

**Table: PBIS NonCompliance Reports for Plants requested in FOIA 2011-00258 for 03J01 and 04C04 1st Shift Procedures from 3/1/11 - 8/31/11**

NRNumber	EstID	EstNbr	EstName	State	Date	Shift	Procedure	Regulation Cited	Description
0036-2011-14373	2230	00018 P	Cargill Meat Solutions Corp.	VA	23-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 0740 hours while performing a scheduled Food Safety Verification test of CCP- <sup>(b)(4)</sup> on line <sup>(b)(4)</sup> (toms), I observed fecal material on bird eight of my ten bird random sample. The fecal was located on the right inside thigh area and just inside the opening cut and measured approximately 3/8 inches in diameter, greenish brown in color and was of a pasty consistency. I immediately notified Evisceration Supervisor, <sup>(b)(6) (b)(7)(C)</sup> of my observation. <sup>(b)(6) (b)(7)(C)</sup> upon notification confirmed the observation to be fecal material. The establishment did not meet the following regulatory requirements of 9 CFR 381.65(e) which states, "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank," and 9 CFR 417.2(c) (4), which states, "List the procedures, and frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits."
0042-2011-14373	2230	00018 P	Cargill Meat Solutions Corp.	VA	31-Mar-11	1	04C04	381.86	At approximately 1218 hours, while performing a 03J01 procedures on OM/Salvage parts, I observed a yellow caseated material at the end of the humerus proximal end. The approximate sizes ranged from 1/8" to 5/16". I informed <sup>(b)(6) (b)(7)(C)</sup> <sup>(b)(6) (b)(7)(C)</sup> Evisceration Supervisor, and <sup>(b)(6) (b)(7)(C)</sup> IIC of my findings. The establishment did not meet regulatory requirement 9 CFR 381.86, which states, "Any organ or part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole affected part shall be condemned." The establishment did not follow their written SOP's, dated 03/05/2009, under Procedure for Salvaging Wholesome Edible Parts, section #2, which states, <sup>(b) (4)</sup> <sup>(b) (4)</sup>
0055-2011-14373	2230	00018 P	Cargill Meat Solutions Corp.	VA	21-Apr-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 0954 hours, while performing a scheduled FS and OCP Verification test, I observed fecal material on the left side of the thigh, near the knee joint of the tenth carcass of a random ten carcass test on line <sup>(b)(4)</sup> . The fecal material was approximately 3/8" in diameter, dark green, and had a pasty consistency. I notified <sup>(b)(6) (b)(7)(C)</sup> Evisceration Lead Person of my observation. <sup>(b)(6) (b)(7)(C)</sup> IIC confirmed my observation. The establishment immediately started their corrective actions as stated in their HACCP plan. The establishment did not meet regulatory requirement 9 CFR 381.65(e), which states, "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." and 9 CFR 417.(c)(4), which states, "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits."
0060-2011-14373	2230	00018 P	Cargill Meat Solutions Corp.	VA	3-May-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 0907 hours while performing a scheduled Food Safety Verification Test of CCP- <sup>(b)(4)</sup> on line <sup>(b)(4)</sup> (toms), I observed fecal material on bird two of my ten bird random sample. The fecal was located inside the left thigh area on the inside of the carcass, it was approximately 1/8 of an inch in diameter, olive green in color, and of a pasty consistency. It appeared that the left fat flap had been trimmed. I immediately notified <sup>(b)(6) (b)(7)(C)</sup> Evisceration Supervisor of my observation. Upon notification and observation, <sup>(b)(6) (b)(7)(C)</sup> acting IIC, confirmed my observation met the criteria for fecal material. The establishment did not meet the following regulatory requirements of 9 CFR 381.65(e) which states, "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." and 9 CFR 417.2(c)(4) states, "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits;"

0062-2011-14373	2230	00018 P	Cargill Meat Solutions Corp.	VA	11-May-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 1155 hours while performing a scheduled Food Safety Verification Test of CCP (b)(4) on line (b)(1) I observed fecal material on bird number eight of my ten bird random sample. The fecal was located inside of the carcass at the opening cut at the keel bone. It was measured with USDA Form 6000-15 and spanned approximately two inches in width across the keel bone and approximately one and a half inches in length from the tip of the keel bone down inside the carcass. A smear of approximately a half inch was observed also on the edge of the left fat flap. The fecal material was olive green in color and was of a pasty consistency. I immediately notified (b)(6) (b)(7)(C) Evisceration Supervisor of my observation. Upon notification and observation, (b)(6) (b)(7)(C) acting IIC, confirmed my observation met the criteria for fecal material. The establishment did not meet the following regulatory requirements of 9 CFR 381.65(e) which states, "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." and 9 CFR 417.2(c)(4) which states, "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits;"
0063-2011-14373	2230	00018 P	Cargill Meat Solutions Corp.	VA	13-May-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 09:28, while performing a scheduled Food Safety Verification test on production line (b)(4) observed fecal material on the eight bird out of my ten bird random sample. The fecal material was a 1/2 inch smear, olive green in color, of a pasty consistency and located on the right hock area. I immediately notified establishment designee (b)(6) (b)(7)(C) and Evis Manager, (b)(6) (b)(7)(C) Acting IIC, (b)(6) (b)(7)(C) confirmed my findings and the establishment started corrective action as outlined in their written HACCP plan. The establishment failed to meet the following regulatory requirements. CFR 381.65(e) which states, "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." and CFR 417.2(c)(4) which states, "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits;" (b)(6) (b)(7)(C) General Manager was notified in writing with this NR.

0068-2011-14373	2230	00018 P	Cargill Meat Solutions Corp.	VA	10-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 0953 hours while performing a scheduled Food Safety Verification Test of CCP- (b)(4) on line (b)(4) (toms), I observed fecal material on bird number seven of my ten bird random sample. The fecal was located on the back of the right hock. The fecal material measured approximately 3/16 of an inch in length, light green in color and of a mucoid consistency. I notified Evisceration Supervisor, (b)(6) (b)(7)(C) of my observation. Upon notification and observation, (b)(6) (b)(7)(C) IIC, confirmed my observation met the criteria for fecal material. The establishment did not meet the following regulatory requirements of 9 CFR 381.65(e) which states, "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank," and 9 CFR 417.2(c)(4) which states, "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits."
0074-2011-14373	2230	00018 P	Cargill Meat Solutions Corp.	VA	22-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 1251 hours while performing a scheduled Food Safety Verification Test of CCP- (b)(4) on line (b)(4) (hens), I observed fecal material on bird number nine of my ten bird random sample. The fecal was located inside the cavity of the bird at the inner right thigh area approximately a half inch from the hip joint. The fecal material measured approximately 3/16 of an inch in length, light green in color and of a mucoid consistency. I notified Evisceration Supervisor, (b)(6) (b)(7)(C) and Tucking Room Designee, (b)(6) (b)(7)(C) of my observation. Upon notification and observation, (b)(6) (b)(7)(C) IIC, confirmed my observation met the criteria for fecal material. The establishment did not meet the following regulatory requirements of 9 CFR 381.65(e) which states, "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank," and 9 CFR 417.2(c)(4) which states, "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits."

0086-2011-14373	2230	00018 P	Cargill Meat Solutions Corp.	VA	25-Jul-11	1	04C04	381.3(b)	At approximately 1317 hours, while performing a Verification sampling procedure for Cargill Meat Solutions, Inc., a (b)(4) line plant, the OCP-1 Maximum Limits from table 2 "Maximum Limits for Various Sampling Sizes" of the Young Turkey Inspections HIMP Draft 4, 02/22/04 were exceeded. I observed three airsacculitis carcasses on an OCP check in a ten bird random sample (in the number 4, 5 and 6 carcasses) on Line (b)(4). At 0847 hours on an OCP check there was one airsacculitis and at 1246 hours on an OCP check on Line (b)(4) there was one airsacculitis, for a total of five out of a 50 bird sample on Line (b)(4). I informed (b)(6) (b)(7)(C) visceration Supervisor of my observations. The establishment did not meet regulatory requirement 9 CFR 381.3(b), which states, "The Administrator may in specific classes of cases waive for limited periods any provisions of the regulations in order to permit appropriate and necessary action in the event of a public health emergency or to permit experimentation so that new procedures, equipment, and processing techniques may be tested to facilitate definite improvements; Provided, That such waivers of the provisions of the regulations are not in conflict with the purposes or provisions of the Act.
0101-2011-14373	2230	00018 P	Cargill Meat Solutions Corp.	VA	18-Aug-11	1	04C04	381.86	At approximately 1251 hours while performing procedure code 03J01on Osteomyelitis (OM) salvage parts I observed a yellowish white caseated exudate protruding from a small cut at the head of the femoral joint of an OM salvaged thigh. Per 9 CFR 500.1, I retained the bag of OM parts with US Retain Tag #B39697567. I immediately notified Evisceration Supervisor, (b)(6) (b)(7)(C) and IIC, (b)(6) (b)(7)(C) of my observation. (b)(6) (b)(7)(C) requested the femoral joint be incised to visibly inspect the inside marrow cavity. The inside was necrotic with a grayish yellow color. Upon her observation she determined the part was positive for OM. Regulatory control actions were relinquished at 1300 hours after the affected part was condemned and the remaining parts were reconditioned. The establishment did not meet the regulatory requirement of 9 CFR 381.86 which states, "Any organ or part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole affected part shall be condemned." In addition the establishment did not follow their written SOP's, revised on 10-28-2008 under Turkey Osteomyelitis Complex Handling Procedure states, (b)(4)

0044-2011-14894	3850	00165S P	OK Foods, Inc	AR	2-Mar-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 1307, while performing a scheduled FS/OCP test on evisceration line (b)(6) lot 15, I observed feces on the second carcass. I continued performing my test and at 1310 I observed feces on the fifth carcasses. Both feces finds were greenish-yellow in color, pasty, and approximately 1/8" x 1/8" in size. The plant and Q.C. were informed of the finds. (b)(6) (b)(7)(C) gave me a verbal cause for the feces finds - equipment. The plant took corrective action and Q.C. performed a retest which was acceptable. Reference NR # 37-2011-14894 dated 2-24-2011 which documents a similar noncompliance with the same cause - equipment. The referenced NR has not been answered at this time but it is safe to say that the further preventive actions for the referenced NR were not effective and/or not properly implemented as indicated by this finding.
0050-2011-14894	3850	00165S P	OK Foods, Inc	AR	8-Mar-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 03/08/2011 at 10:53 a.m. while performing a Food Safety/OCP test on evisceration line (b)(4) during production lot # 7, I observed feces on the third carcass of ten randomly selected carcasses. The feces was located on the outside tail area, was approximately 1/2" X 1/8", was dark green with a thick, pasty consistency. (b)(6) (b)(7)(C) Superintendent) was notified and agreed it to be feces. Verbal cause was given as employee. Quality Control performed a retest and no further feces was found. A similar noncompliance was documented on NR #0040-2011-14894 dated 02/25/2011. The Further Planned Action was as stated: Management counseled the back-up rehangar to ensure that birds are properly hung in the shackle so that the carcasses will feed into the equipment correctly. After a review of the HACCP Plan, no changes were necessary. It is reasonable to conclude by this finding that these actions were not effective or have not been properly implemented.

0053-2011-14894	3850	00165S P	OK Foods, Inc	AR	9-Mar-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 03/09/2011 at 2:24 p.m. while performing a scheduled OCP/Food Safety Test on evisceration line (b)(4) During production lot # 15, I observed feces on the fourth carcass of ten randomly selected carcasses. (b)(6) (b)(7)(C) (Supervisor) was notified and agreed it to be feces. The feces was located inside the rib-cage area, was dark green with a thick, pasty consistency, and measured approximately 1/4" in two spots. Quality Control performed a retest and no further feces was found. Verbal cause was given as employee error. A similar noncompliance was documented on NR#0050-2011-14894 dated 03/08/2011 which has not been answered. It is reasonable to assume that any Further Planned Action was not effective or not properly implemented as determined by this finding.
0061-2011-14894	3850	00165S P	OK Foods, Inc	AR	22-Mar-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 1338, while performing a scheduled Food Safety test on evisceration line (b)(4) lot, I observed feces on the tenth carcass. The feces was located inside the carcass in the tail area. The feces was yellowish-brown in color, pasty in consistency, and was approximately 1/4" x 1/4" in size. The plant and Q.C. were notified of the feces find. (b)(6) (b)(7)(C) gave me a verbal cause for the feces find - equipment. The plant took corrective action and Q.C. performed a retest which was acceptable. Reference NR #44-2011-14894 dated 3-2-2011 which documents a similar noncompliance with the same cause. The further planned action for the referenced NR : Maintenance personnel discovered that the nozzles in the I/O washer on line (b)(4) were out of adjustment and the nozzles were corrected. Maintenance personnel monitored the equipment later and verified that everything continued to function properly. After a review of the HACCP plan, no changes were necessary. It is reasonable that the further preventive actions for the referenced NR were not effective and/or not properly implemented as indicated by this finding.

0063-2011-14894	3850	00165S P	OK Foods, Inc	AR	24-Mar-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 10:14 a.m. I began to perform a scheduled Food Safety/OCP test on Line (b)(4). The ten Samples were randomly selected that was part of lot #14. I observed fecal contamination on carcass #5 at 10:16 a.m. The feces was located in two places, on the inside flap area, and on the neck. Both being approximately 1/8 inch in size olive green in color and pasty in consistency. (b)(6) (b)(7)(C) (Evis Supervisor) was notified of the find along with QC Tech (b)(6) (b)(7)(C) (QC Tech). (b)(6) (b)(7)(C) gave the verbal cause: Employee. This test is performed between the final wash and the C.I. station at the Verification station per Himp draft 8. The plant followed their procedure for feces and Q.C. performed a retest at CCP (b)(4) which was acceptable. A similar noncompliance was documented on NR# 0053-2011-14894 dated on 03/09/2011. The further planned action for this noncompliance states: Management counseled the employee working as the floor support on the importance of keeping viscera removed from the (b)(4) machine in a timely manner to avoid the cross contamination of carcasses. It is reasonable to assume any further planned action has been ineffective or has not been properly implemented. -
0065-2011-14894	3850	00165S P	OK Foods, Inc	AR	28-Mar-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 9:33 a.m. while performing a scheduled Food Safety test on line (b)(4) I observed feces on the fifth carcass of the ten carcass sample. The feces was located inside of the carcass in the tail area. It was approx. 1/4 inch in size, had a pasty consistency, and was dark green in color. (b)(6) (b)(7)(C) (evisceration supervisor ) was notified, and he gave the verbal cause to be equipment. The plant followed their procedure for feces and Q.C. performed a retest and no feces was found. This test is performed at the V.I. station as per HIMP Draft 8. N.R.# 061-2011-14894, dated 03/22/2011, documents a similar nonconformance with the same cause. Even though this N.R. has not been answered by the plant it is reasonable to conclude that any further planned actions were either not implemented or were not effective in preventing the current N.R.

0070-2011-14894	3850	00165S P	OK Foods, Inc	AR	30-Mar-11	1	03J01	417.5(a)(1)	At 9:35 AM, while taking a routine tour with the FLS of the evisceration department, we noticed a plant employee in the paw scalding room taking paws off both lines that were missed by the paw unloader and putting them in the paw scalding for line (b)(6). This practice has no written procedure in place that would prevent paws from condemned carcasses to be mixed with inspected and passed paws going to the consumer. (b)(6) (b)(7)(C) was notified of the deficiency. The company immediately began condemning any return paws and put on hold the day's paw production until management made a product disposition for the affected product. There was 5 whole pallets and three partial pallets that the company decided to relabel as uninspected paws as a solution for this deficiency. Paws are collected under a batch system and at (b)(4) birds per minute the paw dump cycle is approximately 6 minutes. According to the company's records, the last paw dump for a condemnable carcass was at 9:02 AM.
0073-2011-14894	3850	00165S P	OK Foods, Inc	AR	4-Apr-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 04/04/2011 at 12:58 p.m. while performing a scheduled Food Safety/OCP on evisceration line (b)(4) during production lot # 2, I observed feces on the sixth carcass of ten randomly selected carcasses. (b)(6) (b)(7)(C) (Supervisor) was notified. The feces was located inside the breast area, was dark green, with a thick, pasty consistency and measured approximately 1/2". Quality Control performed a retest and no further feces was found. Verbal cause was given as employee error. A similar noncompliance with cause employee was documented on NR # 0063-2011-14894 dated 03/24/2011. The Further Planned Action: Management counseled the back-up ventor to use proper venting techniques when opening birds and to handle them in a manner so as to ensure that other product is not contaminated in the process. After a review of the HACCP Plan, no changes were necessary. These actions have not been effective or have not been properly implemented as determined by this finding.



0078-2011-14894	3850	00165S P	OK Foods, Inc	AR	7-Apr-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 11:23 a.m. while performing a scheduled OCP/Food Safety test on line (b)(4) observed feces on the fifth carcass of the ten carcass sample. The feces was located inside of the carcass in the kidney area. It was dark green in color, had a pasty consistency, and was approx. 1 inch in size. (b)(6) (b)(7)(C) (evisceration supervisor ) was notified and he gave the verbal cause to be equipment. The plant followed their procedure for feces and Q.C. performed a retest and no feces was found. This test is performed at the V.I. station as per HIMP Draft 8. N.R. #065-2011-14894, dated, 03/28/2011 documents a similar nonconformance with the same cause. Even though this N.R. has not been answered by the plant it is reasonable to conclude that any further planned actions were either not implemented or were not effective in preventing the current N.R.
0079-2011-14894	3850	00165S P	OK Foods, Inc	AR	12-Apr-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At0445, while performing a scheduled Food Safety test on evisceration line (b)(6) lot 7, I observed that inside the first carcass the pelvic area had urates throughout the area. (b)(6) (b)(7)(C) was notified of the find and he concurred. (b)(6) (b)(7)(C) and Q.C. were notified of the feces find. The urates were covering an area that included the vent area, the flap, and throughout the pelvic area. The plant took corrective action and Q.C. performed a retest which was acceptable. (b)(6) (b)(7)(C) gave me a verbal cause for the feces find - employee. Reference NR #0073-2011-14894 dated 04/04/2011 which documents a similar noncompliance with the same cause - employee. The referenced NR has not been answered at this time but it is safe to say that the further preventive actions for the referenced NR were not effective and/or not properly implemented as indicated by this finding.

0080-2011-14894	3850	00165S P	OK Foods, Inc	AR	14-Apr-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 5:02 a.m. while performing a Food Safety test on line (b)(4) I observed feces on the second carcass of the ten carcass sample. The feces was located inside of the carcass in the kidney area. It was of a yellowish-green color, had a pasty consistancy and was approx. 1/2 inch in size. (b)(6) (b)(7)(C) (visceration supervisor ) was notified and he gave the cause to be equipment. The plant followed their procedure for feces and Q.C. performed a retest and no feces was found. This test is performed at the V.I. station as per HIMP Draft 8. N.R. # 078-2011-14894, dated 04/07/2011 documents a similar nonconformance with the same cause. Even though this N.R. has not been answered by the plant, it is reasonable to conclude that any further planned actions were either not implemented or were not effective in preventing the current N.R.
0086-2011-14894	3850	00165S P	OK Foods, Inc	AR	22-Apr-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 04/22/2011 at 12:43 p.m. while performing a Food Safety/OCP Test on evisceration line (b)(4) during production lot # 33, I observed feces on the eighth carcass of ten randomly selected carcasses. The feces was located inside the rib-cage area and was approximately 1/4" in size and was dark green with a thick, pasty consistency. (b)(6) (b)(7)(C) (Supervisor) was notified. Quality Control performed a retest and no further feces was found. This is a noncompliance for 00165S as per HIMP Draft Eight. A similar noncompliance was documented on NR #0080-2011-14894 dated 04/14/2011 for the same cause given (Equipment) which has not been answered. It is reasonable to assume that any preventive measures have not been effective or have not been properly implemented as determined by this finding.

0088-2011-14894	3850	00165S P	OK Foods, Inc	AR	28-Apr-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 1031, while performing a scheduled Food Safety test on evisceration line (b) (4) lot 16, I observed feces on the fourth carcass. The feces was located inside the carcass in the kidney area. The feces was pasty, yellowish-brown in color, and covered an area approximately 1/4" x 1/4" in size. (b) (6) (b) (7) (C) and Q.C. were notified of the feces find. The plant took corrective action and Q.C. performed a retest which was acceptable. (b) (6) (b) (7) (C) gave me a verbal cause for the feces find - employee. Reference NR # 79-2011-14894 dated 04-12-2011 which documents a similar noncompliance with the same cause - employee. The referenced NR has not been answered at this time but it is safe to say that the further preventive actions for the referenced NR were not effective and/or not properly implemented as indicated by this finding.
0089-2011-14894	3850	00165S P	OK Foods, Inc	AR	28-Apr-11	1	03J01	417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 1402, while performing a scheduled FS/OCP test on evisceration line (b) (4) lot 16, I observed feces on the third carcass. The feces was located inside the carcass in the kidney area. The feces was pasty, yellowish-brown in color, and covering an area approximately 1/8" x 1/8" in size. The plant and Q.C. were notified of the feces find. (b) (6) (b) (7) (C) gave me a verbal cause for the feces - equipment. The plant took corrective action and Q.C. performed a retest which was acceptable. Reference NR #86-2011-14894 dated 04-22-2011 which documents a similar noncompliance with the same cause - equipment. The referenced NR has not been answered at this time but it is safe to say that the further preventive action(s) for the referenced NR were not effective and/or not properly implemented as indicated by this finding.

0090-2011-14894	3850	00165S P	OK Foods, Inc	AR	2-May-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 8:08 a.m. while performing a scheduled OCP/Food Safety test on line (b) (4) I observed feces on the second carcass of the ten carcass sample. (b)(6) (b)(7)(C) evisceration superintendent ) was notified of the nonconformance and he gave the verbal cause to be employee. This test is performed at the V.I. station as per HIMP Draft 8. The plant followed their procedure for feces and Q.C. preformed a retest and no feces was found. The feces was located inside of the carcass in the keel bone area. It was dark green in color, had a pasty consistency. The feces was smeared over a two inch area, approx. N.R. # 088-2011-14894, dated04/28/2011, documents a similar nonconformance with the same cause. Even though this N.R. has not been answered by the plant it is reasonable to conclude that any further planned actions were either not implemented or were not effective in preventing the current N.R.
0093-2011-14894	3850	00165S P	OK Foods, Inc	AR	3-May-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 9:43 AM, I performed a scheduled Food Safety verification test on ten poultry carcasses randomly selected from Evisceration Line (b) (4) after the final wash and prior to the Carcass Inspection station and the chiller. This is the location in the process, per HIMP draft 8, that FSIS personnel examine carcasses to verify compliance with regulatory requirements and relevant performance standards. I observed a smear of feces, dark green in color, measuring approximately 2" x 1" between the tail and the kidneys inside the third carcass of the sample set. (b)(6) (b)(7)(C) Evisceration Department Supervisor, was notified of the noncompliance with performance standards. Corrective action in accordance with the Establishment's HACCP plan began. This included a retest at the CCP (b) (4) location to verify that no carcasses with visible fecal contamination were allowed to enter the chill system. The retest was acceptable. Documented on the Quality Control HACCP Deviation form was a statement that the deviation was due to a spray nozzle out of adjustment on the neck breaker (equipment). Noncompliance Record 0089-2011-14894 dated 04/28/2011 should be referenced since it documents feces on product at this location, and has the same cause. Noncompliance Record 0089-2011-14894 has not been responded to by plant management in writing at this time. It is reasonable to conclude that any proposed corrective actions were ineffective or have not been implemented.

0095-2011-14894	3850	00165S P	OK Foods, Inc	AR	5-May-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 6:31 AM, I performed a scheduled Food Safety verification test on ten poultry carcasses randomly selected from Evisceration Line (b)(4) after the final wash and prior to the Carcass Inspection station and the chiller. This is the location in the process, per HIMP draft 8, that FSIS personnel examine carcasses to verify compliance with regulatory requirements and relevant performance standards. I observed a smear of feces, dark green in color, measuring approximately 1" in diameter on the tip of the keel inside the ninth carcass of the sample set. (b)(6) (b)(7)(C) Evisceration Department Supervisor, was notified of the noncompliance with performance standards. Corrective action in accordance with the Establishment's HACCP plan began. This included a retest at the CCP (b)(4) location to verify that no carcasses with visible fecal contamination were allowed to enter the chill system. The retest was acceptable. Documented on the Quality Control HACCP Deviation form was a statement that "The failure was due to birds misfeeding into vent machine. (equipment)" Noncompliance Record 0093-2011-14894 dated 05/03/2011 should be referenced since it documents feces on product at this location, and has the same cause. Noncompliance Record 0093-2011-14894 has not been responded to by plant management in writing at this time. It is reasonable to conclude that any proposed corrective actions were ineffective or have not been implemented.
0097-2011-14894	3850	00165S P	OK Foods, Inc	AR	11-May-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 05/11/2011 at 9:21 a.m. while performing a scheduled Food Safety on evisceration line (b)(4) during production lot # 5, I observed feces on the fifth carcass of ten randomly selected carcasses. The feces was dark green with a thick, pasty consistency, measuring approximately 2 inches, located inside the keel area. (b)(6) (b)(7)(C) (Supervisor) was notified. Quality Control performed a retest and no further feces was found. (b)(6) (b)(7)(C) gave verbal cause as employee error. A similar noncompliance was documented on NR #0090-2011-14894 which has not been answered. It is reasonable to assume that any Further Planned Action has not been effective or has not been properly implemented as determined by this finding.

0098-2011-14894	3850	00165S P	OK Foods, Inc	AR	11-May-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 05/11/2011 at 2:04 p.m. while performing a scheduled Food Safety on evisceration line (b)(4) during production lot # 17, I observed feces on the fourth carcass of ten randomly selected carcasses. The feces was located inside the tail area, was dark green with a thick, pasty consistency and measured approximately 1/4". (b)(6) (b)(7)(C) Supervisor) was notified. Quality Control performed a retest and no further feces was found. (b)(6) (b)(7)(C) gave verbal cause to be equipment. A similar noncompliance was documented on NR # 0095-2011-14894 dated 05/05/2011 which has not been answered. It is reasonable to assume by this finding that any Further Planned Action was not effective or not properly implemented.
0103-2011-14894	3850	00165S P	OK Foods, Inc	AR	17-May-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 7:07 a.m. I began to perform a scheduled Food Safety test on Line (b)(4). The ten samples were randomly selected that was part of lot #6. This test is after the final wash and prior to the Carcass Inspection station and the chiller. This is the location in the process, per HIMP draft8, that FSIS personnel examine carcasses to verify compliance with regulatory requirements. I observed fecal contamination on carcass #9 at 7:11 a.m. The feces was located on the inside kidney area, olive green in color, pasty in consistency, and being approximately 1/4 inch in size. (b)(6) (b)(7)(C) (Supervisor) was notified of the find along with QC Tech (b)(6) (b)(7)(C) (b)(6) (b)(7)(C). (b)(6) (b)(7)(C) gave the verbal cause: Employee. Corrective action in accordance with the HACCP plan began. The plant followed their procedure for feces and Q.C. performed a retest at CCP (b)(4) which was acceptable. A similar noncompliance was documented on NR#0097-2011-14894 dated on 05/11/2011. This NR has not been answered at the current time. It is reasonable to conclude that any proposed corrective actions were either not implemented or were not effective in preventing the current NR.

0104-2011-14894	3850	00165S P	OK Foods, Inc	AR	18-May-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 1:11p.m. I began to perform a scheduled Food Safety test on Line (b)(4). The ten samples were randomly selected that was part of lot #16. This test is after the final wash and prior to the Carcass Inspection station and the chiller. This is the location in the process, per HIMP draft 8, that FSIS personnel examine carcasses to verify compliance with regulatory requirements. I observed fecal contamination on carcass #6 at 1:15p.m. The feces was located on the outside breast area, next to the base of the wing. The feces was olive green in color, pasty in consistency, and being approximately 1/4 inch in size. (b)(6) (b)(7)(C) (b)(6) (b)(7)(C) (Supervisor) was notified of the find along with QC Tech (b)(6) (b)(7)(C) (b)(6) (b)(7)(C) gave the verbal cause: Equipment . Corrective action in accordance with the HACCP plan began. The plant followed their procedure for feces and Q.C. performed a retest at CCP- (b)(4) which was acceptable. A similar noncompliance was documented on NR#0098-2011-14894 dated on 05/11/2011. This NR has not been answered at the current time. It is reasonable to conclude that any proposed corrective actions were either not implemented or were not effective in preventing the current NR.
0106-2011-14894	3850	00165S P	OK Foods, Inc	AR	23-May-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 05/23/2011 at 9:56 a.m. while performing a scheduled Food Safety Test on evisceration line (b)(4) during production lot # 1, I observed feces on the fourth carcass of ten randomly selected carcasses. The feces was dark green, with a thick, pasty consistency, measuring approximately 1/4", and was located inside the tail area. (b)(6) (b)(7)(C) (Superintendent) was notified. Quality Control performed a retest and no further feces was found. (b)(6) (b)(7)(C) (Supervisor) gave verbal cause to be employee error. A similar noncompliance was documented on NR # 0103-2011-14894 dated 05/17/2011, which has not been answered. It is reasonable to assume by this finding that any Further Planned Actions have not been effective or have not been properly implemented.

0109-2011-14894	3850	00165S P	OK Foods, Inc	AR	1-Jun-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 11:31 a.m. while performing a scheduled Food Safety Test on line (b)(4) I observed feces on the second carcass of the ten carcass sample. The feces was located inside of the carcass on the tip of the keel bone. It was dark green in color, had a pasty consistency and was approximately 1/2 inch in size. (b)(6) (b)(7)(C) (evisceration supervisor ) was notified and he gave the verbal cause to be employee. The plant followed their procedure for feces, and Q.C. performed a retest and no feces was found. This test is performed at the Verification station as per HIMP Draft 8. N.R. # 106, dated 05/23/2011 documents a similar deficiency with the same cause. Even though this N.R. has not been answered by the plant, it is reasonable to conclude that any further planned actions were either not implemented or were not effective in preventing the current N.R.
0112-2011-14894	3850	00165S P	OK Foods, Inc	AR	6-Jun-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 06/06/2011 at 5:04 a.m., while performing a scheduled Food Safety/OCP Test on evisceration line (b)(4) during production lot # 1, I observed feces on the third carcass of ten randomly selected carcasses. The feces was dark green, with a thick pasty consistency, measuring approximately 1/8" and was located inside the neck area. (b)(6) (b)(7)(C) (Supervisor) was notified. Quality Control performed a retest and no further feces was found. (b)(6) (b)(7)(C) gave verbal cause to be equipment. A similar noncompliance was documented on NR # 0104-2011-14894 dated 05/18/2011 which has not been answered. It is reasonable to assume by this finding that any Further Planned Action have not been effective or has not been properly implemented.



0116-2011-14894	3850	00165S P	OK Foods, Inc	AR	13-Jun-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 06/13/2011 at 9:53 a.m. while performing a scheduled Food Safety/OCP Test on evisceration line (b)(4) during production lot # 1, I observed feces on the fifth carcass of ten randomly selected carcasses. The feces was dark green in color, with a thick, pasty consistency, located inside the tail area. The feces was located in several spots with sizes ranging from 1/8" to 1/4". (b)(6) (b)(7)(C) (Supervisor) was notified. Quality Control performed a retest and no further feces was found. (b)(6) (b)(7)(C) gave verbal cause to be equipment. A similar noncompliance with the cause equipment was documented on NR # 0112-2011-14894 dated 06/06/2011 which has not been answered. It is reasonable to assume by this finding that any Further Planned Action has not been effective or has not been properly implemented.
0121-2011-14894	3850	00165S P	OK Foods, Inc	AR	22-Jun-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 0941, while performing a scheduled FS/OCP on ten randomly selected carcasses from evisceration line (b)(6) lot 12, I observed feces on the tenth carcass. The feces was located inside the carcass on the right flap. The feces was pasty in consistency, brownish-green in color, and approximately 1/8" x 1/8" in size. The plant and Q.C. were notified of the feces find. (b)(6) (b)(7)(C) gave me a verbal cause for the fecal find - equipment. The plant took corrective action and Q.C. performed a retest which was acceptable.

0123-2011-14894	3850	00165S P	OK Foods, Inc	AR	23-Jun-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 06/23/2011 at 1:08 p.m. while performing a scheduled Food Safety Test on evisceration line (b)(4) during production lot #17, I observed feces on the seventh carcass of ten randomly selected carcasses. The feces was dark green, with a thick, pasty consistency, was located inside the flap area and measured approximately 1/8" to 1/4". Quality Control performed a retest and no further feces was found. (b)(6) (b)(7)(C) Superintendent) was notified and gave verbal cause to be employee error. A similar noncompliance with the same cause was documented on NR# 0109-2011-14894 dated 06/01/2011. The Further Planned Action: The failure was the result of a sorter not properly inspecting a carcass after manually removing the viscera pack. The employee was counseled on his/her job performance and re-instructed to ensure that all contaminated carcasses are inspected properly before being placed back online and allowed to continue in the process. It is reasonable to assume by this finding that these actions were not effective or not properly implemented.
0127-2011-14894	3850	00165S P	OK Foods, Inc	AR	29-Jun-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 06/29/2011 at 10:06 a.m. while performing a scheduled Food Safety Test on evisceration line (b)(4) during production lot # 11, I observed feces on the tenth carcass of ten randomly selected carcasses. The feces was dark green, with a thick pasty consistency, measured approximately 1/2" and was located inside the keel area. (b)(6) (b)(7)(C) Supervisor) was notified. Quality Control performed a retest and no further feces was found. (b)(6) (b)(7)(C) gave verbal cause to be employee error. A similar noncompliance was documented on NR # 0123-2011-14894 dated 06/23/2011 which has not been answered. It is reasonable to assume that any Further Planned Action has not been effective or has not been properly implemented as determined by this finding.

0128-2011-14894	3850	00165S P	OK Foods, Inc	AR	30-Jun-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 06/30/2011 at 7:56 a.m. while performing a scheduled Food Safety Test on evisceration line (b)(4) during production lot # 15, I observed feces on the third carcass of ten randomly selected carcasses. The feces was dark green in color, with a thick, pasty consistency and was located inside the keel area. The feces measured approximately 1/2". (b)(6) (b)(7)(C) (Superintendent) was notified. Quality Control performed a retest and no further feces was found. (b)(6) (b)(7)(C) gave verbal cause to be equipment. A similar noncompliance was documented on NR # 0121-2011-14894 dated 06/22/2011 which has not been answered. It is reasonable to assume that any Further Planned Action has not been effective or have not been properly implemented as determined by this finding.
0131-2011-14894	3850	00165S P	OK Foods, Inc	AR	5-Jul-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 2:42 p.m. I began to perform a scheduled Food Safety test on Line (b)(4). The ten Samples were randomly selected that was part of lot #3. I observed fecal contamination on carcass #7 at 2:46 p.m.. The feces was located inside on the keel bone area, approximately 1inch smear in size olive green in color and pasty in consistency. (b)(6) (b)(7)(C) (Evis Supervisor) was notified of the find along with QC Tech (b)(6) (b)(7)(C). (b)(6) (b)(7)(C) gave the verbal cause: equipment. This test is performed between the final wash and the C.I. station at the Verification station per Himp draft 8. The plant followed their procedure for feces and Q.C. performed a retest at CCP (b)(4) which was acceptable. A similar noncompliance was documented on NR# 00128-2011-14894 dated on 06/30/2011. There is no written response at the time of this current noncompliance -

0132-2011-14894	3850	00165S P	OK Foods, Inc	AR	7-Jul-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 6:07 while performing a scheduled Food Safety test on line (b)(4) I observed feces on the third carcass of the ten carcass sample. The feces was located inside of the bird in the keel area. There were two areas of feces , each were approximately 1 1/2 inch long and 1/4 inch wide. The feces was yellowish green in color and had a pasty consistency. (b)(6) (b)(7)(C) son was notified and he gave to verbal cause to be employee. The plant followed their procedure for feces and Q.C. performed a retest and no feces was found. This test is performed at the V. I. station as per HIMP Draft 8. N.R. #127-2011-14894, dated 06/29/2011 documents a similar deviation with the same cause. Even though this N.R. has not been answered by the plant it is reasonable to conclude that any further planned actions were either not implemented or were not effective in preventing g the current N.R.
0133-2011-14894	3850	00165S P	OK Foods, Inc	AR	7-Jul-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 07/07/2011 at 9:37 a.m., while performing a scheduled Food Safety Test on evisceration line (b)(4) during production lot # 14, I observed feces on the fifth carcass of ten randomly selected carcasses. (b)(6) (b)(7)(C) (Supervisor) was notified. The feces was dark green in color, with a thick, pasty consistency, and was located inside the ribcage area, measuring approximately 1/2". Quality Control performed a retest and no further feces was found. (b)(6) (b)(7)(C) gave verbal cause to be equipment malfunction. A similar noncompliance was documented on NR # 0131-2011-14894 dated 07/05/2011 which has not been answered. It is reasonable to assume by this finding that any Further Planned Actions have not been effective or have not been properly implemented.

0136-2011-14894	3850	00165S P	OK Foods, Inc	AR	11-Jul-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 1:35 p.m. while performing a scheduled OCP/Food safety test on line (b)(4) I observed feces on the seventh bird of the ten bird sample. The feces was located in the kidney area, It had a dark green color and was approximately 3/4 inch in size. (b)(6) (b)(7)(C) (b)(6) (b)(7)(C) evisceration supervisor ) was notified and he gave the verbal cause to be employee. The plant followed their procedure for feces and Q.C. performed a retest and no feces was found. This test is performed at the V.I. station as per HIMP Draft 8. N.R. # 132-2011-14894, dated 07/07/2011 documents a similar deviation with the same cause. Even though this N.R. has not been answered by the plant it is reasonable to conclude that any further planned actions were either not implemented or were not effective in preventing the current N.R.
0141-2011-14894	3850	00165S P	OK Foods, Inc	AR	26-Jul-11	1	03J01	309.4, 381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 0804, while performing a Food Safety test on ten randomly selected carcasses from evisceration line (b)(4) lot 8, I observed feces on the fifth carcass. The plant and Q.C. were notified of the feces find. The feces was located inside the carcass in the keel area. The feces was yellowish-brown in color, thick and pasty in consistency, and was smeared across an area approximately 2-inch square. (b)(6) (b)(7)(C) gave me a verbal cause for the feces - employee. The plant took immediate action and Q.C. performed a retest which was acceptable. Reference NR# 136-2011-14894 dated 7-11-11 which documents a similar noncompliance with the same cause(employee). The referenced NR has not been answered at this time but it is safe to say that the further preventive action(s) for the referenced NR were not effective and/or not properly implemented as indicated by this finding.

0145-2011-14894	3850	00165S P	OK Foods, Inc	AR	10-Aug-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 7:38a.m. I began to perform a scheduled Food Safety test on Line (b)(4). The ten samples were randomly selected that was part of lot #12. This test is after the final wash and prior to the Carcass Inspection station and the chiller. This is the location in the process, per HIMP draft 8, that FSIS personnel examine carcasses to verify compliance with regulatory requirements. I observed fecal contamination on carcass #6 at 7:43a.m.. The feces was located on the inside kidney area. The feces was olive green in color, pasty in consistency, and being approximately 1/2 inch in size. (b)(6) (b)(7)(C) (Supervisor) was notified of the find along with QC Tech (b)(6) (b)(7)(C) (b)(6) (b)(7)(C) gave the verbal cause: Employee. Corrective action in accordance with the HACCP plan began. The plant followed their procedure for feces and Q.C. performed a retest at CCP-B1A which was acceptable. A similar noncompliance was documented on NR#0141-2011-14894 dated on 07/26/2011. The further planned action on this noncompliance states: An employee working in the position of the back-up rehangar on line (b)(4) failed to properly hang a carcass back in the shackle properly, allowing it to become lodged in equipment. The employee has been counseled regarding the importance of ensuring that all carcasses are hung by both legs before being allowed to continue in the process. The employee's job performance was later evaluated to ensure that the job was being performed as instructed.
0147-2011-14894	3850	00165S P	OK Foods, Inc	AR	17-Aug-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 1111, while performing a scheduled FS/OCP on ten randomly selected carcasses from evisceration line (b)(4) lot 12, I observed feces on the seventh carcass. The plant and Q.C. were notified of the feces find. The feces was located inside the carcass in the left flap area. The feces was yellowish-brown in color, pasty in consistency, and was smeared across an area approximately 1" square in size. (b)(6) (b)(7)(C) gave me a verbal cause for the feces - equipment. The plant took immediate action and Q.C. performed a retest which was acceptable.

0148-2011-14894	3850	00165S P	OK Foods, Inc	AR	18-Aug-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	On 08/18/2011 at 10:26 a.m. while performing a scheduled Food Safety on evisceration line (b)(4) during production lot # 18. I observed feces on the fourth carcass of ten randomly selected carcasses. The feces was dark green in color, with a thick pasty consistency and was located inside the rib-cage area. It measured approximately 1". (b)(6) (b)(7)(C) (Supervisor) was notified. Quality Control performed a retest and no further feces was found. (b)(6) (b)(7)(C) gave verbal cause to be employee error. A similar noncompliance was documented on NR # 145-2011-14894 dated 08/10/2011 which has not been answered at this time. It is reasonable to assume that any Further Planned Actions have not been effective or have not been properly implemented as determined by this finding.
0149-2011-14894	3850	00165S P	OK Foods, Inc	AR	22-Aug-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 8:03a.m. I began to perform a scheduled Food Safety test on Line (b)(4). The ten samples were randomly selected that was part of lot #1. This test is after the final wash and prior to the Carcass Inspection station and the chiller. This is the location in the process, per HIMP draft 8, that FSIS personnel examine carcasses to verify compliance with regulatory requirements. I observed fecal contamination on carcass #5 at 8:06a.m.. The feces was located on the inside flap area. The feces was olive green in color, pasty in consistency, and being approximately 1/4 inch smear in size. (b)(6) (b)(7)(C) (Supervisor) was notified of the find along with QC Tech (b)(6) (b)(7)(C) (b)(6) (b)(7)(C) gave the verbal cause: Employee. Corrective action in accordance with the HACCP plan began. The plant followed their procedure for feces and Q.C. performed a retest at CCP- (b)(4) which was acceptable. A similar noncompliance was documented on NR#0148-2011-14894 dated on 08/18/2011. This noncompliance has not been answered at the present time of this writing.

0150-2011-14894	3850	00165S P	OK Foods, Inc	AR	24-Aug-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 1010, while performing a scheduled FS/OCP on ten randomly selected carcasses from evisceration line (b)(6) lot 16, I observed feces on the eighth carcass. The feces was located on the hock of the carcass. The feces was pasty in consistency, brownish-green in color, and approximately 1/4" x 1/4" in size. (b)(6) (b)(7)(C) and Q.C. were notified of the feces find. (b)(6) (b)(7)(C) gave me a verbal cause for the feces find - employee. The plant took immediate action and Q.C. performed a retest which was acceptable. Reference NR #149-2011-14894 dated 8-22-11 that documents a similar feces find with the same cause(employee). The referenced NR has not been answered at this time but it is reasonable to assume that any further planned actions have not been effective and/ or not been properly implemented as determined by this finding.
0151-2011-14894	3850	00165S P	OK Foods, Inc	AR	25-Aug-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 0605, while performing a scheduled FS/OCP test on ten randomly selected carcasses from evisceration line (b)(6) lot 21, I observed feces on the seventh carcass. The feces was located in the neck cavity. The feces was thick and pasty, greenish-brown in color, and approximately 1/8" x 1/8" in size. (b)(6) (b)(7)(C) and Q. C. were notified of the feces find. (b)(6) (b)(7)(C) gave me a verbal cause for the feces find - employee. The plant took immediate action and Q. C. performed a retest which was acceptable. Reference NR #150-2011-14894 dated 8-24-11 that documents a similar feces find with the same cause (employee). The referenced NR has not been answered at this time but it is reasonable to assume that any further planned actions have not been effective and/or not been properly implemented as determined by this finding..



0152-2011-14894	3850	00165S P	OK Foods, Inc	AR	25-Aug-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 0733, while performing a scheduled FS/OCP test on ten randomly selected carcasses from evisceration line (b)(6) lot 21, I observed feces on the sixth carcass. The plant and Q.C. were notified of the feces find. The feces was located inside the carcass on the left flap. The feces was greenish-brown in color, thick and pasty in consistency, and was 1/8" x 1/8" in size. (b)(6) (b)(7)(C) gave me a verbal cause for the feces - equipment. The plant took immediate action and Q.C. performed a retest which was acceptable. Reference NR #147-2011-14894 dated 8-17-2011 that documents a similar feces find with the same cause (equipment). The referenced NR has not been answered at this time but it is reasonable to assume that any further planned action(s) have not been effective and/or not been properly implemented as determined by this finding.
0153-2011-14894	3850	00165S P	OK Foods, Inc	AR	29-Aug-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 1035, while performing a scheduled Food Safety test on ten carcasses randomly selected from evisceration line (b)(6) lot 2, I observed feces in the second carcass. The feces was located inside the carcass in the keel area. The feces was yellowish-brown in color, pasty in consistency, and smeared over a 1" square. The plant and Q.C. were notified of the feces find. (b)(6) (b)(7)(C) gave me a verbal cause for the feces - equipment. The plant took corrective action and Q. C. performed a retest which was acceptable. Reference NR #152-2011-14894 dated 8-25-2011 with a similar feces find cause (equipment). The referenced NR has not been answered at this time but it is reasonable to assume that any further planned action(s) have not been effective and/or not been properly implemented as determined by this finding.

0154-2011-14894	3850	00165S P	OK Foods, Inc	AR	30-Aug-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	At 0506, while performing a scheduled Food Safety test on ten carcasses randomly selected from evisceration line (b)(6) lot 6, I observed feces on the seventh carcass. The feces was located inside the carcass in the left flap area. The feces was greenish-brown in color, pasty in consistency, and 1" globular in size and shape. The plant and Q.C. were notified of the feces find. (b)(6) (b)(7)(C) gave me a verbal cause for the feces - . The plant took corrective action and Q.C. performed a retest which was acceptable. Reference NR #151-2011-14894 dated 8-25-11 with a similar feces find cause (employee). The referenced NR has not been answered at this time but it is reasonable to assume that any further planned action(s) have not been effective and/or not been properly implemented as determined by this finding.
0021-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	11-Mar-11	1	03J01	417.2(c)(4)	While performing parts inspection at approximately 1331 hours, I observed a greenish brown pasty substance approximately 1/8 inch in diameter on one breast. Using color, consistency and composition, the substance was determined to be feces. (b)(6) (b)(7)(C) (line leader) and (b)(6) (b)(7)(C) (Evisceration Supervisor) were notified of the noncompliance and the establishment's failure to comply with zero tolerance standards. Corrective actions were performed as stated in the current HACCP Plan. No tag was applied the establishment elected to condemn one tub of breast and washed and sanitized the conveyor belt in my presence. (b)(6) (b)(7)(C) stated "that the employee responsible would be wrote up."The CCP was brought back under control at approximately 1336 hours.

0024-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	21-Mar-11	1	03J01	417.2(c)(4)	<p>While performing parts inspection at approximately 1334 hours, I observed a greenish brown pasty substance approximately 1/2 inch in diameter on one breast front half. Using color, consistency, and composition, the substance was determined to be feces. (b)(6) (b)(7)(C) (Line Leader) was notified of the noncompliance, and the establishment failure to comply with zero tolerance standards. Corrective actions were performed as stated in the current HACCP Plan. Tag # B34295138 was applied to one tub of affected product. The records for 03/21/2011 states Measures to prevent recurrence were: (b)(4) (b)(4)</p> <p>The CCP was brought back under control at approximately 1342 hours. A similar noncompliance was documented on NR# 0021 dated 03/11/2011. Measures to prevent reoccurrence: " Employee was sent to personnel and written up for poor work performance and explained the importance of ensuring product is properly trimmed, washed and inspected prior to placing into holding container". The preventive measure were not implemented or ineffective in preventing this type of noncompliance. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.</p>
0033-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	6-May-11	1	03J01	417.2(c)(4)	<p>While performing a Food Safety verification test on line (b)(6) at approximately 0533 hrs, I observed a gut still attach to the carcass and a greenish pasty substance approximately 1/8 inch diameter located on the leg area of one carcass from a randomly selected sample of ten. Using color, consistency, and composition, the substance was determined to be feces by IIC. (b)(6) (b)(7)(C) Line Leader in Evisceration, was notified of the establishment's failure to comply with Zero tolerance standards. The establishment initiated their corrective actions as stated in their current HACCP Plan. (b)(6) (b)(7)(C) Evisceration Supervisor stated " the cause to be the timing of the kick out." A similar noncompliance was documented on NR#0031-2011-14848 dated 04/28/2011. Measures to prevent reoccurrence: " was determined that the most probable cause was a busted hose on the bird washer. The line was stopped and the hose replaced with a new one." The preventive measure were not implemented or ineffective in preventing this type of noncompliance. This serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action</p>

0037-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	16-May-11	1	03J01	417.2(c)(4)	While performing a Food Safety verification test on line (b)(4) at approximately 0616 hours, I observed a greenish/brown pasty substance approximately 1/4 inch diameter located inside kidney area of one carcass from a randomly selected sample of ten. Using color, consistency, and composition, the substance was determined to be feces by the IIC. (b)(6) (b)(7)(C) (Evisceration Line Leader) was notified of the establishment failure to comply with Zero Tolerance Standards. The establishment initiated their corrective actions as stated in the current HACCP Plan. (b)(6) (b)(7)(C) Evisceration Supervisor) stated " the cause to be the cut-out machine was cutting some gut and going in to deep. A similar noncompliance was documented on NR# 0033-2011-14848 dated 05/06/2011. This NR #0033 hasn't been answer to date but (b)(6) (b)(7)(C) stated "the cause was to be timing of the kick out." The preventive measures were not implemented or ineffective in preventing this type of noncompliance. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
0046-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	13-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	I was performing a Food Safety/OCP verification test on line (b)(4) at approximately 09:45 hrs. I observed a greenish brown pasty substance approximately 1/8 inch in diameter in the kidney area of one carcass from a randomly selected sample of ten. Using color, consistency, and composition the substance was determined to be feces by the IIC. (b)(6) (b)(7)(C) (line leader) was notified of the establishment's failure to comply with Zero tolerance standards. The establishment initiated their corrective actions as stated in their current HACCP Plan. (b)(6) (b)(7)(C) Evisceration Manager, stated the cause was " the pump on the bird washer went out." The pump was replaced to restore water pressure. As a prevent measure the pumps will be replaced as they go bad. A similar noncompliance was documented on NR#0042-2011-14858 dated 06/01/2011. Measures to prevent reoccurrence:"(b)(4) The preventive measure was not implemented or ineffective in preventing this type of noncompliance. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.

0047-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	13-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	While performing a Food Safety/OCP verification test on line (b)(4) at approximately 1306hrs, I observed a dark greenish pasty substance 1/8 inch in diameter located inside the flap of one carcass of a randomly selected sample of ten. Using color, consistency, and composition the substance was determined to be feces. Evisceration Superintendent, (b)(6) (b)(7)(C) was notified of the establishment's failure to comply with the zero tolerance standards. The establishment initiated their corrective action procedure as per stated in their HACCP Plan to reinstate control. The Establishment's Corrective Action Form dated 06/13/2011 states, after investigation the cause of the deviation "equipment failure". As a preventative measure to prevent recurrence, equipment was adjusted and hasn't been determined which piece of equipment caused the failure either the PNT and the Opener both were adjusted. A similar noncompliance was documented on NR# 0047-2011-14848, dated 06/13/2011. The records stated that "the pumps on the bird washers went out." Pumps were replaced to restore water pressure. Measures to prevent reoccurrence the pumps will be replaced as they go bad. The preventative measures was not implemented or ineffective in preventing this type of noncompliance. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
0049-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	14-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	I was performing a Food Safety/OCP verification test on line (b)(4) at approximately 13:03 hrs. I observed a brownish green pasty substance approximately 1/2 inch in diameter in the kidney area of one carcass from a randomly selected sample of ten. Using color, consistency and composition, the substance was determined to be feces by the IIC. (b)(6) (b)(7)(C) (line leader) was notified of the establishment's failure to comply with Zero tolerance standards. The affected carcass was taken to reprocessing to be reconditioned. The establishment initiated their corrective actions as stated in their current HACCP Plan. The Establishment's HACCP Corrective Actions Recording Form dated 06/14/2011 states the cause of the deviation "Employee error." As a measure to prevent recurrence "employee was written up for poor workmanship."

0053-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	23-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	<p>I was performing a Food Safety/OCF verification test on line (b)(4) at approximately 08:15 hrs. I observed a greenish pasty substance approximately 1/4 inch in diameter on the outside breast area of one carcass from a randomly selected sample of ten. Using color, consistency, and composition, the substance was determined to be feces by the IIC. Evisceration Supervisor, (b)(6) (b)(7)(C) was notified of the establishment's failure to comply with Zero tolerance standards. The affected carcass was taken to reprocessing to be reconditioned. The establishment initiated their corrective actions as stated in their current HACCP Plan. (b)(6) (b)(7)(C) stated the cause of the deviation "feces dripped from a gut hanging from the pack line" the gut was removed. The Establishment's HACCP Corrective Actions Recording Form dated 06/14/2011 states to prevent recurrence (b)(4) A similar noncompliance was documented on NR#0050-2011-14858 dated 06/16/2011. The record's stated Measures to prevent reoccurrence: (b)(4) (b)(4) The preventive measure was not implemented or ineffective in preventing this type of noncompliance. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.</p>
0056-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	25-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	<p>I was performing a Food Safety/OCF verification test on line (b)(4) at approximately 06:39hrs. I observed a greenish brown pasty substance approximately 1/4 inch in diameter in the kidney area of two carcasses from a randomly selected sample of ten. Using color, consistency, and composition, the substance was determined to be feces by the IIC. (b)(6) (b)(7)(C) (line leader) was notified of the establishment's failure to comply with Zero tolerance standards. The affected carcasses were taken to reprocessing to be reconditioned. The establishment initiated their corrective actions as stated in their current HACCP Plan. (b)(6) (b)(7)(C) (Evisceration Supervisor) stated the cause of the deviation (b)(4) (b)(4) The guide bar was adjusted. The Establishment's HACCP Corrective Actions Recording Form dated 06/25/2011 states to prevent recurrence (b)(4) (b)(4) A similar noncompliance was documented on NR#0055-2011-14858 dated 06/24/2011. The record's stated Measures to prevent reoccurrence: (b)(4) The preventive measure was not implemented or ineffective in preventing this type of noncompliance. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.</p>

0058-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	28-Jun-11	1	03J01	417.2(c)(4)	<p>While performing parts inspection at approximately 1149 hours, I observed a greenish brown substance approximately 1/4 inch in diameter on one wing. Using color, consistency, and composition, the substance was determined to be feces. (b)(6) (b)(7)(C) (Evisceration Supervisor) was notified of the noncompliance, and the establishments failure to comply with zero tolerance standards. Corrective actions were performed as stated in the current HACCP Plan. Tag # B34295021 was applied to three tubs of affected product. All affected product was reconditioned, HACCP tech. performed a retest at 1236 hrs. and verification test at 1238 hrs. both test passed. (b)(6) (b)(7)(C) stated " employee error and that the employee responsible would be wrote up." The CCP was brought back under control at approximately 1244 hours.</p>
0059-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	5-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	<p>I was performing a Food Safety Test on line (b)(4) at approximately 0839 hrs. I observed a dark greenish pasty substance approximately 1/2 inch in diameter in the kidneys area from a randomly selected sample of ten. Using color, consistency, and composition, the substance was determined to be feces and confirmed by the IIC (b)(6) (b)(7)(C) Supervisor (b)(6) (b)(7)(C) was notified of the establishment's failure to comply with Zero tolerance standards. The affected carcass was taken to be reconditioned. Corrective Action were implemented by the establishment as stated in the HACCP Plan. After the investigation, the cause of deviation was "found one nozzle that was partially clogged". Measure to prevent reoccurrence was (b)(4) according to establishment's records. A similar noncompliance was documented on NR#0057 dated 06/27/2011. The records stated measure to prevent reoccurrence:"in the future maintenance will make (b)(4) (b)(4) The preventative measure was not implemented or was ineffective in preventing this type of noncompliance. In the weekly meeting dated 06-28-2011, (b)(6) (b)(7)(C) discussed with plant management about recent NR's linkage developing a trend. This document serves as a written notification that your failure to comply with regulatory requirements could result in additional regulatory or administrative action.</p>

0063-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	11-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	<p>While performing a Food Safety Test on line (b)(4) at approximately 0549 hours, I observed a brownish pasty substance approximately 1/4 inch in diameter in the kidney area from a randomly selected sample of ten. Using color, consistency, and composition, the substance was determined to be feces. (b)(6) (b)(7)(C) Line Leader) was notified of the establishment's failure to comply with Zero Tolerance Standards. The affected carcass was taken to be reconditioned. Corrective Actions were implemented by the establishment as stated in the current HACCP Plan. After the investigation, the cause of the deviation was " PNT had a spoon out of adjustment causing the birds to be contaminated". Measures to prevent reoccurrence was (b)(4) according to establishment's records. A similar noncompliance was documented on NR # 0059 dated 07/05/2011. The records stated measure to prevent reoccurrence: " (b)(4) (b)(4) The preventative measure was not implemented or was ineffective in preventing this type of noncompliance. This document serves as a written notification that your failure to comply with regulatory requirements could result in additional regulatory or administrative action.</p>
0072-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	4-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	<p>While performing a Food Safety verification test on line (b)(4) at 0950hrs, I observed a dark greenish pasty substance 3/16 inch diameter located inside the vent area of one carcass of a randomly selected sample of ten. Using color, consistency, and composition, the substance was determined to be feces by (b)(6) (b)(7)(C) IIC. Line Leader, (b)(6) (b)(7)(C) was notified of the establishment's failure to comply with the zero tolerance standards. The affected carcass was taken to reprocessing to be reconditioned. I verified that the establishment initiated their corrective action procedure as per stated in their HACCP Plan to reinstate control. The Establishment's Corrective Action Recording Form dated 08/04/2011 states the cause of deviation " vent machine not venting properly performing at 90% at the time of machinery check." As a measure to prevent recurrence " equipment malfunction, equipment was repaired." A similar noncompliance was documented on NR# 0070 dated 07/28/2011. The records stated to prevent reoccurrence was " (b)(4) The preventative measure was not implemented or ineffective in preventing this type of noncompliance. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action</p>



0080-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	12-Aug-11	1	04C04	381.3(b), 381.78, 381.90	I was in the Evisceration Department verifying and evaluating the OCP process control at 1247 hrs. I observed a carcass showing evidence of having died from causes other than slaughter on Line <sup>(b)(6)</sup> station #2. The sorter proceeded to remove the carcass from the Evisceration line and placed the carcass on the sorter's lower rack. Upon further examination, the carcass had the head attached. The head was blood red and swollen. No evidence was found of the neck being cut. After placing the carcass on the rack, the sorter resumed her sorting duties. The sorter failed to press the yellow button to condemn the paws and remove the giblets (Heart, Liver, Paws, Necks and Gizzard). 9CFR381.78 (a) states: "At the time of any inspection under this subpart each carcass, or any part thereof, which is found to be adulterated shall be condemned, except that any such article which may be not adulterated by reprocessing, need not be so condemned it so reprocessed under the supervision of an inspector and thereafter found to be not adulterated". The paws and giblets went through the system to be harvested. I immediately stopped the Evisceration Line and tagged it with US Retain #B41251414. Evisceration Supervisor <sup>(b)(6) (b)(7)(C)</sup> was shown the carcass and agreed with CSI findings. <sup>(b)(6) (b)(7)(C)</sup> called a Code 4 meaning condemnation of all paws and giblets. <sup>(b)(6) (b)(7)(C)</sup> was notified of this noncompliance. The establishment elected to condemn the carcass including: 790 pds of paws, 128 pds of gizzard, 26 pds of hearts, 34 pds of necks, and 232 pd of livers. <sup>(b)(6) (b)(7)(C)</sup> stated "the employee would be written up". The line was relinquish at 1250 hrs.
0081-2011-14848	9	00177 P	Pilgrim's Pride Corporation	GA	18-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	I was performing a Food Safety verification test on line <sup>(b)(6)</sup> at approximately 0949 hrs. I observed a greenish pasty substance approximately 1/4 inch in diameter located inside the vent area of one carcass from a randomly selected sample of ten. Using color, consistency, and composition, the substance was determined to be feces by IIC. <sup>(b)(6) (b)(7)(C)</sup> was notified of the establishment's failure to comply with Zero Tolerance Standards. The establishment initiated their corrective actions as stated in their current HACCP Plan. The affected carcass was taken to reprocessing to be reconditioned. The establishment's corrective action form dated 08/18/11 states the cause of deviation "the bird washer on the line <sup>(b)(6)</sup> misfeeding from a guide bar that was out of adjustment." As a preventive measure " maintenance monitor performance of bird washer for misfeeds make adjustments when necessary." A similar noncompliance was documented on NR#0072-2011-14848 dated 08/04/2011. The records indicated to prevent reoccurrence was " after further investigation it was determined that the Inside/Outside bird washer nozzles weren't working at optimum performance. New Inside/Outside bird washer nozzles were ordered and installed on 08/07/11." The preventive measure was not implemented or ineffective in preventing this type of noncompliance. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.

0044-2011-10023	4501	00192 P	Pilgrim's Pride Corporation	AL	1-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At 1209, I performed a 03J01 verification check on a tub of reprocessed /salvage parts in tub # 28. I found fecal contamination on one of the wing tips . The fecal measured approximately 1/8 of an inch in diameter, and was dark green in color with a pasty consistency. I notified Utility (b)(6) (b)(7)(C) for corrective action, the tub of parts was retained for reconditioned. This is a failure of CCP (b)(4). Please be advised this document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
0045-2011-10023	4501	00192 P	Pilgrim's Pride Corporation	AL	3-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At 1305 while performing a ten bird verification check on line (b)(4) the eighth bird of the ten bird sample contained fecal material inside the carcass near the thigh bone. Fecal material was approximately 1/8" in diameter, green in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) for (b)(4). Past Similar NRs - Previous Ineffective Plant Actions: NR: 44-2011 dated 3/1/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).

0046-2011-10023	4501	00192 P	Pilgrim's Pride Corporation	AL	8-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At 0657 while performing a 03J01 verification salvage parts check on a tub of wing portions, feces was found on one part in tub # 10. Feces was approximately 1/8" in diameter, light brown in color, and pasty in consistency. Employee (b)(6) (b)(7)(C) was immediately notified of the noncompliance and to notify supervision for corrective action(s). The tub of wing portions was passed by FSIS and allowed to enter production after all corrective action(s) were performed. Past Similar NRs - Previous Ineffective Plant Actions: NR: 45-2011 dated 3/3/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).
0049-2011-10023	4501	00192 P	Pilgrim's Pride Corporation	AL	9-Mar-11	1	03J01	381.65(e), 417.2(c)	At 1126, while performing a verification check on line (b)(4) I observed green/brown fecal material on the 5th bird of a ten bird randomly selected sample. It was smeared approximately 1 1/2" across the inside of the carcass and had not been properly vented, with cloaca still attached and approximately 3" of intestine on the inside of the carcass. Also, on the tail area of the carcass was approximately 1/2" smear and approximately 1/2" smear on the back. I notified (b)(6) (b)(7)(C) Food Safety, of the deficiencies so corrective actions could be implemented. This is a deviation from the plants HACCP plan and the regulatory requirements that all poultry carcasses must be free from visible fecal material before entering the chilling system. Although preventive measures may have been applied, they were either ineffective or failed to prevent today's failure.

0057-2011-10023	4501	00192 P	Pilgrim's Pride Corporation	AL	11-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At 0850 while performing carcass line inspection duties on line (b)(4) a carcass that had been hung by one leg exposing the inside giving a clear view for inspection, was found to contain two spots of feces. Line was immediately stopped and Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). The neck appeared to have been manually trimmed and kidneys manually removed. This is consistent with salvage/reprocessing procedures. The two spots of feces were each approximately 1/8" in diameter, green in color, and pasty in consistency. Feces was located in the upper breast area inside the carcass and near the tail area. After all salvaged birds were removed from Line (b)(4) for corrective action(s), the line was restarted and production was continued. This is a failure of CCP (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 55-2011 dated 3/10/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).
0061-2011-10023	4501	00192 P	Pilgrim's Pride Corporation	AL	16-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At 1008 while performing a ten bird verification check on line (b)(4) the seventh bird of the ten bird sample contained fecal material on one leaf flap. Fecal material was approximately 1/16" in diameter, green in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) for fecal material. Past Similar NRs - Previous Ineffective Plant Actions: NR: 57-2011 dated 3/11/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).

0062-2011-10023	4501	00192 P	Pilgrim's Pride Corporation	AL	16-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At 1307 while performing 03J01 verification procedure on evisceration line (b)(4) I observed fecal contamination on bird number ten of my ten bird sample check. Feces was approximately 1/2 of an inch in diameter located on the inside of carcass on an intestine attached to a gizzard and liver. I notified food safety (b)(6) (b)(7)(C) for corrective action. This is a failure of the establishment CCP- (b)(4) for (b)(4) Past similar NRs . Previous ineffective plant action NR- 61 -2011 dated 03/16/2011 . Please be advised this document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
0064-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	24-Mar-11	1	04C04	381.3(b)	On 03/24/2011, Plant 00192 exceeded the number of days above performance standard for OCP-5 (25 days - 5 days allowable), Table 3. Dates failed were 03/02/2011: 17/50 (50 bird sample), 03/04/2011: 16/50, 03/10/2011: 16/50, 03/14/2011: 15/50, 03/17/2011: 18/50 and 03/24/2011: 14/50. Total days failed= 6. (b)(6) (b)(7)(C) Food Safety Supervisor was advised of this failure of a 25-day limit. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.

0065-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	29-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At 0505 while performing 03J01 food safety verification procedure on line (b)(4) fecal material was found in the fifth bird of a ten bird sample. Fecal material was located inside the carcass near the tail area. The fecal material was approximately 1/16" in diameter, dark brown in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was immediately notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) for (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 62-2011 dated 3/16/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
0066-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	29-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At 0655 while performing 03J01 food safety verification procedure on line (b)(4) fecal material was found in the fourth bird of a ten bird sample. Fecal material was located inside the carcass near the tail area. The fecal material was approximately 1/16" in diameter, dark brown in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was immediately notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) or (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 65-2011 dated 3/29/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.

0069-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	31-Mar-11	1	04C04	381.3(b)	On the 03/30/2011 the establishment at P-192 exceeded the maximum limits from table (2) which is a total of 4/50 for airsacculitis . The following times and corresponding random 10 bird samples for Lines (b)(4) failed for the Other Consumer Protection checks for airsacculitis: Line (b)(4) 0540- 1/10 Line (b)(4) 0846- 1/10 Line (b)(4) 1010- 2/10 The following sample set failed for line (b)(4) Line (b)(4) 1146-1/10 These 10 bird random sample sets exceeded the maximum of 4/50 allowed with a failing total of 5/50. Supervisor (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). The establishment went into action by performing additional checks at the postchill stations per the establishments corrective actions. This document serves as written notification that your failure to comply with regulatory requirements could result in additional regulatory or administrative actions.
0073-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	22-Apr-11	1	04C04	381.3(b)	On 4-22-2011, Plant 00192 exceeded the number of days above performance standard for OCP5 (5days-25 days allowable) Table 3. Total days exceeded limit was 6 days. Days failed were 4-5-11;14/50,4-8-11:14/50,4-11-11;16/50,4-12-11:15/50,4-14-11:15/50 and 4-22-11:14/50. (b)(6) (b)(7)(C) Food Safety Supv. was advised of this failure of a 25 day limit. Same noncompliance on NR64 3-24-2011. This document serves as written notification that your failure to comply with regulatory requirements could result in additional regulatory or administrative action.

0074-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	26-Apr-11	1	03J01	381.65(e), 417.2(c)(4)	While performing a Food Safety and OCP check at 1122 on evisceration line (b)(4) I observed fecal contamination on bird # 2 of my ten bird sample check. There were three spots of fecal, one on the flap and two on the drum stick. The size was approximately 1/8 of an inch in diameter, dark green in color with a pasty consistency . I notified food safety (b)(6) (b)(7)(C) for corrective action . This is a failure of the establishment's CCP (b)(4) for (b)(4) . Past similar NR- previous ineffective plant actions and it's preventive measure Nr-66 -2011 dated 03 -29-2011. Maintenance stopped production removed the vent probe that was bent on the auto ventor replaced it with a new one .Also reset in feed trimming on the machine. This document serves as written notification that your failure to comply with regulatory requirements could result in additional regulatory or administrative action.
0075-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	6-May-11	1	03J01	381.65(e), 417.2(c)(4)	At 0916 while performing an 03J01 verification procedure on evisceration line (b)(4) I observed fecal contamination on bird number 10 of my ten bird sample check. Feces was approximately 1/8 of an inch in diameter located on the inside kidney area. I notified food safety (b)(6) (b)(7)(C) for corrective action. This is a deviation from the establishment's HACCP plan CCP (b)(4) and regulatory requirement 381.65 (e) . A similar NR-with it's preventive measures: Nr-74 -04/26/2011. Maintenance removed three dull cutter blades and replaced with new blades . Also checked machine for two min. machine check out . Also adjusted in feed guide bars and auto ventor it check out ok . Please be advised this document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action with regulatory.



0076-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	6-May-11	1	03J01	381.65(e), 417.2(c)(4)	At 0946 while performing a ten bird verification check on line (b)(4) the second bird of the ten bird sample contained fecal material inside the carcass near the tail area. Fecal material was approximately 1/16" in diameter, green in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) for (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 75-2011 dated 5/6/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).
0079-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	12-May-11	1	03J01	381.65(e), 417.2(c)(4)	At 0809 while performing an 03J01 verification and OCP procedure on evisceration line (b)(4) I observed fecal contamination on bird number one of my ten bird sample check. Feces was approximately 1/2 of an inch in diameter yellowish brown color located on the inside breast area. I notified food safety (b)(6) (b)(7)(C) for corrective action. This is a deviation from the establishment's HACCP plan CCP (b)(4) and regulatory requirement 381.65 (e) . A similar NR-with it's preventive measures:Nr-76-2011 dated 05/06/2011 . Maintenance readjusted the auto opener to prevent contamination and a employee was added to back-up the ventor and auto opener . Please be advised this document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action with regulatory.

0080-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	12-May-11	1	03J01	381.65(e), 417.2(c)(4)	At 1004 while performing a ten bird verification check on line (b)(4) the seventh bird of the ten bird sample contained fecal material on the hock. Fecal material was approximately 1/16" in diameter, green in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) for (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 79-2011 dated 5/12/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).
0083-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	31-May-11	1	03J01	381.65(e), 417.2(c)(4)	At 1134 while performing a 03J01 verification salvage parts check on a tub of wing tips, feces was found on one part in tub #32. Feces was approximately 1/16" in diameter, dark green in color, and pasty in consistency. Employee (b)(6) (b)(7)(C) was immediately notified of the noncompliance and for corrective action(s). At 1155 tub #32 was passed by FSIS and allowed to enter production after all corrective action(s) were performed. This is a failure of the establishment's CCP (b)(4) for (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 80-2011 dated 5/12/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).

0085-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	1-Jun-11	1	04C04	381.3(b)	On 05-31-11 Plant 00192 exceeded the number of days above performance standard for OCP-5 ( days - 25 days allowable) Table 3. Total number of days exceeding limit - 6 days. Days failed were 04-25-11;15/50: 05-11-11;16/50: 05-16-11;21/50: 05-23-11;16/50: 05-27-11;15/50: 05-31-11;14/50. (b)(6) (b)(7)(C) Food Safety Supervisor was advised of this failure on 06-01-11. Same noncompliance on NR 73 04-22-11. This document serves as written notification that your failure to comply with regulatory requirements could result in additional regulatory or administrative action.
0088-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	7-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	At 0815 while performing a 03J01 verification procedure on evisceration line (b)(4) I observed fecal contamination on bird number five of my ten bird sample check. Feces was approximately 1/2 of an inch in diameter yellowish in color located on the inside kidney area. I notified food safety (b)(6) (b)(7)(C) for corrective action. This is a deviation from the establishment's HACCP plan CCP (b)(4) and regulatory requirement 381.65 (e) . A similar NR-with it's preventive measures: NR-80-05/12/2011 . Maintenance removed the defected draw machine part, and replaced gut clamp with new clamp. Also checked all 20 clamps on machine they were ok . Please be advised this document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action .

0093-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	14-Jun-11	1	03J01	417.3(a)(3)	The Noncompliance Records (from the past 6 months) as linked and documented in the CFSA Background Inspection Information Section reflected a trend of ineffective HACCP Corrective Actions (Preventive Measure) at the establishment's Fecal Zero Tolerance Critical Control Points. Upon review of the establishment's HACCP Corrective Actions records from the past 90 days, the establishment's HACCP Corrective Action records documented a trend of ineffective HACCP Corrective Actions (Preventive Measures) in response to deviations or non-compliances caused by the ventors for both of the establishment's slaughter lines at the On-line Fecal Zero Tolerance Critical Control Point. Therefore it appears that the establishment has failed to comply with the regulatory requirements of 9 CFR 417.3 (a)(3).
0095-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	14-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	At 1253 while performing a 03J01 verification salvage parts check on a tub of wings, feces was found on one wing in tub #39. Feces was approximately 1/16" in diameter, dark green in color, and pasty in consistency. Employee (b)(6) (b)(7)(C) was immediately notified for corrective action(s). At approximately 1305, tub #39 was passed by FSIS and allowed to enter production after all corrective action(s) were performed. Past Similar NRs - Previous Ineffective Plant Actions: NR: 88-2011 dated 6/7/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).

0107-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	18-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At 1238 while performing a ten bird verification check on line (b)(4) the sixth bird of the ten bird sample contained three spots of fecal material inside the carcass in the area of the kidneys. Each spot of fecal material was approximately 1/8" in diameter, green in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) for (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 105-2011 dated 7/12/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).
0109-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	20-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At 0602 while performing a ten bird verification check on line (b)(4) the seventh bird of the ten bird sample contained fecal material on the outside of the carcass near the opening cut. Fecal material was approximately 1/16" in diameter, green in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 107-2011 dated 7/18/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).

0117-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	27-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At 0639 while performing a ten bird verification check on line (b)(4) the fifth bird of the ten bird sample contained fecal material inside the carcass near the tail/bursa area. Fecal material was approximately 1/16" in diameter, green in color, and pasty in consistency. Food Safety Supervisor (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 110-2011 dated 7/20/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).
0122-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	1-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	At 0530 while performing a ten bird verification check on line (b)(4) the fourth bird of the ten bird sample contained fecal material inside the leaf flap. Fecal material was smeared and covered an area approximately 1/4" in diameter, green in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 117-2011 dated 7/27/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).

0126-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	5-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	On 8/4/2011 at 1357 while performing a 03J01 verification salvage parts check on a tub of leg quarters, feces was found on one part in tub #39. Feces was approximately 1/8" in diameter, dark green in color, and pasty in consistency. Q.A. (b)(6) (b)(7)(C) was immediately notified of the noncompliance and for corrective action(s). Tub #39 was passed by Second Shift FSIS at a later time on 8/4/2011 and allowed to enter production after all corrective action(s) were performed. Past Similar NRs - Previous Ineffective Plant Actions: NR: 124-2011 dated 8/2/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).
0133-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	18-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	At 0829 while performing a ten bird verification check on line (b)(4) the sixth bird of the ten bird sample contained a piece of intestine that was approximately 1/8" in length. Fecal material was observed to be at the end of the intestine. The fecal material was approximately 1/16" in length, green in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 130-2011 dated 8/12/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).

0138-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	24-Aug-11	1	03J01	381.65(e), 417.4(a)(2)(ii)	At approximately 0936 while conducting an 03J01 at CCP (b)(4) of parts found 1 thigh with fecal contamination on the inside area of the thigh. The fecal was a thin 2 inch smear in length. The width was approximately the width of an ink pen line. The product was in the tub released by QA at 0926. I reported the Zero Tolerance failure to (b)(6) (b)(7)(C) at approximately 0937. The tub of product was reworked and later rechecked by (b)(6) (b)(7)(C) at approximately 0959. At this time the product had been brought into compliance and released to production.
0139-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	24-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	At 0948 while performing a ten bird verification check on line (b)(4) the sixth bird of the ten bird sample contained fecal material under the tail outside of the carcass. Fecal material was approximately 1/16" in diameter, green in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) ast Similar NRs - Previous Ineffective Plant Actions: NR: 138-2011 dated 8/24/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).



0146-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	31-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	At 0506 while performing a ten bird verification check on line (b)(4) the tenth bird of the ten bird sample contained fecal material inside the carcass between the tail and kidney areas. Fecal material was approximately 1/8" in diameter, green in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective action(s). This is a failure of the establishment's CCP (b)(4) Past Similar NRs - Previous Ineffective Plant Actions: NR: 145-2011 dated 8/30/2011 This document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).
0147-2011-19480	4501	00192 P	Pilgrim's Pride Corporation	AL	31-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	At 0915 while performing a ten bird food safety check on line (b)(4) the tenth bird of the ten bird sample contained fecal material inside the carcass between the tail and kidney areas. Fecal material was approximately 1/4" in diameter, greenish brown in color, and pasty in consistency. Food Safety (b)(6) (b)(7)(C) was notified of the noncompliance and for corrective actions(s). This is a failure of the establishment's CCP (b)(4) this document serves as written notification that your failure to comply with regulatory requirement(s) could result in further regulatory or administrative action(s).

0100-2011-17532	4141	00206 P	Pilgrim's Pride Corporation	TX	10-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 1242 hours, while performing a Food Safety/ Other Consumer Protection verification test on the (b)(4) line the following noncompliance was observed: The second bird in the ten bird random sample was observed with fecal material located inside on left leaf fat of the carcass when looking inside. The fecal material was green in color with a semi-pasty consistency. There was no identifiable plant material present in or around the fecal material. The fecal material measured approximately a one quarter of an inch width and a half inch in length. (b)(6) (b)(7)(C) Evisceration Superintendent was verbally notified and shown the noncompliance. The bird was taken to the reprocessing area and reconditioned in (b)(4) ppm of chlorinated water after plant personal was shown the location of the fecal material inside the carcass. (b)(6) (b)(7)(C) Evisceration Superintendent stated the cause of the deviation was mechanical, due to a guide bar needing adjusting and two hose that had to be reattached on the final inside/outside bird washer. Please refer to NR0091-2011 dated 03/06/11 for similar noncompliance regarding a mechanical deviation from the critical limit of CCP (b)(4) and P206's written HACCP plan, dated 04/29/10 which states (b)(4) Preventative measures were ineffective in, or were not implemented in a way that is, preventing the noncompliance from recurring. Regulations 381.65(e) and 417.2(c) (4) of 9 CFR were not met. You are hereby advised of your right to appeal this decision as delineated by 381.35 of 9 CFR.
0112-2011-17532	4141	00206 P	Pilgrim's Pride Corporation	TX	21-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 1004 hours, while performing a scheduled FS ( Food Safety) evaluation at the VI station on the (b)(4) Line, fecal material was present on the eight carcass of my ten unit randomly selected carcass sample. The fecal material was located to the right of the thoracic inlet. The fecal material measured approximately one-fourth of an inch in diameter. The fecal materials were dark green in color with semi-solid texture. No identifiable plant material was present during my finding. (b)(6) (b)(7)(C) Evisceration Supervisor was verbally notified and shown this deviation. The presence of fecal material on or inside a carcass at the VI (Verification) station constitutes as a failure of the plant's Critical Limit CCP (b)(4) as set in the plants written HACCP Plan dated April 29, 2010, which states (b)(4) The affected carcass was taken to the reprocessing for reconditioning with chlorinated water which measured between (b)(4) ppm- (b)(4) ppm. FSIS Regulation 381.65 (e) and 417.2 (c) (4) of 9 CFR were not met. Please reference to NR# 0108-2011-17532, dated 03/16/2011, for a similar noncompliance of a deviation from the Critical Limit for CCP (b)(4) the establishment's preventive measures given, were ineffective in, or not properly implemented in a way that is preventing the noncompliance from recurring. You are hereby advised of your right to appeal this decision as delineated by 381.35 of 9 CFR.

0127-2011-17532	4141	00206 P	Pilgrim's Pride Corporation	TX	31-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 0920 hours, while performing a scheduled FS/OCP evaluation at the VI station on the (b)(4) Line, fecal material was present on the first carcass of my ten unit randomly selected carcass sample. The fecal material was located on the inside to the right just below the opening cut. The fecal material measured approximately one-fourth of an inch in diameter. The fecal materials were dark green in color with semi-solid texture. No identifiable plant material was present during my finding. (b)(6) (b)(7)(C) Evisceration Supervisor was verbally notified and shown this deviation. The presence of fecal material on or inside a carcass at the VI (Verification) station constitutes as a failure of the plant's Critical Limit CCP (b)(4) as set in the plants written HACCP Plan dated April 29, 2010, which states (b)(4). The affected carcass was taken to the reprocessing for reconditioning with chlorinated water which measured between (b)(4) ppm (b)(4) ppm. FSIS Regulation 381.65 (e) and 417.2 (c) (4) of 9 CFR were not met. Please reference to NR# 0119-2011-17532, dated 03/22/2011, for a similar noncompliance of a deviation from the Critical Limit for CCP (b)(4). The establishment's preventive measures given, were ineffective in, or not properly implemented in a way that is preventing the noncompliance from recurring. You are hereby advised of your right to appeal this decision as delineated by 381.35 of 9 CFR.
0130-2011-17532	4141	00206 P	Pilgrim's Pride Corporation	TX	4-Apr-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 0707 hrs, while performing a Food Safety-OCP (Other Consumer Protection) Records Test at the Verification Station on the (b)(4) Line, the following deviation from the Critical Limit for CCP (b)(4) was observed; Feces was observed in the tenth carcass of ten randomly selected carcasses. The bursa and approximately 2-inches of intestine were still attached. The feces was smeared on the left opening fat in an area of approximately 1/4-inch by 2-inches and on the right ribcage in an area of approximately 1/4-inch by 1-inch. The feces was brown in color with no identifiable plant material was present. (b)(6) (b)(7)(C) Evisceration Supervisor, was verbally notified and shown this noncompliance. The affected carcass was sent to the Reprocessing Department to be reconditioned per the Establishment's Parts Wash Procedure. This is a failure to comply with Regu (b)(4) (4) of 9 CFR. It is also a deviation of the Critical Limit for CCP (b)(4) dated 4/29/2010, which states (b)(4) NR #129-2011-17532, dated 4/3/2011, documents a similar noncompliance of the deviation of the Critical Limit for CCP (b)(4). The Establishment's preventive measure of repairing the leg loop of the (b)(4) has been ineffective in, or was not implemented in a way, that is preventing the noncompliance from recurring. You are hereby advised of your right to appeal this decision as delineated by 381.35 of 9 CFR.

0134-2011-17532	4141	00206 P	Pilgrim's Pride Corporation	TX	7-Apr-11	1	04C04	381.3(b), 381.84	At 1043 hours during verification sampling procedure for OCP1 in this (b)(4) line HIMP plant, the OCP1 maximum limits form Table 2 "Maximum Limits for various Samples Sizes" of young Chicken Inspection HIMP draft 8, dated 1/9/05, were exceeded (line (b)(6) 0905-1 airsacculitis; 01043-3 airsacculitis; Line (b)(6) 1007-1 airsacculitis) for a total of (b)(6) OCP1 defects out of a thirty bird sample. (b)(6) (b)(7)(C) Evisceration Supervisor, was notified. The facility began testing at postchill as per the draft. QA conducted prechill testing to demonstrate re-establishment of process control. Line speeds were reduced in an attempt to re-establish process control. After 3 failed tests, process control was re-established and was verified by USDA verification test at 1115 hours. Please refer to NR# 0121-2011, dated 03/24/2011 for a similar noncompliance of maximum baseline failure. You are hereby advised of your right to appeal this decision as delineated by 9 CFR381.35.
0011-2011-17468	4541	00341 P	Golden Rod Broilers Inc.	AL	3-May-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 1229 hours while performing a food safety test on Line (b)(4) (lot 4), I observed that bird #2 of my randomly selected ten bird sample set had a brownish-green fecal smear inside the carcass on the left flap measuring approximately one inch in length. Since there were no plant employees between me and the chiller, it is reasonable to conclude that the contaminated carcass would have entered the chiller in violation of Poultry Regulations 381.65 (e), and also a failure to comply with Regulation 417.2 (c) (4). Regulatory control action was taken, the line stopped and (b)(6) (b)(7)(C) was notified of the noncompliances. After the plant had implemented it's immediate corrective actions, and they were verified, production resumed. A similar noncompliance was documented on NR #009-2011-17468, dated 03/17/2011, and the corrective actions were either not followed or were ineffective in preventing another fecal failure at CCP (b)(4)

0013-2011-17468	4541	00341 P	Golden Rod Broilers Inc.	AL	6-May-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 07:20, while performing Food Safety Verification procedure on line number (b)(4) I was performing a ten-carass Food Safety check and I found fecal material on the number 8 (eight) carcass. I took immediate regulatory action, stopping the line, and informing (b)(6) (b)(7)(C) of this noncompliance. The fecal was located on the left-side of the tail, it was greenish-brown in color, and was globular shaped about 1/4 inch wide and 1/4 inch long. Regulatory action was taken until plant initiated corrective actions.
0025-2011-17468	4541	00341 P	Golden Rod Broilers Inc.	AL	25-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 9:14 a m while performing a food verification test on line (b)(4) i observed fecal located on the underside of the left wing on the # 5 of my ten test birds. The fecal was approx. 1/4 Inch long and brown in color. The bird was shown to (b)(6) (b)(7)(C) Plant implemented corrective actions.

0029-2011-17468	4541	00341 P	Golden Rod Broilers Inc.	AL	26-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 0630 hours while performing a food safety verification procedure on line (b)(4) (lot#2) I observed fecal on the left inside thigh area. It was in the #6 bird of my 10 bird randomly selected sample set. It was green in color and cover the entire area from the kidneys to the opening cut and up into the flap. I took regulatory control action by stopping the evisceration line and notifying (b)(6) (b)(7)(C) of the noncompliance. After the plant implemented its regulatory control action, the line was released for production.
0004-2011-16602	5118	00360 M	Clougherty Packing Co.	CA	7-Apr-11	1	03J01	417.2(c)(4)	At approximately 0620 while performing procedure 03J01, carcass verification for zero tolerance for fecal/ingesta, I observed the following non-compliance. On set #1 sample #1, I observed a smear of fecal contamination that was tannish brown in color and measured approximately 1and « inch x1 inch and located on the right side of the carcass in the pelvic canal. I took regulatory control by placing U.S. Retained tag #B37461014 on the carcass. I notified Lead HIMP auditor (b)(6) (b)(7)(C) and floor Supervisor (b)(6) (b)(7)(C) of my findings. (b)(6) (b)(7)(C) stated that the plants immediate action would be disciplinary action of the 'bung gun' operators and new blades for the 'bung guns' have been on order. An employee was instructed to trim the carcass, after re-inspecting the carcass, I removed the retained tag and released the carcass for production. I informed management that this non-compliance will be documented on an NR and discussed at the next USDA weekly meeting.

0006-2011-16602	5118	00360 M	Clougherty Packing Co.	CA	1-Jun-11	1	03J01	417.2(c)(4)	<p>Today at approximately 0718 hours during a zero tolerance verification inspection for FS-2 conditions (fecal/ingesta) I observed a regulatory noncompliance. While inspecting carcass sample #7 at the USDA rail station I observed several pieces of ingesta spread over different areas of the left and right jowls. The ingesta were fibrous, tan and brown in color. I took an immediate regulatory control action by retaining the carcass using U. S. retained tag NO. B37444912. I then notified Supervisor (b)(6) (b)(7)(C), Lead Himp Auditor (b)(6) (b)(7)(C) and Superintendent (b)(6) (b)(7)(C) of the failure to comply with regulations 9 CFR 417.2 (c) (4) which states that the establishment should monitor each of the critical control points to ensure compliance with the critical limits. I asked (b)(6) (b)(7)(C) what where the establishments immediate corrective actions. (b)(6) (b)(7)(C) informed me that he will monitor (15) extra carcasses every hour for the remainder of the shift. Neither (b)(6) (b)(7)(C) nor (b)(6) (b)(7)(C) could determine the rout cause of the non-compliance at this time. The contaminated jowls were trimmed and the carcass was released for further processing. I informed management that this issue will be discussed at the next USDA weekly meeting.</p>
0007-2011-16602	5118	00360 M	Clougherty Packing Co.	CA	6-Jun-11	1	03J01	417.2(c)(4)	<p>Today at approximately 0824 hours during a zero tolerance verification inspection for FS-2 conditions (fecal/ingesta) I observed a regulatory noncompliance. While inspecting carcass sample #10 at the USDA rail station I observed a piece of ingesta on the right jowl. The ingesta was plant like, tan in color and approximately 1/2 of an inch in length. I took an immediate regulatory control action by retaining the carcass using U. S. retained tag NO. B37444875. I then notified Lead Himp Auditor (b)(6) (b)(7)(C), Supervisor (b)(6) (b)(7)(C) and Superintendent (b)(6) (b)(7)(C) of the failure to comply with regulations 9 CFR 417.2 (c) (4) which states that the establishment should monitor each of the critical control points to ensure compliance with the critical limits. (b)(6) (b)(7)(C) was asked by management to come out to the USDA rail station and confirm that the substance was ingesta. (b)(6) (b)(7)(C) concurred with my decision and informed (b)(6) (b)(7)(C) that the substance was in fact ingesta. I asked (b)(6) (b)(7)(C) what where the establishments immediate corrective actions. (b)(6) (b)(7)(C) informed me that (15) extra carcasses will be monitored every hour starting after the first break for the remainder of the shift. The rout cause of the non-compliance could not be determined at this time. The contaminated jowl was trimmed and the carcass was released for further processing. I informed management that this issue will be discussed at the next USDA weekly meeting.</p>

0008-2011-14707	5118	00360 M	Clougherty Packing Co.	CA	6-Jul-11	1	03J01	417.2(c)(4)	<p>Today at approximately 1030 hours during a zero tolerance verification inspection for FS-2 conditions (fecal/ingesta) I observed a regulatory noncompliance. While inspecting carcass sample #18 at the USDA rail station I observed 2 pieces of ingesta on the right Jowl. The ingesta were fibrous, tan and spread over an area of 1/4 x 1/4 of inch. I took a regulatory control action by retaining the carcass using U. S. retained tag NO. B37444884. I then notified Supervisor (b)(6) (b)(7)(C) and Lead Himp Auditor (b)(6) (b)(7)(C) of the failure to comply with regulations 9 CFR 417.2 (c) (4) which states that the establishment should monitor each of the critical control points to ensure compliance with the critical limits. I asked (b)(6) (b)(7)(C) what where the establishments immediate corrective actions. (b)(6) (b)(7)(C) informed me that he would have an extra employee monitor the Jowls after the spinal cord removal station for the remainder of the day. Neither (b)(6) (b)(7)(C) nor (b)(6) (b)(7)(C) could determine the rout cause of the non-compliance at this time. The contaminated Jowl was trimmed and the carcass was released for further processing. I informed management that this issue will be discussed at the next USDA weekly meeting.</p>
0009-2011-14707	5118	00360 M	Clougherty Packing Co.	CA	8-Jul-11	1	03J01	417.2(c)(4)	<p>Today at approximately 1143 hours during a zero tolerance verification inspection for FS-2 conditions (fecal/ingesta) I observed a regulatory noncompliance. While inspecting carcass sample #21 at the USDA rail station I observed a smear of fecal contamination in the anal canal (right side). The fecal was solid, brown and spread over an area of 2 1/2 x 2 1/2 inches. I took a regulatory control action by retaining the carcass using U. S. retained tag NO. B37444879. I then notified Supervisor (b)(6) (b)(7)(C) and Lead Himp Auditor (b)(6) (b)(7)(C) of the failure to comply with regulations 9 CFR 417.2 (c) (4) which states that the establishment should monitor each of the critical control points to ensure compliance with the critical limits. I asked (b)(6) (b)(7)(C) what where the establishments immediate corrective actions. (b)(6) (b)(7)(C) informed me that for the remainder of the shift; he would have an extra employee monitor the anal canal on the stand right after the HIMP Auditor's rail station. Neither (b)(6) (b)(7)(C) nor (b)(6) (b)(7)(C) could determine the rout cause of the non-compliance at this time. After verifying that the fecal contamination was trimmed I released the carcass for further processing. I informed management that this issue will be discussed at the next USDA weekly meeting.</p>



0029-2011-15683	3852	00468 P	Peco Foods, Inc	AR	13-May-11	1	03J01	381.65(e)	At approximately 0625 while performing a scheduled 03J01 zero fecal tolerance test on line (b)(4) lot number 1. On carcass number 3 out of 10 randomly selected young chicken carcass, I observed fecal on the hock, this adulteration was approximately 1/2 inch in length and approximately 1/4 inch wide. Dark green in color and had a pasty consistency. I immediately stopped the line and notified line leader (b)(6) (b)(7)(C). This is a failure of zero fecal tolerance procedure. (b)(6) (b)(7)(C) my IIC was notified.
0031-2011-18016	3852	00468 P	Peco Foods, Inc	AR	24-May-11	1	03J01	417.2(c)(4), 417.6	At approximately 0605 while performing a check on young chicken carcass parts, at CCP (b)(6) I observed fecal contamination on a wing approximately 1/4 inch long and 1/8 inch wide. This adulteration was dark green in color and pasty in consistency. This is a failure of the plants HACCP Plan CCP (b)(4). This was lot number one. (b)(6) (b)(7)(C) my IIC was notified.

0033-2011-15683	3852	00468 P	Peco Foods, Inc	AR	2-Jun-11	1	03J01	381.65(e)	At approximately 1150 while performing a scheduled 03J01 zero fecal tolerance test on line (b)(4) lot number 2. I observed fecal on the 1st young chicken carcass of a ten bird test, the adulteration was approximately 1/8 inch in diameter, pasty in consistency, and dark green in color. I stopped the line and notified line leader (b)(6) (b)(7)(C). This is a failure of plants of zero fecal tolerance procedure.
0050-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	17-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 0800, while performing ISP Code 03J01 (Food Safety) verification check on evisceration line (b)(4) lot #2, I observed the following regulatory noncompliance. Fecal material that was brown and semi-solid in appearance and was approximately 10 mm x 8 mm in size was observed inside the carcass on the right flank above the ribs of the 6th of 10 carcasses that were randomly selected for the Food Safety verification. The presence of fecal material created an insanitary condition which would lead to the production of contaminated or/and adulterated product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements of 9 CFR 381.65(e) and 9 CFR 417.2(c) (4). In addition, the establishment's HACCP plan for CCP-(b)(4) which states, (b)(4) (b)(4) failed. A similar regulatory noncompliance involving fecal material was recorded on NR # 0038 -2011, which was dated 02/21/2011. Due to the recurrent nature of this deficiency, the further planned action, "The opener was adjusted. A 25 bird test was done. The retest passed." was ineffective. (b)(6) (b)(7)(C) Day Shift Manager, was notified of this regulatory noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements could result in additional regulatory or administrative action as described in 9 CFR 500.4.

0057-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	25-Mar-11	1	04C04	381.65(a)	<p>At approximately 0811, while performing ISP code 03J02 (HACCP/Raw not Ground), at the Giblet/Neck chiller in 1st Processing, I observed the following 04C04 regulatory noncompliance: I observed a section of intestine containing a complete lumen approximately 2 inches in length that contained fecal material attached to a chicken liver in the liver chiller exit bin. Additionally, visible fecal material was observed oozing out of this intestine onto product in production in the chiller exit bin. Because of the location of the intestine, it is reasonable to conclude that the intestine entered the liver chiller, traveled through the chilling system, and then exited the chilling system into the product exit bin. This creates an insanitary condition and also indicates a lack of process control by allowing cross contamination of product for digestive tract contents and/or fecal material. This regulatory noncompliance represents insanitary handling of product and a potentially food safety concern which could lead to the contamination and/or adulteration of product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements 9 CFR 381.65(a) and 9 CFR 416.4(d). In addition, the establishment's "Procedure for intestine with feces found in the Giblet Chiller Operation", section 1 &amp; 4, which states, (b)(4)</p> <p>(b)(4)</p> <p>facility is maintained." (b)(4)</p> <p>(b)(4)</p> <p>(b)(4)</p> <p>(b)(4)</p> <p>failed. Regulatory control action was taken as described in 9 CFR 500.2 by applying U.S. Rejected tag # B34644087 was applied to the liver chiller exit bin. A similar regulatory noncompliance was documented on NR # 0031 dated 02-15-10 with the same root cause. The further planned actions proposed by management included, "The gut cutter was cleaned out and some adjustments were made." failed. Due to the repetitive nature of this regulatory noncompliance, it is reasonable to conclude that the preventive measures proposed by the establishment in response to these noncompliances were ineffective at preventing the recurrence. The issue with the in the liver exit bin was discussed with plant management during the weekly meeting held on 02-17-2011. (b)(6) (b)(7)(C) 1st Processing Supervisor, was notified of the noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements could result in additional regulatory or administrative action as described in 9 CFR 500.4.</p>
0063-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	4-Apr-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1100, while performing ISP Code 03J01 (Food Safety) verification check on evisceration line (b)(4) lot #2, I observed the following regulatory noncompliance. The fecal material mass that was green and pasty in appearance and was approximately 1/4" x 1/8" in size was observed on the inside, kidney area of the seventh bird of a randomly selected 10 bird food safety verification. The presence of fecal material created an insanitary condition which would lead to the production of adulterated product. This regulatory noncompliance resulted from the establishment's failure to meet the regulatory requirements of 9 CFR 381.65(e) and 9 CFR 417.2(c)(4). In addition, the establishment's HACCP plan for CCP (b)(4) which states, (b)(4)</p> <p>(b)(4) failed. (b)(6) (b)(7)(C) 1st processing supervisor, was notified of this regulatory noncompliance. A similar regulatory noncompliance was recorded on NR #0050-2011 which was dated 3/17/2011. Due to the recurrent nature of this deficiency, the further planned action, "The opener was adjusted, A retest was done the retest passed" was ineffective. Continued failure to meet regulatory requirements can lead to enforcement actions as described in 9 CFR 500.4.</p>

0067-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	8-Apr-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0640, while performing ISP Code 03J01 (Food Safety) verification check on evisceration line (b)(4) lot #5, I observed the following regulatory noncompliance. Two masses of fecal material that were green and pasty in appearance and both were approximately 1/4" x 1/8" in size was observed on the inside of the breast cavity on the keel bone of the first bird of a randomly selected 10 bird food safety verification. The presence of fecal material created an insanitary condition which would lead to the production of adulterated product. This regulatory noncompliance resulted from the establishment's failure to meet the regulatory requirements of 9 CFR 381.65(e) and 9 CFR 417.2(c) (4). In addition, the establishment's HACCP plan for CCP: (b)(4) which states: (b)(4) (b)(4) failed. (b)(6) (b)(7)(C) 1st processing supervisor, was notified of this regulatory noncompliance. A similar regulatory noncompliance was recorded on NR #0063-2011 which was dated 4/4/2011. Due to the recurrent nature of this deficiency, the further planned action, "Maintenance adjusted the opener , A retest was done the retest passed" was ineffective. Continued failure to meet regulatory requirements can lead to enforcement actions as described in 9 CFR 500.4.</p>
0081-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	4-May-11	1	04C04	381.65(a)	<p>At approximately 0829, while performing ISP code 03J02 (HACCP/Raw not Ground), at the Giblet/Neck chiller in 1st Processing, I observed the following 04C04 regulatory noncompliance: I observed a section of intestine containing a complete lumen approximately 1 1/4 inches in length that contained fecal material attached to a chicken liver in the liver chiller exit bin. Additionally, visible fecal material was observed oozing out of this intestine onto product in production in the chiller exit bin. Because of the location of the intestine, it is reasonable to conclude that the intestine entered the liver chiller, traveled through the chilling system, and then exited the chilling system into the product exit bin. This creates an insanitary condition and also indicates a lack of process control by allowing cross contamination of product for digestive tract contents and/or fecal material. This regulatory noncompliance represents insanitary handling of product and a potentially food safety concern which could lead to the contamination and/or adulteration of product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements 9 CFR 381.65(a) and 9 CFR 416.4(d). In addition, the establishment's "Procedure for intestine with feces found in the Giblet Chiller Operation", section 1 &amp; 4, which states: (b)(4) (b)(4) (b)(4) failed. Regulatory control action was taken as described in 9 CFR 500.2 by applying U.S. Rejected tag # B34644129 was applied to the liver chiller exit bin. A similar regulatory noncompliance was documented on NR # 0057 dated 03-25-11 with the same root cause. The further planned actions proposed by management included, (b)(4) (b)(4) failed. Due to the repetitive nature of this regulatory noncompliance, it is reasonable to conclude that the preventive measures proposed by the establishment in response to these noncompliances were ineffective at preventing the recurrence. The issue with intestines in the giblet chillers was discussed with plant management during the weekly meeting held on 03-31-2011. (b)(6) (b)(7)(C) QA Supervisor, and (b)(6) (b)(7)(C) 1st Processing Superintendent, were notified of the noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements could result in additional regulatory or administrative action as described in 9 CFR 500.4.</p>

0082-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	5-May-11	1	04C04	381.65(a)	<p>At approximately 0636, while performing ISP code 03J02 (HACCP/Raw not Ground), at the Giblet/Neck chiller in 1st Processing, I observed the following 04C04 regulatory noncompliance: I observed 4 sections of intestine containing a complete lumen ranging from approximately 1 1/2 to 3/4 inches in length that contained fecal material attached to a chicken liver in the liver chiller exit bin. Additionally, visible fecal material was observed oozing out of this intestine onto product in production in the chiller exit bin. Because of the location of the intestine, it is reasonable to conclude that the intestine entered the liver chiller, traveled through the chilling system, and then exited the chilling system into the product exit bin. This creates an insanitary condition and also indicates a lack of process control by allowing cross contamination of product for digestive tract contents and/or fecal material. This regulatory noncompliance represents insanitary handling of product and a potentially food safety concern which could lead to the contamination and/or adulteration of product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements 9 CFR 381.65(a) and 9 CFR 416.4(d). In addition, the establishment's "Procedure for intestine with feces found in the Giblet Chiller Operation", section 1 &amp; 4, which states, (b)(4)</p> <p>(b)(4)</p> <p>(b)(4)</p> <p>(b)(4) failed. Regulatory control action was taken as described in 9 CFR 500.2 by applying U.S. Rejected tag # B34644128 was applied to the liver chiller exit bin. A similar regulatory noncompliance was documented on NR # 0081 dated 05-04-11 with the same root cause. The further planned actions proposed by management included, (b)(4)</p> <p>(b)(4) failed. Due to the repetitive nature of this regulatory noncompliance, it is reasonable to conclude that the preventive measures proposed by the establishment in response to these noncompliances were ineffective at preventing the recurrence. The issue with intestines in the giblet chillers was discussed with plant management during the weekly meeting held on 03-31-2011. (b)(6) (b)(7)(C) 1st Processing Superintendent, and (b)(6) (b)(7)(C) 1st Processing Supervisor, were notified of the noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements could result in additional regulatory or administrative action as described in 9 CFR 500.4.</p>
0096-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	20-May-11	1	04C04	381.65(a)	<p>At approximately 0953, while performing ISP code 03J02 (HACCP Temperatures), at the Giblet/Neck chiller in 1st Processing, I observed the following 04C04 regulatory noncompliance: I observed five chicken necks, with heads attached exit the neck chiller and fell into a combo box of necks at the neck chiller exit which indicated that the neck processing system was out of control. Additionally, I observed three chicken wings portions exit the neck chiller fall into the same combo box of chicken necks. Also, I observed black UFM (unidentified foreign material) on several chicken necks being rotated inside the North neck chiller which indicated that the neck chill system was out of control. These regulatory noncompliances represent insanitary handling of these necks which would lead to the contamination and/or adulteration of product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements 9 CFR 381.65(a) and 9 CFR 416.4(d). In addition, the establishment's Procedure for Neck Processing, section 1 &amp; 5, which states, (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) failed. Regulatory control action was taken as described in 9 CFR 500.2 by applying U.S. Retained tag # #B34644119 to the effected combo box and the North neck chill system. (b)(6) (b)(7)(C) 1st Processing Supervisor, was notified of the noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements could result in additional regulatory or administrative action as described in 9 CFR 500.4.</p>

0105-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	30-May-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1300, while performing ISP Code 03J01 (Food Safety) verification check on evisceration line (b)(4) lot #3, I observed the following regulatory noncompliance. Fecal material that was light brown and semi-solid in appearance and was approximately 9 mm x 5 mm in size was observed inside the carcass on the right flank above the ribs of the 8th of 10 carcasses that were randomly selected for the Food Safety verification. The presence of fecal material created an insanitary condition which would lead to the production of contaminated or/and adulterated product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements of 9 CFR 381.65(e) and 9 CFR 417.2(c) (4). In addition, the establishment's HACCP plan for CCP-1B-S which states, (b)(4) (b)(4) failed. A similar regulatory noncompliance involving fecal material was recorded on NR # 0067 -2011, which was dated 04/08/2011. Due to the recurrent nature of this deficiency, the further planned action, "The opener was adjusted. A retest was done. The retest passed." was ineffective. (b)(6) (b)(7)(C) 1st Processing Supervisor, was notified of this regulatory noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements could result in additional regulatory or administrative action as described in 9 CFR 500.4.</p>
0119-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	13-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1245, while performing ISP Code 03J01 (Food Safety) verification check on evisceration line (b)(4) lot #2, I observed the following regulatory noncompliance. Fecal material that was dark green and pasty in appearance and was approximately 4 mm x 4 mm in size was observed inside the carcass in the kidney area of the 4th of 10 carcasses that were randomly selected for the Food Safety verification. The presence of fecal material created an insanitary condition which would lead to the production of contaminated or/and adulterated product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements of 9 CFR 381.65(e) and 9 CFR 417.2(c) (4). In addition, the establishment's HACCP plan for CCP-1B-S which states, (b)(4) (b)(4) failed. A similar regulatory noncompliance involving fecal material was recorded on NR # 0105 -2011, which was dated 05/30/2011. Due to the recurrent nature of this deficiency, the further planned action, (b)(4) (b)(4) was ineffective. (b)(6) (b)(7)(C) 1st Processing Supervisor, was notified of this regulatory noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements could result in additional regulatory or administrative action as described in 9 CFR 500.4.</p>

0135-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	12-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 1341 hours, while performing ISP code 03J01 (Food Safety) verification check on evisceration line (b)(4) lot #1, I observed the following regulatory noncompliance. Fecal material was present on the fifth bird of a ten bird random test, performed at the OCP testing station on the evisceration line (b)(4) he fecal material was brown in color and pasty in consistency and was present on the outside of the carcasses. The dimension of the fecal material was approximately 1mm X 1mm in diameter and was located on the tail . This test was performed at the last testing point for U.S.D.A. inspection before product entered the chilling media on evisceration line (b)(4) The presence of fecal material on processed carcasses is an insanitary condition which can lead to the production of adulterated and/or contaminated product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements of 9 CFR 381.65(e) and CFR 417.2(c) (4). This is also a violation of the establishments HACCP Plan, CCP (b)(4) which states, (b)(4) (b)(4) failed. This noncompliance is a repetitive deficiency with similar root cause as documented on NR #133-2011-16884, dated 07-07-11. The establishment's further planned action "Maintenance was called to make an adjustment to the eviscerator. A 30 bird test was performed: None were affected." was ineffective or was not implemented. (b)(6) (b)(7)(C) Evisceration Supervisor was notified of the noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements can lead to enforcement action described in 9 CFR part 500.4.
0142-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	15-Jul-11	1	04C04	381.65(a)	At approximately 1022, while performing ISP code 01C02 (Operational Sanitation), at the chicken Giblet/Neck chiller in 1st Processing, I observed the following 04C04 (Finish Product Standards) regulatory noncompliances. I observed a section of intestine wrapped around the rotating paddles in the neck chiller. The intestine was approximately 1 1/2 feet in length, and contained fecal material. Additionally, numerous other pieces digestive tract materials, such as chicken crops and esophagus were also observed in the neck chiller. In addition, two chicken heads were observed in a combo box of chicken necks in the process of being filled at the exit end of the neck chiller. The above described noncompliances are indicators that the neck processing system could be out of control. These regulatory noncompliances would potentially allow for the cross contamination of necks by digestive contents material such as ingesta and/or feces. These regulatory noncompliances represent insanitary handling of necks which would lead to the contamination and/or adulteration of product. These regulatory noncompliances resulted in the establishment's failure to meet the regulatory requirements 9CFR 416.1, 9 CFR 381.65(a) and 9 CFR 416.4(d). Regulatory control action was taken as described in 9 CFR 500.2 by applying U.S. Rejected tag # B34612417 was applied to the neck chiller system. After sanitary conditions had been restored to the neck chiller it was released back to production. The issue with process control in 1st Processing was discussed with plant management during the weekly meeting held on 07-14-2011. (b)(6) (b)(7)(C) 1st Processing Superintendent, was notified of the noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements could result in additional regulatory or administrative action as described in 9 CFR 500.4.

0156-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	22-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 0803, while performing ISP Code 03J01 (Food Safety) verification check on evisceration line (b)(4) lot #4, I observed the following regulatory noncompliance. Fecal material that was dark green and pasty in appearance and was approximately 4 mm x 4 mm in size was observed inside the carcass in the kidney area of the 6th of 10 carcasses that were randomly selected for the Food Safety verification. The presence of fecal material created an insanitary condition which would lead to the production of contaminated or/and adulterated product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements of 9 CFR 381.65(e) and 9 CFR 417.2(c) (4). In addition, the establishment's HACCP plan for CCP (b)(4) which states (b)(4) (b)(4) failed. A similar regulatory noncompliance involving fecal material was recorded on NR # 0135 -2011, which was dated 07/12/2011. Due to the recurrent nature of this deficiency, the further planned action, "The opener was adjusted. A retest was done. The retest passed." was ineffective. (b)(6) (b)(7)(C) (b)(6) (b)(7) 1st Processing Superintendent, was notified of this regulatory noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements could result in additional regulatory or administrative action as described in 9 CFR 500.4.
0160-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	26-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 1239, while performing ISP Code 03J01 (Food Safety) verification check on evisceration line (b)(4) lot #4, I observed the following regulatory noncompliance. Fecal material that was dark green and pasty in appearance and was approximately 3 mm x 4 mm in size was observed inside the carcass in the kidney area of the 8th of 10 carcasses that were randomly selected for the Food Safety verification. The presence of fecal material created an insanitary condition which would lead to the production of contaminated or/and adulterated product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements of 9 CFR 381.65(e) and 9 CFR 417.2(c) (4). In addition, the establishment's HACCP plan for CCP (b)(4) which states (b)(4) (b)(4) failed. A similar regulatory noncompliance involving fecal material was recorded on NR # 0156 -2011, which was dated 07/22/2011. Due to the recurrent nature of this deficiency, the further planned action, "The maintenance was informed to make adjustments to the Ventor, also line adjustment was made to slow down process." was ineffective. (b)(6) (b)(7)(C) 1st Processing Superintendent, was notified of this regulatory noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements could result in additional regulatory or administrative action as described in 9 CFR 500.4.



0171-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	11-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 0732 hours, while performing ISP code 03J01 (Food Safety) verification check on evisceration line (b)(4) lot #3, I observed the following regulatory noncompliance. Fecal material was present on the first bird of a ten bird random test, performed at the OCP testing station on the evisceration line (b)(4). The fecal material was yellow-green in color and pasty in consistency and was present on the inside of the carcasses. The dimension of the fecal material was approximately 4mm X 2mm in size and was located in the kidney area. This test was performed at the last testing point for U.S.D.A. inspection before product entered the chilling media on evisceration line (b)(4). The presence of fecal material on processed carcasses is an insanitary condition which can lead to the production of adulterated and/or contaminated product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements of 9 CFR 381.65(e) and CFR 417.2(c) (4). This is also a violation of the establishments HACCP Plan, CCP (b)(4) which states, (b)(4) (b)(4) failed. This noncompliance is a repetitive deficiency with similar root cause as documented on NR #167-2011-16884, dated 07-31-11. The establishment's further planned action "Maintenance was called to make an adjustment to the IOBW. A 30 bird test was performed: None were affected." was ineffective or was not implemented (b)(6) (b)(7)(C). Evisceration Supervisor was notified of the noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements can lead to enforcement action described in 9 CFR part 500.4.
0172-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	15-Aug-11	1	04C04	381.65(a)	At approximately 0957, while performing ISP code 04C04 (Finish Product Standards), at the chicken Giblet/Neck chiller in 1st Processing, I observed the following regulatory noncompliances. I observed two section of intestine wrapped around the rotating paddles in the neck chiller. Each section of intestine was approximately 15 inches in length, and contained fecal material. Additionally, numerous other pieces digestive tract materials, such as chicken crops and esophagus were also observed in the neck chiller. The above described noncompliances are indicators that the neck processing system could be out of control. These regulatory noncompliances would potentially allow for the cross contamination of necks by digestive contents material such as ingesta and/or feces. These regulatory noncompliances represent insanitary handling of necks which would lead to the contamination and/or adulteration of product. These regulatory noncompliances resulted in the establishment's failure to meet the regulatory requirements 9CFR 416.1, 9 CFR 381.65(a) and 9 CFR 416.4(d). Regulatory control action was taken as described in 9 CFR 500.2 by applying U.S. Rejected tag # B34612426 was applied to the neck chiller system and U.S. Retained tag # B34612429 was applied to the combo box of necks being produced at the times this noncompliance was observed. After sanitary conditions had been restored to the neck chiller it was released back to production. A similar regulatory noncompliance was documented on NR # 142 dated 07-15-11 with the same root cause. The further planned actions proposed by management included, "The back up Venter will be instructed and held accountable on getting making sure any heads that enter into the process be cut off at the vector's station. Also training will be done with Venter and viscera inspector to pull off intestine before it gets to the neck hopper." failed. Due to the repetitive nature of this regulatory noncompliance, it is reasonable to conclude that the preventive measures proposed by the establishment in response to these noncompliances were ineffective at preventing the recurrence. The issue with process control in 1st Processing was discussed with plant management during the weekly meeting held on 07-21-2011. (b)(6) (b)(7)(C) 1st Processing Superintendent, was notified of the noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements could result in additional regulatory or administrative action as described in 9 CFR 500.4.

0184-2011-18795	4489	00517 P	Marshall Durbin Poultry Co.	MS	30-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 1306 hours, while performing ISP code 03J01 (Food Safety) verification check on evisceration line (b)(4) lot #5, I observed the following regulatory noncompliance. Fecal material was present on the first bird of a ten bird random test, performed at the OCP testing station on the evisceration line (b)(4). The fecal material was brown-green in color and pasty in consistency and was present on the inside of the carcasses. The dimension of the fecal material was approximately 4mm X 2mm in size and was located in the kidney area. This test was performed at the last testing point for U.S.D.A. inspection before product entered the chilling media on evisceration line (b)(4). The presence of fecal material on processed carcasses is an insanitary condition which can lead to the production of adulterated and/or contaminated product. This regulatory noncompliance resulted in the establishment's failure to meet the regulatory requirements of 9 CFR 381.65(e) and CFR 417.2(c)(4). This is also a violation of the establishments HACCP Plan, CCP (b)(4) which states, (b)(4) (b)(4) failed. This noncompliance is a repetitive deficiency with similar root cause as documented on NR #177-2011-16884, dated 08-19-11. The establishment's further planned action "Maintenance was called to make an adjustment to the opener. A 30 bird test was performed: None were affected." was ineffective or was not implemented. (b)(6) (b)(7)(C) Evisceration Supervisor was notified of the noncompliance, and of the failure to meet regulatory requirements. Continued failure to meet these regulatory requirements can lead to enforcement action described in 9 CFR part 500.4.
0051-2011-18268	4506	00548 P	Cagle's Inc.	AL	1-Mar-11	1	03J01	381.65(e)	Lot # 2 (b)(4) - Line (b)(4) At approximately 0806 while performing a FS verification check, the second and fourth carcass of a randomly selected ten bird selection process was found to contain feces. The feces was brown and yellow in color. The feces was located in the keel and inside of the kidney area. The feces was pasty in consistency and measured approximately 3/8" and 1/2" in diameter. (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0048-2011 dated 02/28/11 for documentation of a similar deviation from a critical limit for zero tolerance for feces. This is a deviation from zero tolerance regulations 381.65(e). Continued failure to meet regulatory requirements could result in additional regulatory control action.

0053-2011-18268	4506	00548 P	Cagle's Inc.	AL	2-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	1029 - Line (b)(4) - Lot # 1 - (b)(4) While performing a scheduled Food Safety verification test the first bird of ten randomly sampled carcasses was found to contain feces. The feces was located in the interior back to the left of the tail and covered a total area of approximately 3/4" with thicker concentrations of the fecal material in spots contained inside this area measuring 3/16" and smaller and numbering more than five spots. The feces was brown in color and of a creamy, pasty consistency. (b)(6) (b)(7)(C) was notified of this deviation from the critical limit. Please refer to Noncompliance Record 51-2011 dated 03-01-2011 for documentation of a similar deviation from the critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.
0061-2011-18268	4506	00548 P	Cagle's Inc.	AL	9-Mar-11	1	03J01	381.65(e)	Lot #1 (b)(4) - Line (b) At approximately 0832 while performing a FS/OCP verification check, the fourth carcass selected ten bird selection process was found to contain feces. The feces was brown in color. The feces was located in the keel area. The feces was pasty in consistency and measured approximately 3/8" in diameter. (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0053-2011 dated 03/02/11 for documentation of a similar deviation from a critical limit for zero tolerance for feces. This is a deviation from zero tolerance regulations 381.65(e). Continued failure to meet regulatory requirements could result in additional regulatory control action.

0062-2011-18268	4506	00548 P	Cagle's Inc.	AL	9-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	1310 - Line <sup>(b)(4)</sup> Lot # 2 - <b>(b)(4)</b> While performing a scheduled Food Safety verification test the fifth bird of ten randomly sampled carcasses was found to contain feces. The feces was located in the interior back in three spots on an area which had been mutilated by the machinery. The spots measured 3/16", and two spots measuring 1/8" in diameter. The feces was green in color and of a thick, pasty consistency. <b>(b)(6) (b)(7)(C)</b> was notified of this deviation from the critical limit. Please refer to Noncompliance Record 61-2011 from this same date for documentation of a similar deviation from the critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.
0069-2011-18268	4506	00548 P	Cagle's Inc.	AL	16-Mar-11	1	03J01	381.65(e)	Lot #1 <b>(b)(4)</b> - Line <sup>(b)(4)</sup> At approximately 0713 while performing a FS verification check, the first carcass selected from a ten bird selection process was found to contain feces. The feces was light brown in color. The feces was located in the kidney area. The feces was pasty in consistency and measured approximately 3/8" in diameter. <b>(b)(6) (b)(7)(C)</b> was notified of the deviation. Please refer to non-compliance NR 0064-2011 dated 03/09/11 for documentation of a similar deviation from a critical limit for zero tolerance, regulation 9CFR381.65(e) for feces. Continued failure to meet regulatory requirements could result in additional regulatory control action.

0078-2011-18268	4506	00548 P	Cagle's Inc.	AL	21-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	0835 - Line (b)(4) - Lot # 1 - (b)(4) While performing a scheduled Food Safety verification test the fourth bird of ten randomly sampled carcasses was found to contain feces. The bird had been mutilated by the machinery in the interior back at the tail, with the feces located in this mutilated area and on the exterior back. The feces was brown in color, smooth in consistency , and measured 1/4" in diameter (interior), and 1/8" in diameter (exterior) (b)(6) (b)(7)(C) was notified of this deviation from the critical limit. Please refer to Noncompliance Record 77-2011 dated 03-18-2011 for documentation of a similar deviation from the critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.
0079-2011-18268	4506	00548 P	Cagle's Inc.	AL	22-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	1354 - Line (b)(4) - Lot # 3 - (b)(4) While performing a scheduled Food Safety verification test the ninth bird of ten randomly sampled carcasses was found to contain feces. The feces was located in the interior back in an area which had been mutilated by the machinery. The feces was green in color, smooth in consistency , and measured 5/16" in diameter. (b)(6) (b)(7)(C) was notified of this deviation from the critical limit. Please refer to Noncompliance Record 78-2011 dated 03-21-2011 for documentation of a similar deviation from the critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined by FSIS Directive 5000.1.

0088-2011-18268	4506	00548 P	Cagle's Inc.	AL	31-Mar-11	1	03J01	381.65(e)	<p>Lot #1 (b)(4) - Line (b)(4) At approximately 0808 hour while performing a FS/OCV verification check, the second carcass selected from a ten bird selection process was found to contain feces. The feces was light brown in color. The feces was located in the kidney area. The feces was pasty in consistency and measured approximately 3/8" in diameter. (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0081-2011 dated 03/23/11 for documentation of a similar deviation from a critical limit for zero tolerance, regulation 9CFR381.65(e) for feces. Continued failure to meet regulatory requirements could result in additional regulatory control action.</p>
0089-2011-18268	4506	00548 P	Cagle's Inc.	AL	1-Apr-11	1	03J01	381.65(e), 417.2(c)(4)	<p>0641 - Line (b)(4) - Lot # 1 - (b)(4) While performing a scheduled Food Safety verification the tenth bird of ten randomly sampled carcasses was found to contain feces. The bird had been mutilated by the machinery and the feces was located in the mutilated area in three spots. One spot located in the right kidney crypt measured 3/16" in diameter, with the other two spots in the mutilated area of the back measuring 1/8" in diameter each. The feces was tan in color and of a smooth consistency. (b)(6) (b)(7)(C) was notified of this deviation from the critical limit. Please refer to Noncompliance Record 88-2011 dated 03-31-2011 for documentation of a similar deviation from this critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.</p>

0103-2011-18268	4506	00548 P	Cagle's Inc.	AL	19-Apr-11	1	03J01	381.65(e)	<p>Lot #1 (b)(4) - Line (b) At approximately 1320 hour while performing a FS/OCP verification check, the second carcass selected from a ten bird selection process was found to contain feces. The feces was medium brown in color. The feces was located on the left flap area. The feces was pasty in consistency and measured approximately 3/8" in diameter. (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0100-2011 dated 04/12/11 for documentation of a similar deviation from a critical limit for zero tolerance, regulation 9CFR381.65(e) for feces. Continued failure to meet regulatory requirements could result in additional regulatory control action.</p>
0108-2011-18268	4506	00548 P	Cagle's Inc.	AL	21-Apr-11	1	03J01	381.65(e)	<p>Lot 2 (b)(4) - Line (b) At approximately 1042 hour while performing a FS verification check, the eighth carcass selected from a ten bird selection process was found to contain feces. The feces was medium brown in color. The feces was located in the right kidney area. The feces was pasty in consistency and measured approximately 3/8" in diameter. (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0103-2011 dated 04/19/11 for documentation of a similar deviation from a critical limit for zero tolerance, regulation 9CFR381.65(e) for feces. Continued failure to meet regulatory requirements could result in additional regulatory control action.</p>

0119-2011-18268	4506	00548 P	Cagle's Inc.	AL	2-May-11	1	03J01	381.65(e)	<p>Lot #1 (b)(4) - Line (b)(4) At approximately 0610 hour while performing a FS verification check, the tenth carcass selected from a ten bird selection process was found to contain feces. The feces was medium brown in color. The feces was located in the right kidney area. The feces was pasty in consistency and measured approximately 3/8" in diameter. (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0114-2011 dated 04/26/11 for documentation of a similar deviation from a critical from a critical limit for zero tolerance, regulation 9CFR381.65(e) for feces. Continued failure to meet regulatory requirements could result in additional regulatory control action.</p>
0134-2011-18268	4506	00548 P	Cagle's Inc.	AL	14-May-11	1	04C04	381.76(a)	<p>At approximately 0755, there were birds on evisceration line (b)(4) with excessive amount of feathers. Two trimmers at the mirror location and a third person were holding birds because there wasn't a place to hang them back. Food Safety Supervisor (b)(6) (b)(7)(C) and Supervisor (b)(6) (b)(7)(C) were both present and working with birds but there were too many and the line speed was to fast for the condition of the birds. Birds with excessive feathers were proceeding down the line. I took regulatory control action and stopped the line. When the process was back in control, I released the line. Today's noncompliance failed to meet the requirements of 381.76(a).</p>



0138-2011-18268	4506	00548 P	Cagle's Inc.	AL	19-May-11	1	03J01	381.65(e), 417.2(c)(4)	0805 - Line (b)(4) - Lot # 1 - (b)(4) While performing a scheduled Food Safety - OCP verification test the ninth bird of ten randomly sampled carcasses was found to contain feces in the interior back. The bird had been mutilated by the machinery in the interior back above the kidneys and the feces was located in this mutilated area. The feces was dark green in color, thick and smooth in consistency, and was in a streak measuring 1/8"W x 3/4"L. (b)(6) (b)(7)(C) was notified of this deviation from the critical limit of zero tolerance for feces. Please refer to Noncompliance Record 136-2011 dated 05-17-2011 for documentation of a similar deviation from the critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.
0139-2011-18268	4506	00548 P	Cagle's Inc.	AL	21-May-11	1	03J01	381.65(e), 417.2(c)(4)	0640-Line (b)(4) (b)(4) While performing a scheduled Food Safety verification test the third bird of a randomly sampled carcasses was found to contain feces in the kidney area. The feces was dark green in color and pasty in consistency, and was approximately 3/16" in diameter. (b)(6) (b)(7)(C) was notified of this deviation from a critical limit of zero tolerance for feces. Please refer to Noncompliance Record # 138 dated 05/19/2011 for documentation of a similar deviation from a critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2 (2)(4); 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.

0143-2011-18268	4506	00548 P	Cagle's Inc.	AL	24-May-11	1	03J01	381.65(e), 417.2(c)(4)	<p>Lot # 1 (b)(4) While performing a scheduled Food Safety test on Line (b)(4) the 7th carcass out of a 10 bird randomly sampled had feces on the hock. The feces was green in color and smooth and pasty in consistency. The fecal measured approximately 3/4" long and 3/16" wide. (b)(6) (b)(7)(C) was notified of third deviation from a critical limit of zero tolerance for feces. Please refer to Noncompliance Record # 139 Dated 05/21/2011 for documentation of a similar limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2 (c)(4); 381.65(e). Continued failures to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.</p>
0145-2011-18268	4506	00548 P	Cagle's Inc.	AL	25-May-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1210, I performed the 03J01 procedure on a vat of reprocessed birds. The fourth bird I checked had a 5/16" spot of dark green fecal material on the inside near the tail. The vat had been checked and released by Food Safety. I notified Food Safety Supervisor (b)(6) (b)(7)(C) for corrective action. Today's noncompliance failed to meet the requirements of 9 CFR 417.2(c)(4) and 381.65(e). NR 136-2011 dated 05/17/2011, was for the same noncompliance. The preventive measure: "Employees were correlated with on proper washing procedures and job performance. The employees were given written warnings" was ineffective in preventing today's noncompliance.</p>

0148-2011-18268	4506	00548 P	Cagle's Inc.	AL	31-May-11	1	03J01	381.65(e), 417.2(c)(4)	Lot #3 (b)(4) 155 am While performing a scheduled Food Safety test on Line (b)(4) the 9th carcass out of a 10 bird randomly sampled contained feces in the tail area. The feces was brownish green in color pasty and watery in consistency. The fecal measured approximately 5/8" in diameter. (b)(6) (b)(7)(C) was notified of the deviation from a critical limit of zero tolerance for feces. Please refer to Noncompliance Record #145-11 Dated 05/25/11 for documentation of a similar limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c);381.65(e). Continued failures to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.
0153-2011-18268	4506	00548 P	Cagle's Inc.	AL	2-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	At 0815 hrs while performing a food safety verification test on line (b)(4) the fifth bird out of a 10 bird sample had feces the feces was located in the kidney was approximately 3/16 in diameter. (b)(6) (b)(7)(C) was notified of this deviation. Please refer to Non-Compliance record 150-2011 dated 5/31/2011 for documentation of similar deviation from critical limit of zero tolerance for feces.

0157-2011-18268	4506	00548 P	Cagle's Inc.	AL	7-Jun-11	1	03J01	381.65(e)	(b)(4) Line (b)(4) At approximately 1352 while performing my duties in Carcass Inspection mode (CI) on line (b)(4) observed feces inside a passing reprocessed bird. The feces was light brown in color. The feces was located in the keel area. The feces was pasty in consistency and measured approximately 3/8" in diameter. (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0156-2011 dated 06/06/11 for documentation of a similar deviation from a critical limit for zero tolerance, regulation 9CFR381.65(e) for feces. Continued failure to meet regulatory requirements could result in additional regulatory control action.
0158-2011-18268	4506	00548 P	Cagle's Inc.	AL	8-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	0752 - Line (b)(4) - Lot # 2 - (b)(6) (b)(7)(C) While performing a scheduled Food Safety verification test the second bird of ten randomly sampled carcasses was found to contain feces. The bird had been trimmed to remove the tail and the feces was located in the trimmed area of the tail. The feces was green in color, thick and pasty in consistency, and measured 1/16" and 1/8" in diameter in two spots. (b)(6) (b)(7)(C) was notified of this deviation from the critical limit. Please refer to Noncompliance Record 155-2011 dated 06-03-2011 for documentation of a similar deviation from the critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.

0159-2011-18268	4506	00548 P	Cagle's Inc.	AL	8-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	0916 - Reprocessing While performing a verification test of ten carcasses from Vat # 4 at CCP (b)(4) the eighth bird of ten randomly selected carcasses was found to contain feces. The feces was located in the interior of the left breast and covered an area 1/4" in diameter. The feces was green in color and of a smooth consistency. (b)(6) (b)(7)(C) was notified of this deviation from the critical limit of zero tolerance for feces. Please refer to Noncompliance Record 157-2011 dated 06-07-2011 for documentation of a similar occurrence of feces at CCP (b)(4). Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control action as outlined in FSIS Directive 5000.1.
0177-2011-18268	4506	00548 P	Cagle's Inc.	AL	15-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	1347 - Line (b)(4) - Lot # 2 - (b)(4) While performing a scheduled Food Safety verification test two birds of a ten bird random sample were found to contain feces. The first bird of the sample contained feces in the interior back on the right side of the kidney, as well as multiple spots of urate material in both the left interior back and in the neck cavity. The feces was dark green in color, thick and pasty in consistency, and measured 1/8" in diameter. The urate material was white color and crystalline in appearance and numbered more than five spots in both the neck cavity and interior cavity, measuring 1/16" and smaller in diameter. The fifth bird of this same set contained feces in the interior keel area. The feces was tan in color, smooth in consistency, and measured 1/16" in diameter. (b)(6) (b)(7)(C) was notified of this deviation from the critical limit of zero tolerance for feces. Please refer to Noncompliance Record 173-2011 dated 06-14-2011 for documentation of a similar deviation from the critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.

0178-2011-18268	4506	00548 P	Cagle's Inc.	AL	16-Jun-11	1	03J01	417.2(c)(4), 417.6	At approximately 10:10 while performing a food safety test line <sup>(b)(6)</sup> the third bird out of a 10 bird sample contained feces. The feces was brown in color creamy in consistency and located on the tail area and measured approximately 5/16 in diameter. <sup>(b)(6)</sup> <sup>(b)(7)(C)</sup> was notified of this deviation. Lot 1 <sup>(b)(4)</sup> Please refer to non-compliance record 177-2011 dated 6/15/2011 for documentation of similar deviation from critical limit.
0184-2011-18268	4506	00548 P	Cagle's Inc.	AL	17-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	I performed a ten bird Food Safety verification check on evisceration line <sup>(b)(6)</sup> at 0936. The third bird I checked had two spots of brown fecal material on the inside breast area. The two spots of feces measured approximately 1/4" each. I notified Food Safety Supervisor <sup>(b)(6)</sup> <sup>(b)(7)(C)</sup> of the deviation. Today's noncompliance failed to meet the requirement's of 9 CFR 417.2(c)(4) and 381.65(e). Please refer to NR 180-2011 dated 06/16/2011 for documentation of a similar noncompliance.

0198-2011-18268	4506	00548 P	Cagle's Inc.	AL	29-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	1235 - Line (b)(4) - Lot # 1 - (b)(4) While performing a scheduled Food Safety verification test, the third bird of ten randomly sampled carcasses was found to contain feces. The feces was located in a miscut vent area. The feces was dark green in color, thick and pasty in consistency and measured 1/4" in diameter. (b)(6) (b)(7)(C) was notified of this deviation from the critical limit. Please refer to Noncompliance Record 196-2011 dated 06/28/2011 for documentation of a similar deviation from the critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.
0204-2011-18268	4506	00548 P	Cagle's Inc.	AL	5-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At 0708 while performing a scheduled Food Safety verification test, on Line (b)(4) Lot #1 (b)(6) (b)(7)(C) the first bird of a randomly sampled carcasses was found to contain feces. The feces was located on the left fat flap. The feces was dark green in color, thick and pasty in consistency and measured approximately 1/4" in diameter. (b)(6) (b)(7)(C) was notified of this deviation from a critical limit. Please refer to noncompliance record # 202 dated 07/01/2011 for documentation of a similar deviation from the critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9CFR 417.2(c)(4) and 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.

0205-2011-18268	4506	00548 P	Cagle's Inc.	AL	5-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	0807 - Line (b)(4) Lot # 1 - (b)(6) (b)(7)(C) While performing a scheduled Food Safety verification test the seventh bird of ten randomly samples carcasses was found to contain feces. The bird had a two inch piece of terminal intestine and the bursa of fabricius and cloaca attached, with feces both oozing from the intestine and located in the interior breast cavity of the bird. The feces was brown in color, thick and smooth in consistency and measured 1/4" in diameter in the breast cavity. (b)(6) (b)(7)(C) was notified of this deviation from the critical limit of zero tolerance for feces. Please refer to Noncompliance Record 204-2011 from earlier this same date for documentation of a similar deviation from this critical limit. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.
0207-2011-18268	4506	00548 P	Cagle's Inc.	AL	6-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At 0620 while performing a scheduled Food Safety test on Line (b)(4) Lot #1 (b)(6) (b)(7)(C) the 7th bird of a randomly sampled carcasses was found to contain feces. The feces was located in the miss cut vent area. The feces was green in color, pasty in consistency and measured approximately 1/8" in diameter. (b)(6) (b)(7)(C) was notified of this deviation from a critical limit. Please refer to Noncompliance Record #206 dated 07/05/2011 for documentation of a similar deviation from a critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9CFR 417.2(c) and 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional or regulatory control actions as outlined in FSIS Directive 5000.1.



0209-2011-18268	4506	00548 P	Cagle's Inc.	AL	7-Jul-11	1	03J01	381.65(e)	<p>Lot #1 (b)(4) - Line (b)(4) At approximately 0834 while performing a FS verification check, the eight carcass of a randomly selected ten bird selection process was found to contain feces. The feces was yellowish brown in color. The feces was located in the right flap area. The feces was pasty in consistency and measured approximately 3/8" in diameter. (b)(6) (b)(7)(C) (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0207-2011 dated 07/06/11 for documentation of a similar deviation from a critical limit for zero tolerance for feces. This is a deviation from zero tolerance regulations 9CFR381.65(e). Continued failure to meet regulatory requirements could result in additional regulatory control action.</p>
0210-2011-18268	4506	00548 P	Cagle's Inc.	AL	7-Jul-11	1	03J01	381.65(e)	<p>Lot #2 (b)(4) #1 - Line (b)(4) At approximately 0933 while performing a FS/OCP verification check, the tenth carcass of a randomly selected ten bird selection process was found to contain feces. The feces was yellowish brown in color. The feces was located in the left kidney area. The feces was pasty in consistency and measured approximately 1/2" in diameter. (b)(6) (b)(7)(C) (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0209-2011 dated 07/07/11 for documentation of a similar deviation from a critical limit for zero tolerance for feces. This is a deviation from zero tolerance regulations 9CFR381.65(e). Continued failure to meet regulatory requirements could result in additional regulatory control action.</p>

0211-2011-18268	4506	00548 P	Cagle's Inc.	AL	7-Jul-11	1	03J01	381.65(e)	At approximately 10:33 hours while performing a food safety verification check on line (b)(6) the second carcass of a randomly selected ten bird sample. Was found to contain feces the feces was yellowish brown in color. the feces was located on the tail area was approximately 5/16 of an inch in diameter the feces was pasty in consistency. (b)(6) (b)(7)(C) was notified of this deviation. Please refer to NR-0210-2011 dated 7/07/11 for documentation of similar deviation from a critical limit for zero tolerance for feces. This is a deviation from zero tolerance regulation 9CFR381.65(e).Continued failure to meet regulatory requirements could result in additional regulatory control actions.
0217-2011-18268	4506	00548 P	Cagle's Inc.	AL	12-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At 0908, I performed a Food Safety verification test on evisceration line (b)(4) The sixth bird I checked had brown fecal material in the tail area. The feces covered an area approximately 3/8" in diameter. I notified Food Safety Supervisor (b)(6) (b)(7)(C) Today's noncompliance failed to meet the requirement's of 9 CFR 417.2(c)(4) and 381.65(e). Please refer to NR 215-2011 (07/09/2011) for documentation of a similar noncompliance.

0226-2011-18268	4506	00548 P	Cagle's Inc.	AL	15-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 10:17 hours while performing a food safety test on line (b) I observed feces the third bird of a ten bird randomly selected sample contained feces. The feces was green in color pasty in consistency and measured approximately 5/16 inches in diameter was located on the right hock area. (b)(6) (b)(7)(C) was notified of this deviation from a critical limit. Please refer to noncompliance 0225-7/14/2011 for documentation of similar deviation from a critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9CFR417.2(c)(4) and 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional or regulatory control actions as outlined in FSIS Directive 5000.1
0227-2011-18268	4506	00548 P	Cagle's Inc.	AL	15-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	1037 - Line (b)(4) Lot # 2 - (b)(4) While performing a scheduled OCP/ Food Safety verification test the ninth bird of ten randomly sampled carcasses was found to contain feces. The bird had been mutilated by the machinery and the feces was located in the mutilated areas in the interior back above the kidneys. The feces was greenish-tan in color, smooth and creamy in consistency and measured 3/16" and smaller in diameter in three spots. There was also a small amount of urate material present in the fecal material. (b)(6) (b)(7)(C) was notified of this deviation from the critical limit. Please refer to Noncompliance Record 226-2011 from earlier in this same shift for documentation of a similar deviation from the critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9 CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control action as outlined in FSIS Directive 5000.1.

0231-2011-18268	4506	00548 P	Cagle's Inc.	AL	19-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	I performed the 03J01 procedure on a vat of reprocessed birds at 1043. The sixth bird I checked had dark green fecal material on the inside near the tail area. The feces measured approximately 3/16" in diameter. I notified Food Safety Supervisor (b)(6) (b)(7)(C) of the deviation. Today's noncompliance failed to meet the requirement's of 9 CFR 417.2(c)(4) and 381.65(e). Please refer to NR 224-2011 dated 07/14/2011 for documentation of a similar noncompliance.
0236-2011-18268	4506	00548 P	Cagle's Inc.	AL	22-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 1140 while performing a food safety and, Other Consumer Protection test on Line (b)(4) Lot #3 (b)(4) the seventh bird of a randomly sampled carcasses was found to contain feces. The feces was located in the tail area, the tail had been removed. The feces was dark green in color and pasty in consistency and measured 1/8" in diameter. (b)(6) (b)(7)(C) was notified of this deviation from a critical limit. Please refer to Noncompliance Record #233 dated 07/19/2011 for documentation of a similar deviation from a critical limit of zero tolerance for feces. Today's noncompliance fails to meet the requirements of 9CFR 417.2(c)(4) and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional or regulatory control actions as outlined in FSIS Directive 5000.1.

0243-2011-18268	4506	00548 P	Cagle's Inc.	AL	27-Jul-11	1	03J01	381.65(e)	<p>Lot #2 (b)(4) - Line (b) At approximately 1205 while performing a FS/OCP verification check, the seventh carcass of a randomly selected ten bird selection process was found to contain feces. The feces was yellowish brown in color. The feces was located in the tail area. The feces was pasty in consistency and measured approximately 1/4" in diameter. (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0237-2011 dated 07/22/11 for documentation of a similar deviation from a critical limit for zero tolerance for feces. This is a deviation from zero tolerance regulations 9CFR381.65(e). Continued failure to meet regulatory requirements could result in additional regulatory control action.</p>
0252-2011-18268	4506	00548 P	Cagle's Inc.	AL	3-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 07:02 while performing OCP on Line (b)(4) I observed fecal material inside one of the ten randomly selected birds chosen for OCP. Fecal was brownish in color and located below the kidney area inside the bird. The result of today's task reflects failure of this establishment to meet the regulatory requirements of 9CFR Part 381.65(e) which states in part, "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank," and 9CFR Part 417.2(c)(4), which states, "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." I notified plant management to take immediate corrective action and to implement preventive measures. The repetitive nature of this failure could result in further regulatory and /or administrative action. Past Similar NRs - Previous Ineffective Plant Actions: same deficiency NR: 247-2011 dated 7/30/2011</p>

0254-2011-18268	4506	00548 P	Cagle's Inc.	AL	5-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At Approximately 09:20 while performing a food safety test on line (b)(4) the # bird of a 10 bird randomly selected sample contained feces. The feces was dark brown in color and pasty consistency and measured approximately 1/8 of an inch in diameter. Feces was located on the left interior rib cage (b)(6) (b)(7)(C) was notified of the deviation. Today's noncompliance did not meet 9CFR 381.65(e) and 417.2(c)(4). Failure of the establishment to meet regulatory requirements could lead to additional enforcement action under directive 5000.1. Refer to noncompliance record #253 dated 08/03/2011.</p>
0255-2011-18268	4506	00548 P	Cagle's Inc.	AL	5-Aug-11	1	03J01	381.65(e)	<p>Lot #2 (b)(4) Line (b)(4) At approximately 1022 while performing a FS verification check, the first carcass of a randomly selected ten bird selection process was found to contain feces. The feces was yellowish brown in color. The feces was located in the tail area. The feces was pasty in consistency and measured approximately 1/4" in diameter. (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0254-2011 dated 08/05/11 for documentation of a similar deviation from a critical limit for zero tolerance for feces. This is a deviation from zero tolerance regulations 9CFR381.65(e). Continued failure to meet regulatory requirements could result in additional regulatory control action.</p>

0265-2011-18268	4506	00548 P	Cagle's Inc.	AL	12-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 09:10 while performing Food Safety check on Line (b)(4) I observed fecal material inside tail area and on left flap on fat of one of the ten randomly selected birds chosen for FSI notified plant management to take immediate corrective action and to implement preventive measures. The result of today's task reflects failure of this establishment to meet the regulatory requirements of 9CFR Part 381.65(e) which states in part, " Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank," and 9CFR Part 417.2(c)(4), which states, " List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits."The results of today's tasks indicate previously stated preventive measures were inadequate or not implemented. Past Similar NRs - Previous Ineffective Plant Actions: same deficiency NR: 260-2011 dated 8/9/2011
0268-2011-18268	4506	00548 P	Cagle's Inc.	AL	13-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	0719 - Line (b)(4) Lot # 1 - (b)(4) While performing a scheduled Food Safety/OCP verification test the fourth bird of ten randomly sampled carcasses was found to contain feces in the interior left back area. The feces was brownish-green in color, smooth and creamy in consistency ,and measured 3/16" in diameter. A 1/16" in diameter spot of urate material was also present in this area along with the feces. (b)(6) (b)(7)(C) was notified of this deviation from the critical limit. Please refer to Noncompliance Record 266-2011 dated 08-12-2011 for documentation of a similar deviation from zero tolerance standard. Today's noncompliance fails to meet the requirement of 9 CFR 417.2(c)(4), and 9 CFR 381.65(e). Continued failure to meet the requirements of zero tolerance for feces could result in additional administrative or regulatory control actions as outlined in FSIS Directive 5000.1.

0270-2011-18268	4506	00548 P	Cagle's Inc.	AL	15-Aug-11	1	03J01	381.83	<p>At approximately 08:27 while in CI mode on line (b)(4) observed what looked like a Septox bird. The bird had a dehydrated look, dark meat, prominent keel., and emaciated. I rang the bell for a second opinion. (b)(6) (b)(7)(C) correlated with (b)(6) (b)(7)(C) and he agreed it was a Septox bird. The result of today's task reflects failure of this establishment to meet regulatory requirements and less than effective monitoring of CCP (b)(4) Please refer to 9CFR 381.83</p>
0273-2011-18268	4506	00548 P	Cagle's Inc.	AL	16-Aug-11	1	03J01	381.65(e)	<p>Lot #3 (b)(4) Line (b)(6) At approximately 1243 while performing a OCP/FS verification check, the tenth carcass of a randomly selected ten bird selection process was found to contain feces. The feces was yellowish brown in color. The feces was located in the tail area. The feces was pasty in consistency and measured approximately 1/4" in diameter. (b)(6) (b)(7)(C) was notified of the deviation. Please refer to non-compliance NR 0272-2011 dated 08/15/11 for documentation of a similar deviation from a critical limit for zero tolerance for feces. This is a deviation from zero tolerance regulations 9CFR381.65(e). Continued failure to meet regulatory requirements could result in additional control action.</p>



0279-2011-18268	4506	00548 P	Cagle's Inc.	AL	29-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 07:05 while performing FS on line (b)(4) I observed feces inside two of the ten birds randomly selected birds. One bird had greenish colored feces located in kidney area. The other bird had greenish colored feces located on the keel bone area of the bird. I notified plant management to take immediate corrective action and to implement preventive measures. Fecal contamination is a known vehicle for pathogen transmission. The result of today's task reflects failure of this establishment to meet the regulatory requirements of 9CFR Part 381.65(e) which states in part, "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank," and 9CFR Part 417.2(c)(4), which states, "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." 9CFR Part 416.1 states, "General rules. Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated." The results of today's tasks indicate previously stated preventive measures were inadequate or not implemented. Past Similar NRs - Previous Ineffective Plant Actions: same noncompliance NR: 277-2011 dated 8/24/2011
0105-2011-15121	4148	00584 P	Pilgrim's Pride Corporation	TX	4-Mar-11	1	04C04	381.91(b)	At 0838 hours, while inspecting carcasses in a washout barrel, lot number 14, started at 0755 hours, released by production and checked by plant QA and released to USDA at 0820 hours, the following conditions were observed: Four birds out of twenty were observed with feed and ingesta. Bird number one had feed on the neck area of the bird. The second bird had several pieces of ingesta on the underlying subcutaneous tissue along the dorsal midline. The third bird had several pieces of feed on the inside of the carcass near the tail. The fourth bird had ingesta in the neck area of the bird. Regulatory control was taken by notifying (b)(6) (b)(7)(C) Evisceration Foreman, who observed the birds with ingesta and the barrel was tagged with U. S. Retain Tag # B38485854. The birds were reconditioned and presented for USDA reinspection, and failed at 0924 hours. The birds were reconditioned and presented for USDA reinspection again, and passed at 1000 hours. This is noncompliance with 9 CFR 381.91(b). A similar noncompliance was documented on NR 0077-2011 dated 2/16/2011.

0106-2011-15121	4148	00584 P	Pilgrim's Pride Corporation	TX	4-Mar-11	1	03J01	417.2(c)(4)	<p>Today at 1229 hours while performing an Other Consumer Protection Test on line (b)(6) I observed bird four of a ten bird sample with visible fecal material on the inside of the bird on the breast area. The feces was light green in color, consisted of four smears which ranged in size from 1/2 in length for the first smear to 1/16 inch in diameter for the other three smears, and were creamy in consistency. I notified (b)(6) (b)(7)(C) Evisceration Supervisor, of the noncompliance. The proposed cause was "A bird was caught on the bird lifter causing the spoon to be forced inside the bird. The carcass was removed (maestro machine)." This fecal finding represents a failure to meet the requirements of 9 CFR 381.65(e), 9 CFR 417.2(c), and the establishment's HACCP Plan for Slaughter CCP (b)(6) which states on page 1, (b)(4)</p> <p>Proposed preventative measure was (b)(4)</p> <p>(b)(4) This check will be done twice for the remaining of this shift 3/4/2011. Each check will be documented on a scheduled task log starting 3/4/2011 ending 3/4/2011." Refer to NR # 0104-2011 dated 03/03/2011 for a similar noncompliance.</p>
0112-2011-15121	4148	00584 P	Pilgrim's Pride Corporation	TX	14-Mar-11	1	04C04	381.91(b)	<p>At 0806 hours, while inspecting carcasses in a washout barrel, lot number 3, started at 0630 hours, released by production and checked by plant QA and released to USDA at 0745 hours, the following conditions were observed: Two birds out of twenty were observed with feed and ingesta. Bird number three had three pieces of feed on the thigh of the bird. The second bird had two pieces of ingesta on the thigh of the bird. Regulatory control was taken by notifying (b)(6) (b)(7)(C) (b)(6) (b)(7)(C) visceration Foreman, who observed the birds with ingesta and the barrel was tagged with U. S. Retain Tag # B38485847. The birds were reconditioned and presented for USDA reinspection, and passed at 0859 hours. This is noncompliance with 9 CFR 381.91(b). A similar noncompliance was documented on NR 0105-2011 dated 3/4/2011.</p>

0113-2011-15121	4148	00584 P	Pilgrim's Pride Corporation	TX	16-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	<p>Today at 1115 hours while performing a Food Safety Test on line (b)(4) I observed one bird of a ten bird sample with visible fecal material on the outside of the bird on the thigh area. The feces was light green in color, was approximately 1/16 inch in diameter, and was creamy in consistency. I notified (b)(6) (b)(7)(C) Evisceration Supervisor, of the noncompliance. The proposed cause was "After reviewing the process found a viscera hanging on the guide bar on the (b)(4) machine." This fecal finding represents a failure to meet the requirements of 9 CFR 381.65(e), 9 CFR 417.2(c), and the establishment's HACCP Plan for Slaughter CCP (b)(4) which states on page 1, (b)(4) Proposed preventative measure was (b)(4)</p> <p>(b)(4) Maint. also added and unclogged sprayers inside of the final bird wash. This check will start 3.16.2011 ending 3.16.2011. all checks will be documented on a schedule task log." Refer to NR # 0109-2011 dated 03/09/2011 for a similar noncompliance. The preventative measure for this NR was as follows: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) Checks will be documented on a Schedule Task Log Sheet."</p>
0118-2011-19466	4148	00584 P	Pilgrim's Pride Corporation	TX	25-Mar-11	1	04C04	381.84	<p>At 0858 hours, while inspecting a barrel of reprocessed "Ready to Cook" (RTC) product, I randomly selected ten birds from Lot 10 which consisted of washout birds. I observed bird one out ten birds with air sac exudates and randomly selected another ten birds and observed bird five with air sac exudates. Air sac exudates was observed in both rib cages of both of the birds. Both birds affected were observed after QA passed this lot. I verbally notified and showed (b)(6) (b)(7)(C) Evisceration Foreman, of this noncompliance. I took regulatory control by placing US Retain Tag # B 38485370 on this lot. The plants Prerequisite Program for the Reprocessing Procedure; 000-A Page 2 of 7 Section (2) (ii) states; Carcasses will be vacuumed at the vacuum station-Exudates, lungs, kidneys, and affected tissue(s) will be removed dated 10/30/10. The establishment has failed to meet regulation 9 CFR 381.78 and 381.84 by removing all affected tissues and exudates. The barrel was reprocessed, re-inspected and released back to production at 0931hours. A similar noncompliance was documented on NR # 0078 dated 02/16/2011. Continued failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action as described in 500.4 of 9 CFR.</p>

0125-2011-19466	4148	00584 P	Pilgrim's Pride Corporation	TX	31-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1014 hours, while performing a scheduled FS (Food Safety) verification inspection test on evisceration line (b)(4), ten (10) carcasses to be inspected were randomly selected after the final bird washer and before the USDA carcass inspector. On carcass number three, visible feces was observed on the inside of the cavity of the bird. The feces was located on the left side of the bird on the kidney. The feces was dark green in color and pasty in consistency. The feces covered an area approximately 1/2" by 1/4". (b)(6) (b)(7)(C) HIMP Supervisor was notified and observed the feces in the bird. (b)(6) (b)(7)(C) initiated immediate corrective action as outlined in the plants HACCP plan. This fecal finding is an insanitary condition as feces is a source of biological hazards resulting in product contamination. This is a noncompliance with 9 CFR 417.2 (c)(4), 381.65(a) and with the plant's HACCP plan, CCP (b)(4) page 1 which states (b)(4). The cause was stated as, "After reviewing the process observed the smaller the bird is will cause the spoon on the (b)(4) to go inside to deep causing contamination to get inside the bird." The preventive measure stated was, (b)(4)</p> <p>(b)(4) (b)(4)</p> <p>A similar NR (123) dated 03/29/2011 was documented for feces on a bird during an OCP/FS test on line (b)(4). The preventive measure stated on this NR, "we will modify the sprayer (final bird washer). (b)(4) starting 03/31/2011 until 04/01/2011. All checks will be documented on a schedule task log." This stated preventive measure was either not implemented or was ineffective as implemented, as shown by this noncompliance which also involved employees. Continued failure to meet regulatory requirements can lead to enforcement actions as described in 9 CFR 500.4.</p>
0127-2011-19466	4148	00584 P	Pilgrim's Pride Corporation	TX	5-Apr-11	1	03J01	381.65(e), 417.2(c)(4)	<p>Today at 0929 hours feces was visually identified on line (b)(4) during a Food Safety Test. Ten carcasses were randomly selected from line (b)(4) and the sixth carcass inspected had olive-green feces covering an area approximately 1/2 inch in diameter inside the carcass near the sternum. (b)(6) (b)(7)(C) Evisceration Supervisor was notified of the noncompliance and failure to comply with 9 CFR 417.2(c) 4, 9 CFR 381.65(e) and Establishment P-584's HACCP Plan. Plant personnel determined the cause of the feces to be a small carcass that was hung on a spoon of the (b)(4) machine. The preventive measure proposed was that (b)(4)</p> <p>(b)(4)</p> <p>For a similar noncompliance please reference NR # 125-2011 dated 03-31-11.</p>

0032-2011-16571	4150	00635 P	Cargill Meat Solutions Corp.	TX	17-Mar-11	1	03J01	381.65(e), 417.2(c)	At approximately 0835 hours while performing an OCP carcass test at the designated verification inspection station, I observed the following HAACP deviation; bird number 7 of the randomly selected 10 bird group had fecal located on the narrow portion of the breast. The fecal material was greenish brown, with a pasty consistency and measured 1/8th inch by 1/4 inch. Regulatory control action was taken by stopping the line and notifying (b)(6) (b)(7)(C) Assistant Evisceration Supervisor of the noncompliance. The deviation is a failure to comply with 9 CFR 381.65(e),417.2(c)(4) and the establishment's criteria for CCP-(b)(4) that states (b)(4)
0054-2011-16571	4150	00635 P	Cargill Meat Solutions Corp.	TX	16-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	On 06/16/11 at approximately 0650 hours while performing carcass inspection at the carcass inspection station, I observed the following HACCP deviation: I observed fecal material on the right wing of a turkey carcass. The fecal material was greenish brown in color with a pasty consistency and measured approximately 1/8 inch by 1/8 inch. Regulatory control action was taken by stopping the evisceration line and notifying (b)(6) (b)(7)(C) Evisceration Supervisor, and (b)(6) (b)(7)(C), HACCP monitor, of the noncompliance. This deviation is a failure on the establishment to comply with 9 Code of Federal Regulation 381.65(e) and 417.2(c)(4). This noncompliance is a deviation of the establishment's critical limit for CCP (b)(4) which states (b)(4)

0069-2011-16571	4150	00635 P	Cargill Meat Solutions Corp.	TX	26-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	On 08/26/11 at approximately 0816 hours while performing carcass inspection at the CI station, I observed the following HACCP deviation: I observed fecal material on the inner right flank of a turkey carcass. The fecal material was olive green in color with a pasty consistency and measured approximately 1/8 inch in diameter. Regulatory control action was implemented as authorized by 9 Code of Federal Regulations 500.2(a)(2) by stopping the evisceration line. (b)(6) (b)(7)(C) (b)(6) (b)(7)(C) HACCP Monitor, was verbally notified and visually shown the noncompliance. This deviation is a failure of the establishment to comply with 9 Code of Federal Regulations 381.65(e) and 417.2(c)(4). This noncompliance is a deviation of the establishment's critical limit for CCP (b)(4) which states (b)(4)
0039-2011-19043	4567	01307 P	Marshall Durbin Company	AL	14-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 10:36, while on verification and performing an OCP procedure on line (b)(4) lot #5, I observed fecal material inside of bird #2 from a ten bird sample. It was brownish-yellow in color and measure approximately 11/4 inch x 1/4 inch. I stopped the line and notified (b)(6) (b)(7)(C) past similar NR#0031-2011 dated 02/23/2011 was maintenance lower bottom cam on vendor and would monitor machine for the remainder of the shift. This was either not implemented or was ineffective. This is in violation of 9CFR 381.65(e) which states: Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank. Also the establishment failed to meet the criteria of 417.2(c)(4) by not ensuring compliance with the critical limits which is ZERO tolerance.

0040-2011-19043	4567	01307 P	Marshall Durbin Company	AL	18-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 07:26, while on verification and performing an OCP-F/S test, I observed fecal material on bird #3 from a ten bird sample from line (b)(4). The feces was on the right fat-flap, measuring approximately 1/2 x 1/2 inch in diameter. It was brown in color with a very pasty consistency and a foul odor. I stopped the line and notified (b)(6)(b)(7)(C). This is in violation of 9CFR 381.65(e) which states that: Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tanks. Also the company failed to meet the criteria of 417.2(c)(4) by not ensuring compliance with the critical limits at the CCP which is ZERO tolerance. Past similar NR#0039-2011, maintenance adjusted tail clip and raised hip cam on ventor and would monitor ventor for next two hours every 30 minutes. This was either not implemented or was ineffective.
0044-2011-19043	4567	01307 P	Marshall Durbin Company	AL	25-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At approximately 13:24, while on verification and performing an OCP-F/S check, I observed fecal material inside of bird #3 from a ten bird random sample from line (b)(4). The feces was located inside of the bird on the right side of the keel bone. The feces was brown in color with a pasty consistency, measuring approximately 1/16 x 1/16 inch in size with 3 different blotches. I had the line stopped and notified (b)(6) (b)(7)(C). Past similar NR#0040-2011 dated 03/18/2011. Further planned action was maintenance would monitor (b)(4) (b)(4). This was either not implemented or was ineffective. This is in violation of 9CFR 381.65(e) which states: Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tanks. Also the company failed to meet the criteria of 417.2(c)(4) by not ensuring compliance with the critical limit at the CCP which is ZERO tolerance.

0037-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	2-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0648 hours, while performing a verification FS check on line (b)(4) I observed fecal material on the sixth bird of a ten carcass random sample. The fecal contamination was located on the inside of the bird on the left side near the vent. It had a pasty consistency, was green in color, and was one-sixteenth by three-eighths of an inch in size. Using color, consistency and composition, the substance was determined to be feces by (b)(6) (b)(7)(C) based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0642 hours. The cause of the deviation was identified by the establishment as: "We were having a problem with fecal on the outside of the bird at the CI stand. Maintenance adjusted the Venter too low into the carcass to try to prevent the fecal contamination, cutting the guts." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The plant food safety tech. performed (b)(4) 0830 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) Documentation will be performed at the time of adjustment and filed in Q.A. office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0034, dated (02/25/2011) documents another noncompliance regarding a HACCP deviation-CCP (b)(4)</p> <p>(b)(4)</p>
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0041-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	8-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0746 hours, while performing an FS verification check on line (b)(4), I observed fecal material on the first bird of a ten carcass random sample. The fecal contamination was located in the cloaca area. It had a pasty consistency, was brownish in color, and was 3/16 of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0712 hours. The cause of the deviation was identified by the establishment as: "The quick connect on module #7 busted causing the vent machine to loose vacuum pressure on module #7". Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) the plant food safety technician performed a retest with passing results at 0843 hours. The plant's preventive stated: (b)(4) will be replaced. Maintenance Supervisor or designee will verify the new quick connect on the vacuum hose was effective on the same check for previous fecal failure. Documentation will be filed in the QA office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0037-2011, dated (03/02/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>
0044-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	9-Mar-11	1	03J01	381.66(b), 417.2(c)(4)	<p>At approx 0713 hours, I observed the giblets (necks, livers and gizzards) exiting the gib chillers. As I proceeded to look inside the chillers I noticed that there were very little ice in these chillers. I informed the supervisor in the area at the time to get a thermometer and lets check the temps of the giblets. Using one of the establishment thermometers that had been calibrated earlier this morning. The gizzards were exiting at 40 degrees and lower which was in compliance. The necks were exiting at 57 degrees and the livers were exiting at 61 degrees both being out of compliance with an exiting temp exceeding the limit 40 degrees or lower. The neck and liver chillers were stopped. Personnel in block five were notified of the deviation. Corrective actions taken: (b)(4) Supervisor was counseled." The cause of the deviation was identified as the supervisor failed to put adequate amount of ice in the gib chillers. After being informed that the product were back in control. I performed a retest and I got a recording temp on the livers of 36 degrees and the necks were exiting at 33 degrees average. Both chillers were released by 0814 hours. The livers in the bin were chilled to 34 degrees and the establishment chose to condemn the hot combo of necks. Preventive measures states: "Managers (b)(6) (b)(7)(C) or (b)(6) (b)(7)(C) will verify that the (b)(4) (b)(4) Documentation will be done for the duration of the week and filed in QA office upon completion. By allowing this deviation the establishment have failed Regulation 9 CFR 417.2(c)(4) which states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with critical limits." and Regulation 9 CFR 381.66(b) states in part: "All poultry that is slaughtered and eviscerated in the official establishment shall be chilled immediately after processing so that the internal temperature is reduced to 40 degrees or less." A similar noncompliance have been recorded on NR #0027 dated 2/22/2011.</p>

0052-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	17-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1233 hours, while performing a food safety check on line (b)(4) I observed fecal material on the inside of the 6th bird out of a ten bird sample. Fecal contamination was located inside the bird on the left side near the kidneys. It measured approximately 1/4 inch x 1/8 inch in size. It had a pasty consistency and a brown color. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. Tracy Hill and Tina Tiegue, Evisceration Supervisors and (b)(6) (b)(7)(C) Q.C. Supervisor, were notified of the HACCP deviation. The last acceptable CCP (b)(4) (b)(4) check performed by Q.C. was recorded at 1218 hours. After the corrective actions according to HACCP plan and 9 CFR 417.3(a) were taken, Q.C. performed a retest with passing results at 1344 hours. The cause of the deviation was identified by the plant as: "The pin came out on the module #12 on the PNT." Corrective actions established by the plant as stated in the HACCP plan included: (b)(4)</p> <p><b>(b)(4)</b></p> <p>(b)(4) this will be done on both shifts." By allowing this deviation to exist, you have exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." 9 CFR 417.2 (c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with critical limits." 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank. NR #0047-2011-14500 dated 03/10/2008, documents similar noncompliance regarding a HACCP deviation - CCP (b)(4) (b)(4) Continued failure to meet regulatory requirements can lead to enforcement actions as described in 9 CFR 500.4.</p>
0055-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	22-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0807 hours, while performing a verification OCP check on line (b)(4) I observed fecal material on the third bird of a ten carcass random sample. The fecal contamination was located on the inside of the bird in the renal area. It had a pasty consistency, was green in color, and was three-eighths of an inch in size. Using color, consistency and composition, the substance was determined to be feces by (b)(6) (b)(7)(C) based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0741 hours. The cause of the deviation was identified by the establishment as: "The brass nut on a Venter guide bar broke off, misfeeding the birds and cutting into gut and back bone." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: 1. (b)(4)</p> <p><b>(b)(4)</b></p> <p>(b)(4) The plant food safety tech performed a retest with passing results at 0850 hours. The plant's preventive stated: (b)(4) (b)(4) A verification check will be done and filed in the Q.A. office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0052, dated (03/17/2011) documents another noncompliance regarding a HACCP deviation-CCP (b)(4)</p>

0059-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	25-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1007 hours, while performing an FS verification check on line (b)(4), I observed fecal material on the seventh bird of a ten carcass random sample. The fecal contamination was located in the inside of the right rib cage area. It had a pasty consistency, was brownish in color, and was one-eighth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0952 hours. The cause of the deviation was identified by the establishment as: "The hip module pin opener broke causing the opener blade to cut the guts." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The plant food safety technician performed a retest with passing results at 1036 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) Documentation will be filed in the QA office upon completion. Check will start 3/25-3/31/11." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0057-2011, dated (03/23/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>
0060-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	25-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1015 hours, while performing an FS verification check on line (b)(4), I observed fecal material on the First bird of a ten carcass random sample. The fecal contamination was located on the left leaf flap area. It had a pasty consistency, was brownish in color, and the area involved was one-fourth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 1007 hours. The cause of the deviation was identified by the establishment as: "The sorter did not properly inspect the bird. The gut and bursa was still attached to the bird. Performed line assessment and did not find anything wrong with any of the equipment.." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) (b)(4) The plant's preventive stated: (b)(4) Documentation will be filed in Q.A. office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0059-2011, dated (03/25/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>

0063-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	31-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1238 hours, while performing a food safety check on line (b)(4) I observed fecal material on the inside of the 1st bird out of a ten bird sample. Fecal contamination was located inside the bird on the tail area. It measured approximately 1/4 inch in diameter. It had a pasty consistency and a brown color. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. (b)(6) (b)(7)(C) Evisceration manager and (b)(6) (b)(7)(C) Q.C. Supervisor, were notified of the HACCP deviation. The last acceptable CCP (b)(4) check performed by Q.C. was recorded at 1209 hours. After the corrective actions according to HACCP plan and 9 CFR 417.3(a) were taken, Q.C. performed a retest with passing results at 1304 hours. The cause of the deviation was identified by the plant as: "Broken opener blade, cutting guts." Corrective actions established by the plant as stated in the HACCP plan included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) Documentation will be filed in QA office upon completion." By allowing this deviation to exist, you have exceeded the critical limit of CCP (b)(4) (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) (b)(4) 9 CFR 381.65(e)." 9 CFR 417.2 (c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with critical limits." 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank. NR #0060 dated 03/25/2010, documents similar noncompliance regarding a HACCP deviation - CCP (b)(4)</p>
0067-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	7-Apr-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1003 hours, while performing a food safety check on line (b)(4) I observed fecal material on the outside of the 8th bird out of a ten bird sample. Fecal contamination was located on the under side of the wing. It measured approximately 1/8 by 1/16 inch in size, had a pasty consistency and was brown in color. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. (b)(6) (b)(7)(C) Evisceration Supervisors was notified of the HACCP deviation. The last acceptable CCP (b)(4) check performed by Q.C. was recorded at 0951 hours. After the corrective actions according to HACCP plan and 9 CFR 417.3(a) were taken, Q.C. performed a retest with passing results at 1048 hours. Corrective actions established by the plant as stated in the HACCP plan included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The cause of the deviation was identified by the plant as: "Isolated incident. 10 All equipment was found to be acceptable. 2) No CI fecals have been found. 3) SPC checks were found to be acceptable." The preventive measure consisted of: (b)(4) Food safety will randomly verify extra sorter. Documentation will be filed in the QA office upon completion." By allowing this deviation to exist, you have exceeded the critical limit of CCP (b)(4) which states: (b)(4) (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." 9 CFR 417.2 (c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with critical limits." 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank. NR #0066-2011 dated 04/05/2011, documents similar noncompliance regarding a HACCP deviation - CCP (b)(4) (b)(4) Continued failure to meet regulatory requirements can lead to enforcement actions as described in 9 CFR 500.4.</p>

0080-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	28-Apr-11	1	03J01	381.66(b), 417.2(c)(4)	<p>At 1042 hours, I observed salvaged wings on the wing belt ready for FSIS inspection. I reviewed the time of the salvage wings and found the box on the inspection belt to have times of 0620 (trim time) and 1033 monitoring/verification time by QA Techs for meeting the HACCP's CCP (b)(4) requirements. Also, I observed two more boxes of finished iced wing product ready for FSIS inspection to have times of 0620 and 1037 hours. The 0620 time meant product was trimmed from eviscerated carcasses at 0620 hours and wasn't monitored and verified by QA Technicians for time/temperature requirements until 1037 hours. By allowing this noncompliance to occur, the plant has failed to meet CCP (b)(4) critical limit for (b)(4). It states: (b)(4) but it further states (b)(4) but it is not a HACCP deviation until the 4 hour limit has been exceeded." Product did surpass the 4 hour time limit and neither production nor Food Safety (QA) observed these findings. Product from all three boxes were condemned in my sight on site. 9 CFR 417.2 (c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with critical limits." 9 CFR 381.66b(2) states: "Major portions of poultry carcasses, as defined in § 381.170(b)(22), and poultry carcasses shall be chilled to 40 F. or lower within the following specified times: Weight of carcass Time (hours) Under 4 pounds ..... 4".</p>
0090-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	10-May-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1201 hours, while performing an FS verification check on line (b)(4) I observed fecal material on the second bird of a ten carcass random sample. The fecal contamination was located in the inside of carcass on the right side next to the tail area. It had a pasty consistency, was brownish in color, and was one-fourth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 1149 hours. The cause of the deviation was identified by the establishment as: "A water hose busted on module #5 in the inside/outside bird wash." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The plant food safety technician performed a retest with passing results at 1303 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) Documentation will be filed in QA office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 087-2011, dated (5/5 2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p> <p>(b)(4)</p>

0091-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	10-May-11	1	03J01	381.66(b), 417.2(c)(4)	<p>At approximately 1004 hours, while performing a scheduled 03J01 procedure (temperatures) in the First Processing Area, the following noncompliance was observed. While checking temperatures of the carcasses at the exit of (b)(4) CCP (b)(4) I recorded temperatures of (b)(4) degrees. One of these temperatures exceeded the plant's critical control limit for this CCP of (b)(4) Food Safety Tech. (b)(6) (b)(7)(C) was observing my check and immediately notified Chiller Supervisor (b)(6) (b)(7)(C) she and (b)(6) (b)(7)(C) immediately took corrective actions. The monitoring procedure for this CCP is: (b)(4) (b)(4) The criteria for this CCP is: (b)(4) A retest of the (b)(4) CCP was performed with passing results at approximately 1014 hours with an average temperature of 36 degrees. The last acceptable check by Food Safety in this area was at 0942 hours. The cause for the deviation was given by the plant as carcass was hung up. The plant's corrective actions state: (b)(4) (b)(4) (F.S. Tag #958424). Vat of birds tagged at 1004 hours with F.S. Tag #958425. The tagged product was released at approximately 1032 hours. Temperatures were 34,34,34,36, and36 degrees. The plant's preventive measures state: (b)(4) (b)(4) Documentation will be filed in Q.A. office upon completion. (b)(4) 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with critical limits." ( CFR 381.66(b) states: "(1) All poultry that is slaughtered and eviscerated in the official establishment shall be chilled immediately after processing so that the internal temperature is reduced to 40 degrees or less, as provided in paragraph (b)(2) of this section." A similar noncompliance was documented on NR #0088, dated 5/5/2011.</p>
0095-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	13-May-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0703 hours, while performing a food safety check on line (b)(4) I observed fecal material on the inside of the 7th bird out of a ten bird sample. Fecal contamination was located on the left side of the kidney It measured approximately 1/4 inch x 1/8 inch in size. It had a pasty consistency and a brown color. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. (b)(6) (b)(7)(C) Evisceration Supervisors and (b)(6) (b)(7)(C) Evisceration Manager, were notified of the HACCP deviation. The last acceptable CCP (b)(4) check performed by Q.C. was recorded at 0655 hours. After the corrective actions according to HACCP plan and 9 CFR 417.3(a) were taken, Q.C. performed a retest with passing results at 0746 hours. Corrective actions established by the plant as stated in the HACCP plan included: (b)(4) (b)(4) (b)(4) The cause of the deviation was identified by the plant as: (b)(4) he preventive measure consisted of: (b)(4) Documentation will be filed in QA office upon completion." By allowing this deviation to exist, you have exceeded the critical limit of CCP (b)(4) which states: (b)(4) on any bird as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." 9 CFR 417.2 (c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with critical limits." 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank. NR #0094-2011 dated 05/12/2011, documents similar noncompliance regarding a HACCP deviation - CCP (b)(4) Continued failure to meet regulatory requirements can lead to enforcement actions as described in 9 CFR 500.4.</p>

0096-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	16-May-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0647 hours, while performing an FS verification check on line (b)(4), observed fecal material on the third bird of a ten carcass random sample. The fecal contamination was located on top of the left kidney. It had a pasty consistency, was brownish in color, and was one-eighth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0609 hours. The cause of the deviation was identified by the establishment as: "Gut rod hung in module #11 on PNT.." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The plant food safety technician performed a retest with passing results at 0725 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) Documentation will be filed in QA office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4)</p> <p>(b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0094-2011, dated (05/13/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>
0109-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	26-May-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0704 hours, while performing an FS verification check on line (b)(4), observed fecal material on the ninth bird of a ten carcass random sample. The fecal contamination was located in the inside of carcass on the right side next to the kidney area. It had a pasty consistency, was brownish in color, and was one-eighth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0655 hours. The cause of the deviation was identified by the establishment as: "The spoon on module #2 on PNT was loose. The bolt was too long, not allowing the spoon to clamp the intestine properly." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>The plant food safety technician performed a retest with passing results at 0750 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) Verification will be filed in QA office upon completion " By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4)</p> <p>(b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0108, dated (05/24/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>

0110-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	27-May-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1016 hours, while performing a verification F.S. check on line (b)(4) I observed fecal material on the fourth bird of a ten carcass random sample. The fecal contamination was located on the inside of the bird in the renal area. It had a pasty consistency, was green in color, and was one-half of an inch in size. Using color, consistency and composition, the substance was determined to be feces by (b)(6) (b)(7)(C) based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 1010 hours. The cause of the deviation was identified by the establishment as: "The guide bar on the Vent Machine was out of adjustment, not properly venting birds." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The plant food safety tech. performed a retest with passing results at 1029 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) Documentation will be filed in Q.A. office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0109, dated (05/26/2011) documents another noncompliance regarding a HACCP deviation-CCP (b)(4)</p>
0111-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	30-May-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0708 hours, while performing a verification F.S. check on line (b)(4) I observed fecal material on the ninth bird of a ten carcass random sample. The fecal contamination was located on the inside of the bird near the vent. It had a pasty consistency, was green in color, and was one-fourth of an inch in size. Using color, consistency and composition, the substance was determined to be feces by (b)(6) (b)(7)(C) based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0648 hours. The cause of the deviation was identified by the establishment as: "The hose on Module #6 came off of the Inside/Outside Bird Washer. Not washing the birds out properly." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The plant food safety tech. performed a retest with passing results at 0727 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) Verification will be filed in Q.A. office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0110, dated (05/27/2011) documents another noncompliance regarding a HACCP deviation-CCP (b)(4)</p> <p>(b)(4)</p>



0112-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	30-May-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1232 hours, while performing an FS verification check on line (b)(4), observed fecal material on the first bird of a ten carcass random sample. The fecal contamination was located in the inside of carcass on the right side next to the tail area. It had a pasty consistency, was brownish in color, and was one-sixteenth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 1221 hours. The cause of the deviation was identified by the establishment as: "A probe stopped up on module #19 on the vent machine." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The plant food safety technician performed a retest with passing results at 1330 hours. The plant's preventive stated: (b)(4) verification will be filed in QA office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0111-2011, dated (5/30/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>
0117-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	6-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1201 hours, while performing an FS verification check on line (b)(4), observed fecal material on the ninth bird of a ten carcass random sample. The fecal contamination was located in the inside of carcass on the right side next to the kidney area. It had a pasty consistency, was brownish in color, and was one-fourth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 1147 hours. The cause of the deviation was identified by the establishment as: "The vent machine cams were not positioned properly. The settings were found at 6 and 2. They are supposed to be 5 and 3., thus cutting guts." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The plant food safety technician performed a retest with passing results at 1239 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0112-2011, dated (5/30/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>

0123-2011-14500	72	06505 P	Norman W. Fries, Inc	GA	22-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0906 hours, while performing an FS verification check on line (b)(4), observed fecal material on the tenth bird of a ten carcass random sample. The fecal contamination was located inside of left thigh area. It had a pasty consistency, was brownish in color, and was one-fourth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0845 hours. The cause of the deviation was identified by the establishment as: "Busted vacuum hose on module #2 on the venter line (b)(4). Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4) (b)(4) (b)(4). The plant food safety technician performed a retest with passing results at 0955 hours. The plant's preventive stated: (b)(4) (b)(4). Documentation will be filed in O.A. office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0330-2011, dated (06/06/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>
0129-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	28-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1007 hours, while performing a food safety check on line (b)(4), observed fecal material on the inside of the 8th bird out of a ten bird sample. Fecal contamination was located on the left kidney and measured approximately 1/4 inch x 1/8 inch in size. It had a pasty consistency and a brown color. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. (b)(6)(b)(7)(C), Evisceration Manager and (b)(6)(b)(7)(C) Q.A. Supervisor, were notified of the HACCP deviation. The last acceptable CCP (b)(4) check performed by Q.C. was recorded at 0945 hours. After the corrective actions according to HACCP plan and 9 CFR 417.3(a) were taken, Q.C. performed a retest with passing results at 1047 hours. Corrective actions established by the plant as stated in the HACCP plan included: (b)(4) (b)(4) (b)(4). The cause of the deviation was identified by the plant as: "The spring broke on module #12 on the vent machine." The preventive measure consisted of: (b)(4) (b)(4). A random check will be done for the duration of the shift to ensure the corrective action was effective. Check will be filed in O.A. office upon completion.. By allowing this deviation to exist, you have exceeded the critical limit of CCP (b)(4) (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) (b)(4) 9 CFR 381.65(e)." 9 CFR 417.2 (c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with critical limits." 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank. NR #0128-2011-16679 dated 06/27/2011, documents similar noncompliance regarding a HACCP deviation - CCP (b)(4)</p>

0133-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	30-Jun-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0707 hours, while performing a verification F.S. check on line (b)(4) I observed fecal material on the ninth bird of a ten carcass random sample. The fecal contamination was located on the inside of the bird on the backbone near the vent. It had a pasty consistency, was green in color, and was three-sixteenths of an inch in size. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0655 hours. The cause of the deviation was identified by the establishment as: "A bird was hung up in a module on the PNT Machine. The PNT was set too high." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4) (b)(4)</p> <p>The plant food safety tech. performed a retest with passing results at 0737 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) (b)(4)</p> <p>Verification will be filed in Q.A. office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0129, dated (06/28/2011) documents another noncompliance regarding a HACCP deviation-CCP (b)(4)</p>
0135-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	1-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1231 hours, while performing a food safety check on line (b)(4) I observed fecal material on the inside of the 6th bird out of a ten bird sample. Fecal contamination was located inside the bird on the left side near the kidneys. It measured approximately 1/4 inch x 1/8 inch in size. It had a pasty consistency and a brown color. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. (b)(6) (b)(7)(C) evisceration Manager was notified of the HACCP deviation. The last acceptable CCP (b)(4) check performed by Q.C. was recorded at 1221 hours. After the corrective actions according to HACCP plan and 9 CFR 417.3(a) were taken, Q.C. performed a retest with passing results at 1344 hours. The cause of the deviation was identified by the plant as: "The (b)(4) machine had a bent gut clamp pin causing guts to be broken." Corrective actions established by the plant as stated in the HACCP plan included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) Verification will be filed in QA office upon completion." By allowing this deviation to exist, you have exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." 9 CFR 417.2 (c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with critical limits." 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank. NR #0133-2011-16676 dated 06/30/2008, documents similar noncompliance regarding a HACCP deviation - CCP (b)(4)</p>

0139-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	7-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0907 hours, while performing a verification F.S. check on line (b)(4), observed fecal material on the fifth bird of a ten carcass random sample. The fecal contamination was located on the inside of the bird on the backbone near the renal area. It had a pasty consistency, was green in color, and was one-fourth of an inch in size. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0847 hours. The cause of the deviation was identified by the establishment as: "The blade came off on module #2 on the Vent Machine." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The plant food safety tech performed a retest with passing results at 0941 hours. The plant's preventive stated: "Disciplinary action was taken on employee setting up the machine at start-up. (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) Verification will be filed in the Q.A. office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4)</p> <p>(b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0135, dated (07/01/2011) documents another noncompliance regarding a HACCP deviation-CCP (b)(4)</p> <p>(b)(4)</p>
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0142-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	11-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0803 hours, while performing a food safety check on line (b)(4) observed fecal material on the outside of the 4th bird out of a ten bird sample. Fecal contamination was located approximately 1 1/2 inches below the tail on the back side of the carcass and was approximately 1/8 of an inch in diameter per circular size. It had a pasty consistency and a brown color. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. (b)(6) (b)(7)(C) Evisceration Supervisors and (b)(6) (b)(7)(C) Q.C. Supervisor, were notified of the HACCP deviation. The last acceptable CCP (b)(4) check performed by Q.C. was recorded at 0750 hours. After the corrective actions according to HACCP plan and 9 CFR 417.3(a) were taken, Q.C. performed a retest with passing results at 0903 hours. The cause of the deviation was identified by the plant as: "A busted water hose on the inside outside bird washer on module #8. " Corrective actions established by the plant as stated in the HACCP plan included: (b)(4)</p> <p>(b)(4) (b)(4) The preventive measure consisted of: (b)(4)</p> <p>(b)(4)</p> <p>By allowing this deviation to exist, you have exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) (b)(4) 9 CFR 381.65(e)." 9 CFR 417.2 (c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with critical limits." 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank. NR #0047-2011-14500 dated 03/10/2008, documents similar noncompliance regarding a HACCP deviation - CCP (b)(4)</p>
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0148-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	15-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1013 hours, while performing an FS verification check on line (b)(4) I observed fecal material on the seventh bird of a ten carcass random sample. The fecal contamination was located on the inside of right thigh area. It had a pasty consistency, was green in color, and was one-fourth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 1010 hours. The cause of the deviation was identified by the establishment as: "The infeed guide rail came loose on the I/O bird washer causing to misfeed into modules." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>Disciplinary action taken on sorter.. The plant food safety technician performed a retest with passing results at 1037 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) Documentation will be filed in Q.A. office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0143-2011, dated (07/11/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p> <p>(b)(4)</p>
0153-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	22-Jul-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0640 hours, while performing an FS verification check on line (b)(4) I observed fecal material on the 8th bird of a ten carcass random sample. Three tiny spots of fecal contamination was located in the kidney area. they had a pasty consistency, was dark green in color, and was one-sixteenth to one-eighth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0623 hours. The cause of the deviation was identified by the establishment as: "A broken breast plate spring on eviscerator module #19." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4)</p> <p>(b)(4) The plant food safety technician performed a retest with passing results at 0707 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) Verification will be filed in Q.A office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0152-2011, dated (07/21/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p> <p>(b)(4)</p>

0163-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	2-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0707 hours, while performing an FS verification check on line (b)(4), observed fecal material on the eighth bird of a ten carcass random sample. The fecal contamination was located in the cloaca area. The bird still had the cloaca attached and intestine approximately 1 1/2 inch long It had a pasty consistency, was brownish in color, and was 3/16 of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0648 hours. The cause of the deviation was identified by the establishment as: "Employee error. Sorter was not looking into birds." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4) (b)(4) (b)(4) The plant food safety technician performed a retest with passing results at 0739 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) Documentation will be filed in the QA office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0160-2011, dated (07/26/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>
0164-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	3-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 1004 hours, while performing an FS verification check on line (b)(4), observed fecal material on the fifth bird of a ten carcass random sample. The fecal contamination was located in the renal area. It had a pasty consistency, was brownish in color, and was one-eighth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0945 hours. The cause of the deviation was identified by the establishment as: " The air fitting to the ventor vacuum hose broke, causing the vent of the bird not to be properly vented." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4) (b)(4) The plant food safety technician performed a retest with passing results at 1033 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) (b)(4) Verification will be filed in Q.A. office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that no (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0163-2011, dated (8/21/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>

0167-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	10-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0740 hours, while performing an FS verification check on line (b)(4) I observed fecal material on the sixth bird of a ten carcass random sample. The fecal contamination was located on the left kidney . It had a pasty consistency, was green in color, and was 3/16 of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0719 hours. The cause of the deviation was identified by the establishment as: "The opener blade broke on module #4. The blade was not secure in arm cutting guts." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4) (b)(4) The plant food safety technician performed a retest with passing results at 0804 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) (b)(4) By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0168-2011, dated (08/09/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>
0173-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	18-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0619 hours, while performing an FS verification check on line (b)(4) I observed fecal material on the eight bird of a ten carcass random sample. The fecal contamination was located in the kidney area. It had a pasty consistency, was greenish in color, and was one-sixteenth of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. Before my finding there had not yet been a food safety check performed by QC on this line. So there's no last acceptable check time to document. The cause of the deviation was identified by the establishment as: "Infeed guide rail bolt on the venter line (b)(4) came off causing birds to misfeed. Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4) (b)(4) The plant food safety technician performed a retest with passing results at 0645 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) (b)(4) Documentation will be filed in Q.A. office upon completion." By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0171-2011, dated (08/15/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>



0176-2011-16679	72	06505 P	Norman W. Fries, Inc	GA	22-Aug-11	1	03J01	381.65(e), 417.2(c)(4)	<p>At approximately 0829 hours, while performing an FS verification check on line (b)(4) I observed fecal material on the tenth bird of a ten carcass random sample. The fecal contamination was located in the renal area. It had a pasty consistency, was brownish in color, and was approximately 5/8 of an inch in diameter. Using color, consistency and composition, the substance was determined to be feces based on FSIS Directive 6420.2. A regulatory control action was taken by retaining the bird and the bird was reworked and released. The personnel in block #5 were notified of the HACCP deviation. The last acceptable CCP (b)(4) monitoring check documented by the Food Safety Technician was recorded at 0742 hours. The cause of the deviation was identified by the establishment as: "The infeed guide bar on the vent machine was bent, causing the birds to misfeed into the machine. During the time the machines were being set up a problem occurred in the ceiling. Plastic was being hung through evisceration. Someone stepped on the guide bar on the venter." Corrective actions established by the plant as stated in the HACCP plan and the Fecal Failure Corrective Action Form included: (b)(4)</p> <p>(b)(4) (b)(4) The plant food safety technician performed a retest with passing results at 0908 hours. The plant's preventive stated: (b)(4)</p> <p>(b)(4) (b)(4) By allowing this deviation to exist, the establishment has exceeded the critical limit of CCP (b)(4) which states: (b)(4) as per FSIS Directive 6420.2 which requires that (b)(4) 9 CFR 381.65(e)." Regulation 9 CFR 381.65(e) states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." Regulation 9 CFR 417.2(c)(4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." NR 0173-2011, dated (8/18/2011) documents same noncompliance regarding a HACCP deviation-CCP (b)(4)</p>
0037-2011-18207	3881	07101 P	Tyson Foods, Inc.	AR	30-Mar-11	1	03J01	381.65(e), 417.3(a)(1), 417.3(a)(2), 417.3(a)(3), 417.3(a)(4)	<p>At 0827 hours, while performing a scheduled Food Safety check on line (b)(4) in the evisceration department, a component of procedure 03J01, I observed visible fecal material on the second carcass of the ten randomly selected carcass subgroup sample. I asked Dr. Fox, who was in the carcasses inspection position on line (b)(4) to stop the line and ring the buzzer for a member of the establishment's management. (b)(6) (b)(7)(C) observed the carcass and (b)(6) (b)(7)(C) also observed the carcass and agreed with the determination that the finding was fecal material. (b)(6) (b)(7)(C) took the carcass to the reprocessing department and had the carcass reprocessed. The establishment implemented corrective action. The feces was dark brown in color, creamy in consistency with a smear approximately 1/2 inch by 1 and 1/2 inch in diameter. The feces was located inside the breast cavity on the keel bone. According to plant management the cause of the deviation was, "Bolt came loose that holds blade in proper position. Work order #53165023 issued and completed by maintenance. The plant management stated that the preventive measure would be discussed in a food safety meeting. A review of the establishment's records for CCP 4 revealed no findings of fecal material prior to 0827 hours. All checks by the establishment's personnel were conducted hourly as specified for CCP 4 in the HACCP slaughter plan. The finding of feces is a failure to meet the critical limit at CCP 4 and the establishment's monitoring procedures to identify the failure to meet the critical limits. The establishment failed to meet the regulatory requirement of 9 CFR 381.65(e) and 9 CFR 417.3(a)(1-4) as well as the critical limit for CCP 4 documented in the establishment's Slaughter HACCP Plan which states, (b)(4)</p> <p>(b)(4)</p>

0014-2011-17619	2643	07769 P	Farbest Foods, Inc.	IN	1-Mar-11	1	03J01	381.65(e), 417.2(c)(4)	At 5:29 AM while performing an FS/ OCP verification test, I observed the second turkey in the test set to have fecal on the outside left wing. The feces was one quarter of an inch in diameter and was dark green in color and had a smooth pasty texture. Supervisors (b)(6) (b)(7)(C) and (b)(6) (b)(7)(C) were notified of the non-compliance of the regulatory requirements for zero tolerance of product entering the chilling system. A records review was performed at 9:00 AM which showed that corrective actions had been completed and that no additional fecal contamination was found.
0006-2011-15796	7591	20935 P	Michigan Turkey Producers LLC	MI	15-Mar-11	1	04C04	381.79	03/15/11 @ approximately 1130hrs. while performing a 04C04 Finished Product standards Check in the establishments boning room I observed the following non-compliance issue. While verifying all lungs and kidneys had been removed from 4 tanks of product (4 lots), I observed 3 whole lungs in the first 10 birds checked. An additional 2 partial lungs were observed within the next 10 birds for the first tank. The second tank was observed and found to have 2 lungs in the first 10 and 2 additional lungs in the second 10. The third tank had 1 lung in the first 10 in addition to airsacculitis being observed in the kidney section. The kidneys in the bird that contained the airsacculitis hadn't been removed either. The second group of 10 birds from the same tank was found to have 4 additional lungs. The fourth tank was also found to be non-compliant with 4 lungs observed in the first 10 an a additional 1 lung in the next 10 observed. Out of the for tanks of product there was a total of 19 whole lungs and pieces observed. At the time the tanks were inspected there weren't any controls in place that would have prevented the product from being used for mechanically separated turkey. USDA Inspection personnel retained the 4 tanks of product by utilizing U.S. RETAINED Tag NO.B26577198, NO.B26577194, NO.B26577193 and NO.B26577199. While reviewing the establishments documentation for its Turkey Frame Audit (Form NO. 620.1) it was noted that Quality Assurance Personnel had failed the line @ 0837hrs. with 3 pieces of kidney observed. Two additional checks had been performed @ 0925hrs, and 1030hrs. with acceptable results. The establishments turkey frame audit purpose/objective states "To ensure proper removal of all lungs and kidneys from turkey frames prior to entering the Mechanically Separated Turkey (MST) system." The turkey frame audit is performed (b)(4) You have failed to meet the requirements set forth in 9 CFR 381.76(iv)(b)- An inspector shall monitor the establishment's application of the Finished Product Standards program and shall take corrective action including retaining product to prevent adulterated product from leaving the establishment when the inspector determines that the establishment has failed to apply the program as prescribed in paragraph (b)(3)(iv)(c) of this section). 9 CFR 416.13(c)Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.

0009-2011-17777	7591	20935 P	Michigan Turkey Producers LLC	MI	21-Jun-11	1	03J01	381.65(e)	06/21/2011 at 1002 Hrs. while performing a 10 bird food safety check, carcass number 8 was found with fecal contamination adhering to the underside of the loose tissue on the left side of the vented opening of the body cavity. The two spots observed were approximately 1/4 inch in size with a glossy green color with a pasty consistency that smeared to the touch. Area Manger Rodney Keith was notified of the non-compliance issue in addition to the area Quality Assurance Technician. The Quality Assurance Technician performed carcass checks and no additional fecal contamination was found. Plants HIMP Plan States; (b)(4) 9 CFR 381.65e States; Poultry carcass contaminated with visible fecal material shall be prevented from entering the chilling tank.
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