



Hilltop Meats Pty Ltd  
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ABN 82 143 273 349

## Hilltop meats Pty Ltd

### Establishment 128

### 2019 HACCP Letter of Guarantee

To Whom it may concern,

Hilltop Meats Pty Ltd is registered by the Australian Government Department of Agriculture to process, bone, and store bovine meat and meat products for export markets.

#### HACCP Plan

Hilltop Meats Est. 128 HACCP plan has been audited and approved by the Department of Agriculture. It is the basis of the Approved Arrangement which includes Standard Operating Procedures, Work instructions and the HACCP Plan and is designed to identify Food Safety Hazards including Physical, Biological, Chemical, and Quality Hazards.

The Approved Arrangement and HACCP Plan scope includes the Receival and handling of listed species from Slaughter, Boning, Processing, Chilling and freezing through to dispatch of meat and meat products for domestic and export markets.

Re-assessment of HACCP is conducted annually and final approval is given by the Department of Agriculture.

At Hilltop Meats Pty Ltd Est. 128 re-assessment of our HACCP plan is in line with 9 CFR Part 417 *E.coli 0157: H7 Contamination of Beef Products*, and FSIS Directive 10,010.1

*E.coli 0157:H7* is a microbiological hazard likely to occur in the live animal. Due to the effective and continuous implementation of Sanitary Standard Operating Procedures, training and monitoring of work instruction, Meat Hygiene Assessment, ESAM Testing, *E.coli 0157:H7* and STEC Testing, current CCP's implemented by Est. 128, *E.coli 0157:H7* is a hazard that is not likely to occur on meat and meat products produced at Hilltop Meats Pty Ltd.

#### Control Measures and Interventions

The re-assessed HACCP Plan includes the following control measures and interventions:

- An assessment of animals is conducted on arrival to determine the pre-slaughter condition of livestock prior to being washed.
- Washing of animals pre-slaughter with potable water at a pressure rate acceptable to animal welfare requirements to remove soiled or dirty animals.
- Ante-mortem inspection of all animals conducted by the On Plant Veterinary Officer (Department of Agriculture)

- Identification and segregation of all animals that may be ill or are injured, including non-ambulatory livestock. These animals or associated products are not eligible for export.
- Occlusion of the oesophagus after stunning and prior to hoisting,
- Application of a bag to the tail to deter cross contamination,
- Use of a ballpoint blade on a brisket saw,
- Application of a plastic bag and seal of the bung.
- Post Mortem inspection by a qualified Meat Inspector who is appointed by the Department of Agriculture.
- Individual inspection of each carcase to ensure that no visible defects are remaining.
- Process and product monitoring and trend charts assessed for compliance to MHA procedures.
- All operators are trained in their written work instructions on a regular basis. All new employees are trained in personal hygiene and sanitation procedures prior to commencement of employment.
- Processing speeds are monitored to provide adequate time for the hygiene trimming.
- Freezing of products in accordance with the E C(M&MP) O's Export Control meat and meat products Orders.

All control measures and interventions are designed to reduce, eliminate or control E.coli 0157: H7 and nominated STEC's.

These control measures are verified by microbiological testing for E.coli 0157:H7 in accordance with Meat Notice 2012/03 STEC testing of Raw Ground Beef Components destined for the US and US Territories. (N=60 sampling plan)

For the purpose of raw ground beef components destined for grinding in the US for E.coli 0157:H7, a lot is defined as comprising frozen cartons of beef components not exceeding 700 cartons contained within any single shipping container of raw ground beef components destined for the US.

Est. 128 is a Hot Boning Process. The company's program has been developed by the CSIRO and designed with a strict protocol for time temperature requirements that is exercised together with effective freezing and have a 1-3 reduction in growth of micro organisms including pathogens such as E.coli 0157:H7 and non 0157:H7 STEC.

It has been validated by Food Science Australia that the company's Hot Boning Program can meet these time temperature requirements and has been approved by the Department of Agriculture. Ongoing validation that the time temperature requirements are met is by the data collected through the placement of a data logger into a carton of product during the freezing process.

## Specified Risk Materials

All downer cattle or cattle that cannot make its way to the knocking box are deemed as not eligible to the US. They are either slaughtered for a non-US market or destroyed and condemned and sent to the rendering plant. The decision will be made by the OPVO at ante-mortem inspection.

The following is a list of intervention steps introduced to prevent contamination of carcasses during processing from *E.coli* O157:H7 and non O157 STEC.

## Livestock Receival and Handling

- Cattle under go ante mortem inspection prior to slaughter by authorised DA officer
- Lairages are kept clean, pens hosed out between individual lots and race ways hosed as necessary to remove zero tolerance contamination
- Cattle are handled quietly and humanly prior to and during lairage to avoid stress
- Cattle are washed prior to slaughter to ensure hides have a minimal of zero tolerance contamination when presented for slaughter. In addition, cattle receive a final potable body wash to dampen hair to avoid fall out from hide during processing
- Documentation is maintained to ensure traceability
- A Quality Assurance Officer and Supervisors monitor procedures from cattle receival to stunning

## Slaughter Floor Operations

- Control of the chain speeds, manning levels and operators training are adhered to
- All dressing procedures are preceded by operator washing hands with soap and water and sterilising knives and equipment in 82°C water
- Oesophageal occlusion plugs are inserted prior to hoisting
- Operators are trained using work instructions designed to eliminate contamination of carcasses.
- The bung is bagged and pushed into the abdominal cavity prior to the removal of the hide
- The hide is removed avoiding contact with the dressed carcase.
- A ballpoint brisket saw blade is used to avoid rupturing the paunch.
- Carcasses contaminated during evisceration are tagged and trimmed on the retain rail to remove visible zero tolerance contamination.
- Carcasses and carcase parts are inspected by an authorised DA officer.
- All head meat is inspected to ensure no visible zero tolerance remains on the head meat prior to entry to the offal room.
- All carcasses are inspected and trimmed to ensure no visible zero tolerance remains on the carcase prior to leaving the slaughter floor

- A Quality Assurance Officer and Supervisor monitors all slaughter floor and offal room procedures and product, from slaughter floor to carcass chilling or hot boning. ABN 82 143 273 349

**Boning Operations**

- Boning room temperature is maintained at or below 10°C
- Product is under active refrigeration within 2 hours from stunning
- Chilled product is reduced to ≤5°C within 24 hours of boning
- Chilled product is stored between 0°C and -2°C
- Frozen product is stored at or below -18°C

List of Critical Control Points within the HACCP Plan

CCP 1	Beef Slaughter Floor Hygiene Trim including retain rail	No visible contamination with faecal material, ingesta, or milk (zero tolerance) on the surface of any carcass after leaving the hygiene trim or retain rail on the slaughter floor
CCP 2	Offal Trimming	Removal of zero tolerance from head meat, cheek meat and weasand meat.
CCP 3	Chilled carcass Temperature	Carcasses are chilled to <7°C within 24 hours of stunning.
CCP 4	Chilled Offal Temperature	Offal is chilled to <5°C within 24 hours of stunning.

**Approved Arrangement – Supporting Documents**

- Pre operational sanitation
- Cleaning and Sanitation
- Personal Hygiene
- Waste Control
- Water Supply
- Pest Control
- Structure and Maintenance
- Control of Hazardous substances
- Sourcing animals for slaughter
- Purchasing
- Animal Welfare
- Slaughter
- Boning
- Temperature Control
- Calibration
- Sampling
- Control of SRM
- Meat Hygiene Assessment
- Foreign Object Control
- Product Traceability and Recall
- Export Security and Integrity
- Control of Official Marks
- Management Review
- Internal Audits





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- Corrective action and control of non conforming product
- Training

A pre-shipment review of records relating to HACCP and supporting programs is conducted daily to confirm that only product that has tested negative for *E.coli* O157:H7 and non O157:H7 STEC, and is compliant with our HACCP program is shipped to the U.S.A.

Hilltop Meats is committed to producing quality; food safe product through strict adherence to all elements of its HACCP based Food Safety Program and customer country requirements.

Sincerely,

Dale Andrews

Quality Assurance Manager

09.01.2019

Hilltop Meats Pty Ltd