

TREATED STOMACHS, BLADDERS AND INTESTINES

WHY ARE HYGIENE REQUIREMENTS IMPORTANT IN THE PRODUCTION OF TREATED STOMACHS, BLADDERS AND INTESTINES?

Food borne pathogens such as salmonella, campylobacter and e.coli commonly reside in the gut flora of animals, including those that are clinically healthy. It is therefore very important that hygiene requirements are followed when stomachs, bladders and intestines are treated for human consumption, in order to prevent these pathogens passing into the human food chain.

PREMISES		
LEGAL REQUIREMENTS	GUIDE TO COMPLIANCE	RECOMMENDATIONS ON BEST PRACTICE
Approval of premises	Approval of premises	Approval of premises
Establishments that handle or treat stomachs, bladders and intestines must be approved by the competent authority. Approval will not be required if the establishment carries out only:	Establishments handling stomachs, bladders and intestines intended for human consumption must be approved by the Food Standards Agency (if they are co-located with a slaughterhouse or cutting plant) or by the local food authority	N/A

<ul style="list-style-type: none"> ➤ transport operations, or ➤ storage of products not requiring temperature-controlled storage conditions. <p>(853/2004 Article 4.2)</p>	<p>(in all other cases).</p> <p>Establishments needing approval would therefore include, for example:</p> <ul style="list-style-type: none"> ➤ plants manufacturing sausage casings (“manufacturing plants”); ➤ those parts of slaughterhouses separating and cleaning stomachs, bladders and intestines for human consumption, and ➤ intermediate plants storing stomachs, bladders and intestines requiring temperature-controlled storage. <p>However establishments that only carry out transport and / or ambient storage of stomachs, bladders and intestines that have already been dried or salted are exempt from approval. Such establishments must nevertheless still be registered as food establishments under Regulation 852/2004.</p> <p>Further information – Please refer to Chapter <i>nn</i> (Approvals)</p>	
Design and layout	Design and layout	Design and layout
The layout, design, construction, siting and size of food premises are to permit	Further information - Please refer to Chapter 1 (Design & Facilities).	N/A

<p>good food hygiene practices, including protection against contamination.</p> <p><i>(852/2004 Annex II Chapter I: General requirements: paragraph 2(c))</i></p>		
<p>Separation in the slaughterhouse</p>	<p>Separation in the slaughterhouse</p>	<p>Separation in the slaughterhouse</p>
<p>To avoid contaminating meat slaughterhouses must:</p> <ul style="list-style-type: none"> ➤ have a separate room for emptying and cleaning the stomachs and intestines, unless the competent authority authorises the separation in time of these operations within a specific slaughterhouse on a case-by-case basis ➤ ensure separation in space or time for evisceration and further dressing, handling clean guts and tripe, packaging of offal and dispatching meat ➤ have lockable facilities for the refrigerated storage of meat declared unfit for human consumption ➤ have a special area or place for storing manure or digestive tract content if 	<p>It is the plant operator's responsibility to ensure that all dressing procedures are conducted in a hygienic manner so that meat for human consumption is not contaminated. This includes providing the separation of the different dressing activities and the separation between edible and inedible by-products.</p> <p>Rooms for emptying and cleaning stomachs and intestines are probably the dirtiest rooms in the plant and must be properly isolated from the rest of the building.</p> <p>Wherever separation in time is permitted, the processing area and equipment must be cleaned and disinfected before reuse.</p>	<p>Best practice would be to ensure that separate rooms are provided for (a) cleaning the raw material, (b) treating it, (c) storing it after treatment and (d) dispatching it. This reduces the risk of contamination.</p>

<p>stored in the slaughterhouse.</p> <p>(853/2004, Annex III, Section I, Chapter II, 2(b)(c), 5, 8)</p>		
HYGIENE		
LEGAL REQUIREMENTS	GUIDE TO COMPLIANCE	RECOMMENDATIONS ON BEST PRACTICE
Post mortem inspection	Post mortem inspection	Post mortem inspection
<p>Until <i>post mortem</i> inspection is completed, parts of a slaughtered animal subject to such inspection must remain identifiable as belonging to a given carcass.</p> <p>(853/2004, Annex III, Section I, Chapter IV, 13(a))</p> <p>If the blood or other offal of several animals is collected in the same container before completion of <i>post mortem</i> inspection, the entire contents must be declared unfit for human consumption if the carcass of one or more of the animals concerned has been declared unfit for human consumption.</p>	<p>If the stomachs, bladders and intestines are separated from the carcass before completion of the <i>post mortem</i> inspection, the operator must establish:</p> <ul style="list-style-type: none"> ➤ a system to ensure the separate <i>post mortem</i> inspection of those stomachs, bladders and intestines, and ➤ a system to ensure that if a carcass is separately declared unfit, the stomachs, bladders and intestines from that carcass are also declared unfit and disposed of accordingly`. <p>When it is impossible to identify the specific stomachs, bladders and intestines from a particular carcass declared unfit,</p>	<p>Best practice would be to ensure that stomachs, bladders and intestines remain associated with the carcass / offal until the post mortem inspection is complete. This would eliminate the need for an entire batch of stomachs, bladders and intestines to be declared unfit when a carcass is declared unfit.</p>

<p>(853/2004, Annex III, Section I, Chapter IV, 15)</p> <p>After <i>post mortem</i> inspection:</p> <ul style="list-style-type: none"> ➤ parts unfit for human consumption must be removed as soon as possible from the clean sector of the establishment ➤ meat detained or declared unfit for human consumption and inedible by-products must not come into contact with meat declared fit for human consumption <p>(853/2004, Annex III, Section I, Chapter IV, 16(b)(c))</p>	<p>the entire batch of stomachs, bladders and intestines which might have been derived from that carcass must be declared unfit.</p>	
<p>Hygiene in the slaughterhouse</p>	<p>Hygiene in the slaughterhouse</p>	<p>Hygiene in the slaughterhouse</p>
<p>Measures must be taken to prevent the spillage of digestive tract content during and after evisceration and to ensure that evisceration is completed as soon as possible after stunning.</p> <p>(853/2004, Annex III, Section I, Chapter IV, 7(c))</p>	<p>Care must be taken during evisceration to prevent the contamination of the carcass by faecal matter and gut contents in general. Accidental opening of stomachs and tripes can lead to contamination, spreading to internal and external surfaces of the carcass.</p> <p>The operator is responsible for</p>	<p>Plant staff emptying stomachs and intestines should wash their hands and clean and disinfect their work clothing and equipment to avoid cross contamination.</p> <p>Best practice would be to ensure that staff employed in the gut room are not permitted to enter any other processing room. This further reduces the risk of</p>

	<p>maintaining at all times the proper separation of meat fit for human consumption and animal by-products. This includes the separation of stomachs, bladders and intestines intended for human consumption and those not intended (which are animal by-products – see “animal by-products“ section below).</p> <p>Such animal by-products should be stored in an entirely separate part of the slaughterhouse, so that they could neither be confused with food material, contaminate it nor be substituted for it.</p> <p>The operator is also responsible for providing plant facilities, equipment and staff for the collection, hygienic handling and disposal of inedible by-products.</p> <p>Further information - please refer to the section “Separation from animal by-products” below and to Chapter 2, Part 4 (Animal By-Products).</p>	<p>contamination.</p> <p>Containers / trays of both raw and treated material should ideally be on shelves, not on the floor, and be covered or otherwise closable. This also further reduces the risk</p>
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		of contamination.
Cleaning in the slaughterhouse	Cleaning in the slaughterhouse	Cleaning in the slaughterhouse
<p>When destined for further handling:</p> <ul style="list-style-type: none"> ➤ stomachs must be scalded or cleaned ➤ intestines must be emptied and cleaned <p><i>(853/2004, Annex III, Section I, Chapter IV, 18(a)(b))</i></p>	<p>Stomachs (unless scalded) and intestines intended for human consumption must be thoroughly cleaned and washed in the slaughterhouse. Such cleaning and washing must be done in such a way that contamination of already clean material is avoided.</p> <p>As a result, the stomachs and intestines must be visually clean, without tears or any other abnormalities. They must be as free as is practically possible of faecal contamination. If it is not possible to ensure absolute freedom from faecal contamination after cleaning in, for example, the gut room of the slaughterhouse, the operator must ensure that there are procedures in place elsewhere in the slaughterhouse or in the manufacturing plant which do ensure that absolute freedom from faecal contamination is achieved.</p>	<p>Best practice would be to ensure that cleaned stomachs and intestines are <i>absolutely</i> free of faecal contamination before they leave the slaughterhouse.</p>
Treatment	Treatment	Treatment
Animal intestines, bladders and stomachs may be placed on the market only if:	See section “separation requirements in the slaughterhouse” above on how to	

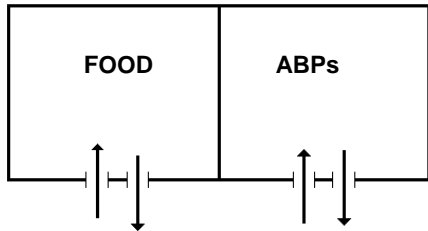
<p>a) they come from animals slaughtered in a slaughterhouse, which following <i>ante mortem</i> and <i>post mortem</i> inspection have been judged fit for human consumption</p> <p>b) they are salted, heated or dried, and</p> <p>c) after the treatment referred to in (b), effective measures are taken to prevent re-contamination</p> <p>(853/2004, Annex III, Section XIII, 1, (a), (b), (c))</p>	<p>ensure that the raw material comes from animals which have passed <i>ante mortem</i> and <i>post mortem</i> inspection.</p> <p>Once the raw material has been cleaned in the slaughterhouse, it must then be either salted or heated or dried, or a combination of these.</p> <p>This treatment may take place either in the slaughterhouse or in a separate manufacturing plant to which the raw material has been transported. If this takes place in the slaughterhouse, this must be in room approved for the purpose and separated in space or time from the room used for cleaning the raw material.</p> <p>See sections “separation requirements in the slaughterhouse” and “separation from animal by-products” on how to ensure hygienic handling and separation from material which could lead to contamination.</p>	<p>Treatment by salting should be thorough, since salting contributes to the removal or destruction of pathogens.</p> <p>If treatment takes place in the slaughterhouse, best practice would be to ensure that the room approved for treatment is clearly separated from the room used for cleaning the raw material and is used only for this purpose.</p> <p>See sections “separation requirements in the slaughterhouse” and “separation from animal by-products” on best practice on hygienic handling and separation of material.</p>
<p>Temperature Controls</p>	<p>Temperature Controls</p>	<p>Temperature Controls</p>

<p>Treated stomachs, bladders and intestines that cannot be kept at ambient temperature must be stored chilled using facilities intended for that purpose until their despatch.</p> <p>If they have been neither salted nor dried, they must be treated as offal kept at a temperature of less than +3°C.</p> <p><i>(853/2004, Annex III, Section XIII, 2 and Annex III, Chapter VII, 1 (a))</i></p>	<p>Unless stomachs, bladders and intestines have undergone salting and / or drying after cleaning, they must be chilled.</p> <p>Instead they must be treated as offal and stored at +3°C or lower under hygienic conditions and be chilled to less than +3°C before despatch in refrigerated transport.</p> <p>This requirement applies both to the raw material in the slaughterhouse and in subsequent premises including the manufacturing plant, and (if it has only been heated) to the treated material.</p>	
Identification Marking	Identification Marking	Identification Marking
<p>Both raw material (i.e. the <i>untreated</i> stomachs, bladders and intestines) and the final product (i.e. the <i>treated</i> stomachs, bladders and intestines) must bear an identification mark showing the approval number of the establishment which handled and prepared them.</p> <p><i>(853/2004, Article 5)</i></p>	<p>In most cases, the raw material will bear the identification mark of the slaughterhouse where it was obtained, and the final product will bear the identification market of the manufacturing plant where it was treated.</p> <p>Further information - please refer to Chapter 11 Traceability (Identification and Health Marking).</p>	N/A

ANIMAL BY-PRODUCTS		
LEGAL REQUIREMENTS	GUIDE TO COMPLIANCE	RECOMMENDATIONS ON BEST PRACTICE
Separation of raw material for human consumption from animal by-products	Separation of raw material for human consumption from animal by-products	Separation of raw material for human consumption from animal by-products
<p>Animal by-products (ABPs) are any part of an animal carcass or any material of animal origin not intended for human consumption, including ova, embryos and semen.</p> <p>(1774/2002, Article 2, 1(a))</p> <p>The legislation requires that at all stages there must be a clear separation between material for human consumption and ABPs.</p> <p>ABPs must be handled and disposed of according to Regulation 1774/2002.</p> <p>(EC 1774/2002, Article 4(2)b, Article 5(2)(b) & Article 6(2)(b))</p>	<p>Stomachs, bladders and intestines are normally disposed of immediately after <i>post mortem</i> inspection as ABPs. However when intended for human consumption, it is important that they are handled not as ABPs, but are rather handled in line with the requirements set out here.</p> <p>The important point is the intention, since products become ABPs as soon as the operator decides that they are no longer intended for human consumption.</p> <p>Once the operator has decided that he does not intend or no longer intends raw materials to go for human consumption, they become ABPs and stay that way. The ABPs cannot then revert to being a foodstuff. The operator is obliged to dispose of them appropriately (e.g. by consignment to an approved ABP</p>	<p>See section “separation requirements in the slaughterhouse” above on best practice on hygienic handling and separation of ABPs from material intended for human consumption.</p>

	<p>premises). In practical terms, this would involve re-labelling the product as ABP when it is dispatched.</p> <p>All ABPs require the strictest supervision by the operator from when they originate until disposal. If not, they could be accidentally or fraudulently diverted into the food chain or included in meat products intended for human consumption.</p> <p>Proper segregation between ABPs and animal products intended for human consumption must be maintained at all times – see section “separation requirements in the slaughterhouse” above.</p> <p>See section “separation requirements in the slaughterhouse” above on how to ensure hygienic handling and separation of ABPs from material intended for human consumption.</p>	
Labelling	Labelling	Labelling
<p>The legislation requires that ABPs must be labelled as such and be conveyed directly to the legitimate plant of destination.</p>	<p>Operators must not label material they want to go into the food chain as ABPs.</p> <p>If they do, these products will be treated</p>	<p>Strict separation of ABPs from material intended for human consumption reduces the risk of the latter being mis-labelled as ABP – see best practice column in section</p>

<p>(1774/2002 Annex II, Chapter I)</p>	<p>as ABPs for enforcement purposes.</p> <p>Materials become ABPs when they are not or are no longer <i>intended</i> for human consumption (see section “separation from animal by-products” above). If an operator labels material as ABPs, that is clear evidence of their intention.</p>	<p>“separation requirements in the slaughterhouse” above.</p>
<p>Storage of food material in intermediate ABP plants</p>	<p>Storage of food material in intermediate ABP plants</p>	<p>Storage of food material in intermediate ABP plants</p>
<p>Intermediate ABP plants must be adequately separated from food premises. Intermediate plants must also not engage in activities other than those in connection with the ABPs for which they are approved.</p> <p>(1774/2002, Annex III, Chapter I & II)</p>	<p>Although not desirable, it is possible for stomachs, bladders and intestines intended for human consumption (i.e. food material) to be consigned to a site on which an intermediate ABP plant is situated, before being consigned to the manufacturing premises, but strict conditions apply. These include:</p> <ul style="list-style-type: none"> ➤ the intermediate plant and the food plant must be demonstrably separate ➤ food material cannot under any circumstances be taken into the intermediate plant ➤ the intermediate plant must be approved under Regulation 1774/2002 ➤ the food plant must be registered 	<p>Best practice would be to transport stomachs, bladders and intestines intended for human consumption direct from the slaughterhouse to the manufacturing plant, without passing through sites that contain ABP plants. This greatly reduces the risk of ABPs being diverted into the food chain.</p> <p>If, however, stomachs, bladders and intestines intended for human consumption are held in a food premises which shares a site with an ABP plant, a number of additional precautions could be taken to reduce the risk of diversion or contamination. For example, containers should be of a colour or type that</p>

	<p>under Regulation 852/2004 or approved under Regulation 853/2004 (see section “approval of premises” above).</p> <p>To be demonstrably separate, the food plant and intermediate plant which share the same site must have separate boundaries and separate entrances. This is to ensure that under no circumstances does food enter the ABP plant nor ABPs enter the food plant. See diagram below.</p> 	<p>distinguishes those for ABPs from those used for food material. There should also be no interchange of personnel between the food plant and the ABP plant, nor any interchange of equipment, and there should be separate changing facilities.</p>
<p>Transport of ABPs and food</p>	<p>Transport of ABPs and food</p>	<p>Transport of ABPs and food</p>
<p>Where conveyances and / or containers are used for transporting anything in addition to food material, there must where necessary be effective separation of products.</p> <p><i>(852/2004, Annex II Chapter IV)</i></p>	<p>If food material and ABPs are transported together, each container used for ABPs must be of sufficient size and strength to safely hold its contents throughout the transport process without spillage or leakage. There must be effective separation between the ABPs and the</p>	<p>Best practice would be to ensure that food material and ABPs are not collected or transported in the same container or vehicle. This greatly reduces the risk of substitution or contamination.</p> <p>If, nevertheless, food material and ABPs</p>

<p>ABPs must be collected and transported in sealed new packaging or covered leak-proof, lidded and correctly labelled containers or vehicles.</p> <p><i>(1774/2002, Annex II, Chapter II)</i></p> <p>During transport, ABPs must be maintained at an appropriate temperature to avoid any risk to animal or public health.</p> <p><i>(1774/2002, Annex II, Chapter VI)</i></p>	<p>food material.</p> <p>Any vehicle or item of equipment that comes into contact with ABPs must be cleaned, washed and disinfected after each daily use. Containers must be kept clean and disinfected.</p> <p>Containers used for food material must be clearly identified and only used for the designated purpose.</p> <p>If food becomes mixed with ABPs then it all has to be treated ABPs.</p> <p>ABPs must be consigned only to permitted approved destinations.</p> <p>Further information - please refer to Chapter <i>[DN: No]</i> (Animal by-Products)</p>	<p>are collected or transported together, an additional precaution would be to ensure that containers are of a colour or type that distinguishes those for ABPs from those for food material.</p>
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WHAT ARE THE OFFICIAL CONTROL REQUIREMENTS?

Establishments that handle stomachs, bladders and intestines intended for human consumption will be subject to the official control requirements of Regulation 854/2004. All establishments will therefore be subject to audit by the competent enforcement authority (which is the Meat Hygiene Service in premises containing slaughterhouses, cutting plants and game handling establishments, and local authorities elsewhere). The audits will contain the following elements:

- Audits of good hygiene practice and HACCP (854/2004, Article 4(3))
- Checks that meat is declared unfit for human consumption if it shows soiling or faecal or other contamination (854/2004, Annex I, Section I, Chapter V)
- Visual *post mortem* inspection of the gastro-intestinal tract (854/2004, Annex I, Section IV, Chapter IB, paragraph 6, Chapter II, paragraph 6, Chapter IV B, Paragraph 1(f))
- Checks on compliance with the requirements of Regulation 1774/2002 (854/2004, Article 4(c))