



## HACCP MANUAL

Oakey Beef Exports Pty Ltd No: 558

### HACCP STATEMENT OF COMPLIANCE 2017

1. Oakey Beef Exports Pty. Ltd. (Establishment 558) is an approved slaughtering and boning Establishment, Registered to export to 24 countries plus 28 EU member States of bovine meat, and bovine offal.
2. The Company has in place a fully documented HACCP-based quality assurance **Approved Arrangement**, which has been established by the Australian Government's Department of Agriculture and has been assessed and approved by Departmental.  
The Approved Arrangement:
  - Complies with Departmental guidelines for meeting FSIS Pathogen Reduction/HACCP requirements.
  - Is audited by on-plant Departmental supervisors.
  - Audited at regular intervals by external Departmental Veterinary officers.
  - Has been subjected to detailed verification audits by external Departmental auditors and found to meet Departmental and FSIS requirements.
3. Est. 558 has taken the necessary steps to prohibit the slaughter of non-ambulatory disable cattle and the elimination of specific risk materials (SRM) from the human food chain. The Approved Arrangement BSE Firewall SOP's provides clear and concise work instructions as to the handling and exclusion of SRM materials from the processing of meat and offal as determined by the AQIS Meat Notice 2004/04 and FSIS Interim Final Ruling Notice 9-04. These procedures have been audited by Departmental and 3rd party Commercial auditors and found to be compliant with the Departmental FSIS regulations.
4. Est. 558 HACCP Plan has 3 CCP's:
  - CCP1A, CCP1B (Carcase and Offal).
  - CCP2A, CCP2B, CCP2C, CCP2D (Refrigeration).
  - CCP3 (Hot Bone).All CCP's are verified through our process flow charts.
5. In relation to Shiga toxin-producing *E. coli* (STEC), establishment 558 confirms that its HACCP Plan is reassessed annually in accordance with 'Federal Register Notice 9 CFR Part 417 Docket Number 00-022N dated 7 October 2002 and titled *E. coli* 0157:H7 Contamination of Beef Products and as per Market Access Advice (Ref: MAA1231).



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6. Est. 558 HACCP Plan has 2 CCP in place that reduces STEC to undetectable levels. The 1<sup>st</sup> CCP1A is on the Slaughter floor after the final carcass hygiene trim where the critical limit is: *No clearly visible faecal, ingesta, milk or urine contamination to be detectable on the carcass after the hygiene trimming is completed.* The 2nd CCP2 (Refrigeration) has been identified as carcass chilling where the critical limit, is *the reduction in surface temperature to <7°C within 24 hours of stunning* and there after maintaining surface temperature of no warmer than 7°C on all surfaces of the carcass so as to achieve refrigeration index (RI) criteria:
  - Average of RI < 1.5.
  - 80% of RI's < 2.
  - Maximum RI = 2.5.
7. The reassessed HACCP Plan includes interventions and other measures of prevention or corrective actions as recommended by the FSIS.
  - Washing or rejection of cattle with heavy hide faecal contamination (verified by inspection of hide-on carcasses by Quality Assurance Assessors).
  - Occlusion of the oesophagus after stunning and/or bleeding (verified by observation by Quality Assurance Assessors of nominated Operatives carrying out their work procedures).
  - Use of 2 knives for hide removal procedures (verified by observation by Quality Assurance Assessors of hide removal Operatives carrying out their work procedures).
  - Identification, using tags, of carcasses where faecal/ingesta leakage is suspected or occurs during dressing procedures which prepare for removal of the gastrointestinal tract (verified by observation by Quality Assurance Assessors of nominated Operatives carrying out their work procedures).
  - Tagged carcasses subjected to intensified inspection and, where necessary, intensified trim and operational sanitation procedures prior to chilling (verified by observation by Quality Assurance Assessors of the nominated trimmer carrying out his/her work procedures).
  - After the final carcass hygiene trim on the Slaughter Floor where the critical limit is, the carcasses go through a De-Contamination Unit to further reduce STEC to a manageable level.
  - Carcass surfaces are rapidly dry chilled to < 7°C prior to boning. Further cooling (chilling or freezing) of boned meat does not exceed the time/temperature requirements of the Australian Standard AS:4696 2007.
8. The efficiency of those interventions is verified by microbiological testing of boned meat product for the presence of STEC using the N = 60 protocol stated in AQIS Meat Notice 2010/03 *Escherichia coli 0157:H7 testing of raw ground beef components destined for export to the US and US Territories* and as per Market Access Advice (Ref: MAA1231).
9. Under Est.558 Oakey Beef Exports STEC testing program, at least 12 in 700 bulk pack cartons are randomly tested for STEC. Each test carton is sampled by taking 5 samples totalling 31.5 grams from that carton and testing a composite sample of 375gms from the 12 cartons. Screening is conducted by our Department of Agriculture approved laboratory using mEHEC media enrichment and BioControl detection (Genetic Detection System, GDS). Any positive screens are sent to Symbio laboratory for confirmation by Cultural and Polymerase chain reaction methods of high sensitivity. During the 2017 production year, we performed 901 STEC tests on frozen loads. Each test is made up from meat out of 12 cartons; therefore we have sampled 10812 frozen cartons. Two (2) tests were detected as positive for 2017.



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10. Following the reassessment of Establishment 558's HACCP Plan and its continued effective operation, as detailed above, Establishment 558 has concluded that the prevalence of STEC has been reduced to manageable levels. The protocol regime is testing for all 7 STEC (026, 045, 0103, 0111, 0121, 0145 and O157:H7) for all US loads destined for grinding. Oakey Beef Exports Pty Ltd is committed to producing the highest quality and safest product possible.
11. The company has declared all meat product as allergen free.  
Hand cleaning procedures are in place to minimise allergens entering the production areas.

If you require further information, please feel free to contact me.

Yours sincerely,

Pat Gleeson  
General Manager