellent = ≤1% vocalize 100 pts Acceptable = ≤3% vocalize 90 pts Unacceptable = >3% vocalize 0 pts If unacceptable conditions are found in the first sample, the sample size must automatically be doubled to ensure a serious problem does not exist.	Actual: 0/50 = 0% Verification Records: Daily welfare audits	100 / 100
	Stunning accuracy	If chain speed is >200/hr., evaluate 100 animals. If speed is >100/hr., evaluate 75. If speed is <100/hr, evaluate 50 animals. Record percentage of animals that were stunned twice and probable cause. Planned double knocking of bulls is prohibited. Excellent = ≤1% double stunned 100 pts Acceptable = ≤5% double stunned 90 pts Unacceptable = >5% double stunned 0 pts If unacceptable conditions are found in the first sample, the sample size must automatically be doubled to ensure a serious problem does not exist.	Actual: 5/50 = 10% Retest - 0/50 = 0% Verification Records: Daily welfare audits	90 / 100



	Guidelines	Observations	Score
	<p>Insensibility</p> <p>If chain speed is >200/hr., evaluate 100 animals. If speed is >100/hr., evaluate 75. If speed is <100/hr, evaluate 50 animals.</p> <p>Record percentage of animals exhibiting characteristics of insensibility on rail prior to stick.</p> <p>Insensibility characterized by floppy head, straight tongue hanging out, no righting reflex, eyes in blank stare (no eye tracking), no natural blinks.</p> <p>Excellent = 100% insensible 100 pts Acceptable = >99% insensible 90 pts Unacceptable = ≤99% insensible 0 pts</p> <p>If unacceptable conditions are found in the first sample, the sample size must automatically be doubled to ensure a serious problem does not exist.</p>	<p>Actual: 0/50</p> <p>Verification Records: Daily welfare audits</p>	<p>100 / 100</p>
Training	<p>Employee training</p> <p>The company's training program must reflect company procedures and policies for livestock receiving, condition of livestock, holding and handling, lead-up and stunning area. Retraining should be at least annual.</p>	<p>Written Program: Employees are trained prior to starting in the yards. Employees receive annual training over animal handling. Records were available for review.</p>	<p>75 / 75</p>



The facility Animal Handling Manual and associated records must include the following:

Livestock Receiving

- Written expectations & humane guidelines for transporters
- Verification of load density
- Verification of trailer condition: sanitation and maintenance
- Verification of unloading area conditions: sanitation and maintenance
- Verification of frequency of electrical prod use

Condition of Livestock

- Written downer policy: Fallen stock from the producer may not be loaded. The only downed animals accepted are those injured in transport (injured stock)
- Tracking of injured stock numbers
- Written procedures outlining handling of animals that become non-ambulatory in the pens as well as in the single file chute
- Tracking of DOA numbers

Holding & Handling

- Written procedure outlining handling of over stressed, over heated, or very long haul animals
- Verification that adequate protection from the elements is employed
- Written policy outlining a minimum rest time of one hour after unloading
- Verification of pen and alleyway conditions: sanitation and maintenance, potential animal distractions
- Verification that slips and falls are not occurring in excess of limits
- Written procedure outlining humane handling of escaped cattle
- Verification of pen and crowd pen density
- Verification of unrestricted access to water

Lead-Up & Stunning Area

- Verification of crowd pen, chute, restrainer, knock box conditions: sanitation and maintenance, potential animal distractions
- Outline of preventive maintenance program for guns, restrainers, knock box
- Verification of frequency of electrical prod use from crowd pen to restrainer / knock box
- Verification of amount of vocalization from crowd pen to restrainer / knock box
- Verification of frequency of double stuns
- Verification of frequency of sensible animals on the rail

Training

- Outline of training content
- Records from training and re-training sessions



Company: San Angelo Packing Co.

Contact: Robert Cope

Date: 6/12/2007

Auditor: Jarrod Miller

Category Number	Line Item	Requirement	Task	Method	Compliance Yes/No	Comments
1	1	No Downers- Any animal that does not walk into the knocking-box is considered a downer. Meat from downer animals is not allowed to go into edible products. If an animal goes down after passing ante mortem inspection, it is not acceptable for use in supplier raw materials.	Confirm documented procedures exist which (i) correctly define a downer, and (ii) adequately describe how downers are handled.	Document Review	Yes	Downers were not allowed in the plant. Downers were condemned and sent to an outside rendering company.
	2		Inspect all pens to see if any downers are present. If downers are present, observe that proper disposition has been/ is occurring and appropriate documentation is being completed.	Direct observation	Yes	No downers were present.
	3		Determine if records are available to confirm compliance with this requirement through recording occurrence of downers and their disposition.	Document review	Yes	Tickets are available listing the disposition of the animals in question.
1	4	No Air Injection stunning.	Verify that air injection stunning is not being performed.	Direct observation and inquiry	Yes	
1	5	No mechanically deboned meat (MDM) or meat from Advanced Meat Recovery Systems (AMR) may be used in trim.	Verify that production segregation is adequate to ensure no MDM or AMR product can potentially be introduced into raw materials.	Direct observation	Yes	None produced in the plant.
	6		Observe to see if MDM or AMR is being produced and if so, verify that appropriate records are available.	Direct observation and document review	Yes	
1	7	Facility has established procedures to ensure complete removal of Specified Risk Material (SRM) from each carcass.	Tissue defined as SRM, including spinal cord, dura, distal illuerm, and dorsal root ganglia from all ages of cattle must be removed.	Document review	Yes	Brains, skulls, eyes, spinal cord, trigeminal ganglia, DRG, tonsils and the distal illuerm were designated as SRM. The plant only processes cows and bulls.
	8		Confirm (i) documented procedures exist for the removal of all SRM, and (ii) operator practices are consistent with these procedures.	Direct observation and document review	Yes	Documented procedures were available for removal of spinal cord and sheath. DRG and vertebral column were addressed including mis-split carcasses.

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Category Number	Line Item	Requirement	Task	Method	Compliance Yes/No	Comments
1	9	Facility has established procedures to ensure complete removal of Specified Risk Material (SRM) from each carcass. (cont'd)	Confirm (i) documented procedures exist for the visual inspection of each carcass to ensure complete removal of spinal cord and dura prior to entry into the cooler, or in the case of hot boning operations, into the boning room, and (ii) operator practices are consistent with these procedures.	Direct observation and document review	Yes	QA checks every carcass on the kill floor. During zero tolerance inspections the spinal cord was also addressed. Carcasses are also examined in the cooler for spinal cord and dura.
1	10	No product from an animal that is tested for BSE may be allowed unless a negative result is obtained.	Confirm segregation procedures exist for all BSE test animals.	Document review	Yes	Tested animals are condemned.
2	11	Lotting procedures are identified to minimize the potential for cross contamination of animals that enter the facility if they have been tested for BSE.	Ensure (i) carcasses are clearly identified and segregated in the cooler, (ii) all other parts of the animal are identified and segregated, (iii) all carcasses and other parts are prohibited from trim products until test results are determined, and (iv) traceability/disposition records are available for BSE test animals.	Document review and direct observation	Yes	Tested animals are condemned and sent to a third party rendering company.
1	12	Programs exist to prevent cross contamination during production by SRM from carcass to carcass.	Confirm (i) documented procedures exist prescribing the use of dedicated tools/ equipment for the severing of the spinal cord at head removal, and removal of the spinal cord and dura at all relevant work stations, and (ii) operator practices are consistent with these procedures. Tools and equipment used to remove SRMs shall not be used on edible tissue.	Document review and direct observation	Yes	Procedures where available for plugging knock holes in the heads. Tonsils and eyes were also addressed. Dedicated equipment was used to drop heads.
2			Confirm (i) documented procedures exist prescribing the use of dedicated sterilizers at all SRM removal stations, and the cleaning of the splitting saw between carcasses to prevent build up, and (ii) operator practices are consistent with these procedures.	Document review and direct observation	No	Sterilizers were not segregated.
2	13	Employees responsible for all SRM related activities are adequately trained.	Confirm employee training and competency verification records are available.	Document review and inquiry of employees	Yes	Employees on the kill floor were trained over SRM procedures and importance. Records were available.
2	14	SRM is removed as potential source of contamination	Confirm (i) all SRM is properly labeled, segregated, and disposed of, and (ii) records are available to verify ongoing compliance.	Direct observation and document review	Yes	SRM is rendered.

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