

Chapter Ag 47

INSPECTION, PROCESSING, MARKETING AND STORAGE OF MEAT AND POULTRY

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History: Chapter Ag 47 as it existed on September 30, 1971 was repealed and a new chapter Ag 47 was created, Register, September, 1971, No. 189, effective October 1, 1971

Ag 47.01 Scope of rules. The provisions of these rules shall apply to slaughterers, mobile slaughterers, frozen food lockers, processors, distributors, carriers, meat brokers, retail stores and central restaurant commissaries engaged in slaughtering, processing, storing, transporting or marketing of meat and poultry, but shall not be applicable to restaurants and vending machine commissaries, as defined in chapter 160, Wis. Stats., or catering establishments, subject to inspection and regulation by the department of health and social services, where only inspected meat and poultry are used in processing operations, where meat or poultry are processed only for use in the preparation or serving of meals and lunches, and processing operations are confined to the premises at which meals or lunches are prepared and served, or in the case of vending machine commissaries or catering establishments, the premises at which meals or lunches are prepared for individual customers or for sale through vending machines. The rules do not apply to establishments under federal inspection, or to establishments under county or municipal inspection approved by the department and conducted pursuant to ordinances and regulations which are substantially equivalent to this chapter and enforced with equal effectiveness.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.02 Definitions. As used in this chapter:

(1) "Department" means the state of Wisconsin department of agriculture.

(2) "Inspector" means any person authorized by the department to conduct inspections.

(3) "Meat products" and "poultry products" mean the carcasses or edible parts of carcasses and poultry.

(4) "Meat food product" means any article intended for use as human food which is derived or prepared in whole or in substantial and definite part from meat products and poultry products.

(5) "Wholesome" means sound, healthful, clean, and otherwise fit for human food.

(6) "Establishment" means a plant or premises, including retail premises, where animals or poultry are slaughtered for human consumption, or a plant or premises, including retail premises, where meat or poultry products or meat food products are processed. The term excludes premises of a person who is the owner of the animal to be slaughtered, and the resulting product is for exclusive use by him and members of his household and his nonpaying guests and employees.

(7) "Unwholesome" means:

(a) Unsound, injurious to health or otherwise rendered unfit for human food.

(b) Consisting in whole or part of any filthy, putrid or decomposed substance.

(c) Processed, prepared, packed or held under unsanitary conditions whereby a carcass or parts thereof, or any meat or poultry product, may have become contaminated with filth or become injurious to human health.

(d) Produced in whole or in part from diseased animals or poultry, except when such disease does not ordinarily render the carcasses of such animals or poultry unfit for human consumption, or from animals or poultry which have died otherwise than by slaughter.

(8) "Official inspection mark" means the symbol formulated under the rules of the department to state that the meat, poultry or product was inspected pursuant to such rules.

(9) "Wis. inspected and passed" means the meats, meat products, poultry products and meat food products so marked have been inspected and passed under the regulations of the Wisconsin department of agriculture and were found to be sound, healthful, wholesome and fit for human food.

(10) "Wis. inspected and condemned" or "U.S. inspected and condemned" means the carcass, viscera, part of carcass, meat product or poultry product or meat food product so marked or identified is unfit for human food, or that the animal so marked has been found on antermortem, postmortem, or reinspection to be unfit for human food.

(11) "Wis. suspect" means the animal so marked is suspected of being affected with a disease or condition which may require its condemnation, in whole or in part, when slaughtered, and is subject to further examination by an inspector to determine its disposal.

(12) "Wis. retained" means the carcass, viscera, meat product, poultry product, meat food product, or other article so marked is held for further examination by an inspector to determine its disposal.

(13) "Animal" means cattle, sheep, swine, goats, horses, mules and other equines.

(14) "Carcass" means all parts, including the viscera, of slaughtered animals and poultry, capable of use as human food.

(15) "Poultry" means any domesticated fowl, including but not limited to chickens, turkeys, geese, ducks, pigeons, or guineas, but shall not include commercially slaughtered gamebirds.

(16) "Meat" means the edible part of the muscle of animals which is skeletal or which is found in the tongue, in the diaphragm, in the heart, or in the esophagus, with or without the accompanying and overlying fat, and the portions of bone, skin, sinew, nerve, and blood vessels which normally accompany the muscle tissue and which are not separated from it in the process of dressing. It does not include the muscle found in the lips, ears, or snout.

(17) "Meat by-products" means any edible part of the carcass of animals other than meat.

(18) "Product" means meat, meat products, poultry products, meat food products and meat by-products.

(19) "Person" means natural person, individual, firm partnership, corporation, company, society, and association, and every officer, agent, or employee thereof. This term shall impart either the singular or the plural, as the case may be.

(20) "Clean" means the absence of dirt, grease, waste materials, residues accumulations, filth, rubbish, garbage, insects, vermin or other unsightly, offensive or extraneous matter.

(21) "Consumer" means any household consumer, restaurant, or institution.

(22) "Potentially hazardous food" means any food which by its nature or composition may contain, or is capable of supporting rapid and progressive growth of, infectious or toxigenic microorganisms.

(23) "Premises" means a retail market, slaughter, processing or storage plant or any other building, structure or facility used in the conduct of slaughtering, processing or storage operations, and the land on which it is situated, and includes all other buildings, structures, facilities and land adjacent thereto under the ownership or control of the owner or operator used in connection with the conduct of such operations.

(24) "Process" means to manufacture, compound, intermix, or prepare meat, meat food, poultry or poultry food products for sale or as a custom service.

(25) "Retail meat market" means a plant or premises in which meat or meat food products or poultry or poultry food products are prepared, stored, handled, sold or offered for sale at retail with such sales being made primarily to household consumers only and the sale of such products to persons other than household consumers does not exceed 25% of the total dollar value of all sales, or more than \$10,000 in dollar value per year, and does not derive from curing, cooking, smoking, canning, formulation of product, or rendering operations.

(26) "Sanitize" means effective bactericidal treatment of clean surfaces of equipment and utensils by a process which has been approved by the department as being effective in destroying microorganisms, including pathogens.

(27) "Vehicle" within the meaning of these regulations means any conveyance utilized in the transport of food or food products.

(28) "Retained" or "Detained" means that the carcass, viscera, or part of carcass of meat animals or poultry or the meat or poultry food products made therefrom so marked is being held for further examination by an inspector to determine its disposition.

(29) "Capable of use as human food" applies to any carcass or part of a carcass of any animal or poultry, or animal or poultry product unless it is denatured or otherwise identified as required under Wis. Adm. Code chapter Ag 48, or is naturally inedible by humans.

(30) "Storage plant" means a plant where products as defined in this section are stored and includes locker plants and branch locker plants as defined in sections 99.01 (6) and (7), Wis. Stats.

(31) "Meat broker" means any person engaged in the business of buying or selling meat or poultry products, or meat or poultry food products on commission, or otherwise negotiating purchases or sales of such articles other than for his own account or as an employee of another person.

(32) "Renderer" means a person who receives carcasses of animals or products derived therefrom and processing them by the dry rendering process to obtain grease, tallow or fat, or other products such as blood, bone or meat meal, or collects or processes such carcasses or products for further processing at a rendering plant. The term animals as used in this subsection means and includes "animals" as defined in subsection (13) and all other animals of any kind.

(33) "Mobile slaughterer" means any person or firm engaged in the business of slaughtering animals on a custom basis for compensation at the premises of the owners of the animals being slaughtered.

(34) "Frozen food locker plant" means a locker plant as defined in section 99.01 (6), Wis. Stats., where meat or poultry products or meat food products are frozen and stored as a custom service, but where no other processing is done and includes branch locker plants as defined in section 99.01 (7), Wis. Stats., where such products are stored.

(35) "Frozen food processing plant" means an establishment where meat or poultry products are processed only by the cutting, wrapping and freezing thereof as a custom service.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (25), Register, September, 1972, No. 201, eff. 10-1-72; am. (6), (13), (14), (16), (17), (20), (23), (29) and cr. (30) to (35), Register, April, 1975, No. 232, eff. 5-1-75.

Ag. 47.03 Facilities and sanitation. (1) RESPONSIBILITY. (a) Every establishment shall be maintained and operated in conformity with the requirements of this section.

(b) Failure to maintain an establishment which complies with the requirements of this chapter shall be grounds for immediate suspension of operations, or denial or revocation of license.

(c) Licenses shall be displayed in a conspicuous place on the premises.

(2) PREMISES. (a) No establishment or holding pens shall be so located or maintained as to create a nuisance.

(b) All newly constructed establishments shall be located in accordance with applicable zoning ordinances and shall be constructed in accordance with all applicable state and local building, plumbing, and waste disposal codes. Plans for construction or alteration shall be submitted to the department for prior approval.

(c) Grounds surrounding the establishment shall be well drained and kept clean and free of accumulated rubbish or other nuisance, contamination hazard or vermin harborage.

(d) Driveways at receiving and shipping doorways shall be constructed or treated and maintained so as to minimize dust and dirt.

(3) BUILDINGS. (a) All establishment buildings shall be so constructed as to prevent the entrance or harboring of vermin and insects. Doors and windows or other openings to the outside shall be provided with screens when necessary to accomplish this.

(b) All dogs, cats, other pets and birds shall be excluded. This shall not serve to exclude seeing eye dogs from retail market areas normally accessible to customers.

(c) Floors, walls, ceilings, partitions, posts, doors and all other construction features of slaughtering rooms, processing rooms, chill rooms, or rooms where edible product is stored, shall be constructed of such material and finish that they may be readily and thoroughly cleaned and shall be kept in a clean and sanitary condition. Floors shall be constructed of hard surface concrete or other impervious materials. Any floor cracks which may develop shall be promptly repaired. Interior construction features consisting of cement blocks or other porous material, in rooms where edible products are handled, shall be treated to render such material impermeable.

(d) Floor drains shall be equipped with traps and grills which shall be so located as to drain all waste liquids. Blood traps or other methods of collecting and disposing of blood shall be provided.

(e) Structures shall be so located that the product does not become contaminated through contact with floors, walls or other structures.

(f) All portions of buildings used in the conduct of operations shall be fully separated from other portions used for living quarters by means of floors, walls, and ceilings constructed of solid concrete, brick, wood, or other impervious materials, and shall be used only for slaughtering or processing operations, or in the storage of products and for no other purposes.

(4) FACILITIES. (a) *Water supply.* The water supply shall be readily accessible, of sufficient quantity to permit compliance with the requirements of this section, and potable. There shall be no cross connection between the potable water supply and any nonpotable water supply nor with the sewage disposal system. Hot water shall be available in sufficient quantity for all cleaning purposes. Hot water for

sanitizing shall be not less than 180° F. at the point of usage. The establishment shall currently have on file in its records evidence that the water supply has been approved by the local health authority within the past calendar year. There shall be effective means to prevent back-siphonage of liquids into the potable water supply or steam lines.

(b) *Ice.* Ice shall be from potable water which meets the requirements of this section. It shall be manufactured, handled, stored, and used in a sanitary manner.

(c) *Cleaning.* A suitable area and facilities shall be provided for the cleansing and sanitizing of equipment such as hand trucks, hooks, gambrels, smokesticks, trays, boxes, and demountable processing equipment.

(d) *Lavatories.* Hand-washing sinks with hot and cold running water, soap from dispensers, and single-service towels or approved hand dryers shall be provided in slaughter rooms and in processing areas. Such hand-washing sinks shall be other than hand operated.

(e) *Lighting.* Each room shall have sufficient natural or artificial lighting for the purpose for which it is to be used. Sufficient lighting shall be present in all areas to permit adequate visibility for cleaning and sanitary inspection operations. Lights in the processing areas shall be equipped with protective shields or shatterproof bulbs. Minimum acceptable light intensities for various operations are:

1. Not less than 20 foot candles on working surfaces, except in areas where grinding, stuffing and packaging or other processing operations are carried on where the intensity shall be not less than 50 foot candles.

2. Not less than 10 foot candles intensity in coolers at a point 3 feet from the floor.

3. Not less than 5 foot candles in storage areas.

(f) *Ventilation and heating.* Ventilation shall be sufficient to control vapors, mold, objectionable odors and accumulation of condensates. Adequate heating shall be provided for comfortable working conditions in all work areas except those areas or rooms requiring refrigeration.

(g) *Pest control.* Effective measures for the control of insects and rodents shall be maintained at all times. Insecticides and rodenticides, if used, shall be only those which are approved by the department. They shall be employed by approved methods and shall be handled and stored in a safe manner, apart from food items or ingredients.

(h) *Storage facilities.* Storage facilities shall be provided for storing raw materials, packing and packaging materials, and finished products. They shall be clean, sanitary, and in good repair. Off floor storage methods which minimize deterioration and prevent contamination or other adulteration and facilitate cleaning shall be used. Shelves, cabinets, and dunnage shall be used to protect materials from contamination. Single-service articles, including cans, bottles, lids, pouches, and paper containers shall be free of contamination and maintained in sanitary boxes, cartons, or tubes or otherwise protected and handled in a sanitary manner.

(i) *Cooling and refrigeration facilities.* 1. Refrigerated space adequate for the prevention of spoilage shall be provided to chill and hold carcasses, parts and products at all slaughter facilities unless there is immediate transportation to another premises where suitable refrigeration is provided.

2. Suitable refrigerated facilities shall be provided for the storage and/or display of food products of fresh, frozen, or potentially hazardous type. The maximum temperature for storage of fresh meats or poultry products shall be + 40° F. The maximum permissible temperature for storage of frozen meat or poultry products shall be + 10° F. at the warmest point at which product is exposed.

(j) *Disposal of wastes.* Liquid wastes shall be conveyed to a public sewer or other approved waste disposal system through enclosed piping by methods or systems which will not create insanitary conditions. Floor drains shall be functional and properly trapped. Trash and rubbish shall be placed in suitable receptacles conveniently located throughout the plant. Product wastes, such as trimmings, shall be collected in suitable containers which shall be kept covered when not continuously receiving wastes. All wastes not disposed of into a sewer or other approved liquid waste disposal system shall be collected and removed from food processing area at least daily, and shall be disposed of in a sanitary and acceptable manner. Paunch contents, manure and inedible offal shall be placed in tight containers, vehicles or separate rooms so as not to create a nuisance, cause odors or attract flies.

(k) *Toilet, dressing room, and hand-washing facilities.* A sufficient number of sanitary toilets to accommodate all personnel in accordance with plumbing codes shall be provided. Toilet rooms shall be conveniently located, constructed of materials which can be easily and satisfactorily cleaned, adequately lighted and shall be separately vented to the outside. They shall be maintained in a sanitary condition and shall be constructed with tight fitting and self-closing doors and provided with a suitable exhaust fan that is vented to the outside and so installed as to assure its operation and the creation of a negative pressure within at any time the toilet facility may be used. A sign directing employes to wash their hands before returning to work shall be posted in all toilet rooms. Hand-washing facilities, including hot and cold running water, soap with dispenser and an effective, sanitary single-service means of drying the hands, shall be conveniently located in the toilet rooms and throughout the area where products are prepared.

(5) **EQUIPMENT AND UTENSILS.** (a) All utensils and equipment used in connection with the slaughtering of animals, processing of meat, storing or otherwise handling of meat, shall be of such material and construction that they may be thoroughly cleaned.

(b) Copper and its usual alloys, cadmium, and lead shall not be used in equipment contacting edible products.

(c) Equipment with painted surfaces in the product zone and containers made of enamelware or porcelain shall not be used in the handling and processing of the product.

(d) Plastic materials and resinous castings must be abrasion and heat resistant, shatterproof, nontoxic, and shall not contain a

constituent that will migrate to meat or meat product in contact with the material. All such materials shall be approved for food usage.

(e) All gasketing and packing materials must be nontoxic, nonporous, nonabsorbent, and unaffected by food products and cleaning compounds.

(f) Where necessary for proper cleaning and inspection, equipment shall be easily demountable.

(g) All bearings shall be located outside the product zone and shall be constructed with removable seals at the entrance of the shaft into the product zone.

(h) All parts of the product zone shall be free of recesses, open seams, crevices, protruding ledges, inside threads, inside shoulders, inside bolts, or rivets and bead ends.

(i) Where necessary for sanitary maintenance, equipment shall be constructed and installed so as to be completely self-draining.

(j) All safety or gear guards must be readily removable for cleaning and inspection.

(k) All parts of the product zone shall be readily accessible to sight and reach for cleaning and inspection.

(6) **SANITATION.** (a) To assure sanitary operation, all equipment, such as scalding tanks, receptacles, tubs, chutes, platforms, racks, tables, knives, saws, trays, cleavers, tools, and machinery used in moving, handling, eviscerating, skinning, dehairing, chopping, cutting, or processing animals, meat, and poultry products, shall be thoroughly cleaned immediately after each day's use, and more frequently if necessary to maintain proper sanitary condition.

(b) Floors in slaughtering and processing areas shall be cleaned immediately following each day's operation and more frequently if necessary to maintain proper sanitary condition. The cleaning of floors and walls shall be conducted in such manner and at such time as to avoid contamination of product.

(c) Hoist chains or cables shall not be permitted to come in contact with carcasses or product.

(d) Product containers shall be protected from any form of insanitary condition during storage and shall not be used for any other purpose.

(e) Properly located sanitizing facilities for cleansing and disinfecting equipment and utensils shall be provided at places in establishment where operations are likely to result in the contamination of such equipment and utensils.

(f) Meat products shipped from or to establishments shall be covered in such a way that they will be adequately protected against dust, dirt, and insects.

(g) Slack barrels and similar containers and vehicles shall be clean and lined with suitable material that will prevent contamination of meat products. Slack barrels, containers, and vehicles in which any meat product is transported shall be kept in clean and sanitary

condition. Any paper used for covering or lining slack barrels and similar containers and vehicles shall be of a kind that does not tear during use, but remains intact when moistened by the meat product.

(h) The use of burlap as a wrapping for meat is not permitted unless the meat is first wrapped with a good grade of moisture resistant paper or cloth of a kind that will prevent contamination with lint or other foreign matter.

(i) Second-hand tubs, barrels, and boxes may be used as containers of meat or meat products if they do not show any evidence of misuse, are correctly labeled, and are thoroughly cleaned and lined with moisture resistant paper or plastic before being reused.

(j) Utensils and equipment that have been used in the preparation or handling of raw meat or raw poultry shall not be used for the preparation of cooked foods or foods that are likely to be eaten without cooking, unless such utensils and equipment have been thoroughly cleaned and sanitized.

(k) Grinders, mixers, stuffers and like items that have been used in the preparation and handling of raw pork items, unless such pork has been treated or certified to destroy trichinae, shall be thoroughly cleaned and sanitized before use in the preparation of any other meat or food items.

(7) RESTRICTIONS. (a) Inedible offal and other inedible by-products shall not be rendered, boned, ground, frozen or otherwise treated with any of the utensils or equipment or stored in rooms used in the slaughtering or processing of edible products, except that the washing of offal in the slaughtering room may be permitted. The rendering or otherwise treating of inedible products shall be completely segregated in separate rooms, apart from any edible food operation. There shall be no intermingling of inedible and edible food operations or any connection between areas used for such operations, except that:

1. There may be one self-closing connecting doorway between the slaughtering or viscera separating department and the inedible rendering department.

2. Pipes, conveyors or chutes may be installed in a manner approved by the department to convey inedible or condemned materials from edible product departments to the inedible rendering areas.

(b) Dead animals, which have died by means other than slaughter or any parts of such animals, shall not be received or kept on the premises of an establishment. Animals which have died in transit may be unloaded for immediate disposal.

(c) No person shall knowingly receive or keep on premises of an establishment any animal which is obviously emaciated or ravaged by disease, or any animal which has been subjected to any substance or drug which might cause a chemical or biological residue to be present in the tissues.

(d) No person shall conduct an inedible rendering operation on the premises of an establishment, except to render by-products of his own slaughtering operation.

(e) Inedible products which closely resemble an edible product, or which are capable of use as human food, shall be placed in containers plainly marked "Inedible" and segregated from edible products. Such containers while in the work processing area shall be reasonably clean, free from odors, accumulated residues, rust and not constitute a health hazard or nuisance.

(f) Inedible products, described in paragraph (e), held at the establishment for further sale or disposition for rendering or use as animal feed, shall be plainly marked or identified "INEDIBLE (SPECIES) NOT FOR HUMAN CONSUMPTION". Transportation or removal of such products from the establishment shall be in conformity with Wis. Adm. Code chapter Ag 48.

(g) Carcass meat or finished product shall not be taken into or through the slaughter room at any time when slaughtering operations are being conducted.

(h) The slaughter room shall not be used for other operations such as processing or packaging at the same time that slaughter operations are being conducted, nor shall it be used as a storage area.

(i) Manure, offal or other inedible by-product shall not be permitted to accumulate in or around any establishment or retail meat market.

(j) Spitting or urinating on floors or into floor drains shall be prohibited.

(k) Smoking is prohibited in all processing areas or other places where meat or meat product is handled in open containers.

(l) No person afflicted with a communicable disease or who has a discharging or infected wound, sore or lesion on hands, arms or other exposed portion of the body shall be permitted to handle foods or food processing equipment.

(m) Persons engaged in handling or processing food products shall wear clean and washable outer clothing, and shall wear head covering or hair nets. Clothing, head covering or hair nets shall be of such types as to prevent accidental contamination of product by body or facial hair, cosmetics, medications or similar substances.

(8) REJECTION OF FACILITIES OR EQUIPMENT. The department may attach a reject tag to utensils, rooms, containers or any other equipment or facilities constructed or maintained in violation of these rules, or which because of their insanitary or unclean condition could lead to the contamination of product. Equipment or facilities so tagged may not be used until brought into compliance with these rules and the reject tag is removed by a department representative.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; cr. (8), Register, September, 1972, No. 201, eff. 10-1-72; am. (4) (d), (7) (a), (e) and (f), cr. (3) (f), Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.04 Plant alterations; time limit. If in the opinion of the department, it is necessary that alterations, additions or changes be made in an establishment, or equipment, a written notice shall be given or mailed to the operator of such plant, requiring such alterations, additions, or changes to be made within 60 days; provided, however, that if the required alterations cannot be made with

reasonable diligence within 60 days, the department may extend the time not to exceed 180 days from receipt of notice. Failure to comply with such department directive shall be grounds for license revocation or suspension.

History: Cr. Register, September 1971, No. 189, eff. 10-1-71.

Ag 47.05 Applicability. **History:** Cr. Register, September, 1971, No. 189, eff. 10-1-71; r. Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.06 Transportation of meat and poultry. (1) **TRANSPORTATION AND STORAGE.** No person shall sell, transport, store, or offer for sale, transportation or storage, or receive for transportation or storage, any carcass or product capable of use as human food unless such carcass or product and its container, if any, is plainly labeled, marked or identified as required under this chapter.

(2) **FACILITIES AND HANDLING.** (a) Vehicles and transportation facilities used in transporting meats, meat foods, poultry or poultry food products shall be constructed and maintained so as to assure that product arrives at its destination in a wholesome and unadulterated condition.

(b) Unwrapped product shall be transported in enclosed vehicles equipped with tight fitting doors, and shall be protected from contamination from walls or floors.

(c) Transportation facilities shall be such that will assure delivery of chilled product at destination with an internal temperature of not more than +40° F.

(3) **EXEMPTIONS.** (a) The provisions of subsection (2) relating to transportation shall not apply to custom or farm slaughtered carcasses or product, transported by the owner thereof, except that any such product determined to be unwholesome or adulterated shall be excluded from any retail market, processing plant, or storage facility engaged in providing meat or poultry processing services to the public, and if found therein shall be subject to seizure, retention and/or condemnation.

(b) The provisions of subsection (1) do not apply to the transportation, by individuals, of carcasses or products resulting from the slaughter or processing by them of animals of their own raising exclusively for their own use and members of their household and non-paying guests and employees.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; r. and recr. Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.07 Seizure, retention, condemnation and disposition of unwholesome, adulterated or misbranded products. (1) The department may seize, retain or apply holding orders to any products in any establishment, retail market, frozen locker plant, frozen food processing plant, storage facility and warehouse, or any other premises or establishment where such products are processed, stored or held for sale or distribution, or which are in the channels of transportation, that are, or are suspected of being, unwholesome, adulterated, or misbranded for further examination, analysis or disposition. If the situation requires, products in transportation may be placed in commercial storage facilities, under retention or holding order, in the account of the consignor.

(2) Products determined to be unwholesome shall be condemned wherever located.

(3) Products determined to be adulterated or misbranded may be retained to be reworked or further processed to correct deficiencies, or condemned if such deficiencies cannot be corrected.

(4) Products processed at any establishment on a custom basis shall be subject to the same rules of seizure, retention and condemnation as prescribed herein as any other products with respect to conditions of disease, parasitic infection, unwholesomeness, presence of harmful chemical, biological or antibiotic residues, or any other condition which would render it potentially harmful to human health or cause it to be a potentially hazardous food.

(5) It shall be the responsibility of the owner or operator of any establishment to examine all products, including products processed on a custom basis, prior to their entry into processing or storage areas, and to exclude any product found to be unwholesome or otherwise contaminated with any objectionable matter or filth, or to require immediate isolation of such products or their cleaning or trimming as necessary to remove such condition. Department inspectors shall require the immediate removal of such unwholesome or contaminated product if found in edible processing or storage areas. If such product is not promptly removed as required, it may be seized or condemned by the inspector.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; r. and recr. Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.08 Composition, formulation and labeling of meat, meat food products, poultry and poultry food products. (1) **COMPOSITION.** The composition of any meat, meat food, poultry, or poultry food product, whether or not in naturally occurring, processed, or composited and processed form, that is prepared, stored, handled, sold or offered for sale in any establishment or retail market shall comply with the definitions and standards of identity for such products as provided in chapter 97, Wis. Stats., and rules issued by the department.

(2) **LABELING.** (a) Any composited meat or poultry food product sold or offered for sale must bear an appropriate label stating that true name of the product, ingredients, the name and address of the processor or distributor and the net weight and inspection legend, except that product prepared and sold at a retail market or sold from bulk lots in retail counters may be accompanied by a counter tag showing the name of the product, a listing of ingredients, and the name and address of the processor, if other than the establishment in which being sold.

(b) All labels and labeling information used in the labeling of products in licensed meat establishments shall be submitted to the department for approval prior to use. The department may seize and destroy all unauthorized labels.

(c) Labels accompanying bulk shipment of products to be repackaged shall not bear the inspection legend, unless the product is shipped to an official establishment for repackaging under inspection supervision.

(d) Any noncomposited product sold or offered for sale in packaged form as a consumer sized lot in any self-service sales facility shall bear an appropriate label showing the true name of the product, the net weight, and the name and address of the processor.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; renum. (2) (b) to be (2) (d) and cr. (2) (b) and (c), Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.09 Custom slaughter, farm slaughter, horse slaughter, game, meat animals not defined. (1) **CUSTOM SLAUGHTER.** (a) Establishments doing custom slaughter or custom processing shall do so on designated hours or days apart from the regular inspection schedule.

(b) All primal parts and detached organs of animals custom slaughtered or processed shall be plainly marked by the slaughterer, or operator of the establishment where such animals are slaughtered or processed or by his agents or employes, immediately after slaughter, or if not slaughtered at such establishment, at the time of entering the establishment, with the establishment or identification number assigned by the department and the words "NOT FOR SALE". The words "NOT FOR SALE" shall be in block letters not less than $\frac{3}{8}$ inch in height. All boxes, cartons, packages or containers containing products custom processed shall be similarly marked at the time of packaging. Stamps, brands and marks for this purpose shall be approved by the department. This paragraph shall apply to all persons engaged in custom slaughtering or processing, including a mobile slaughterer.

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(c) Any meat or parts, such as head meat, tongues, hearts, fat, trimmings, saved from non-inspected, custom slaughtered or processed animals, shall not be offered for sale for human consumption, or combined with inspected products that are offered for sale.

(d) There shall be effective segregation in all facilities and operations at all times to prevent the commingling of inspected and non-inspected product.

(2) **RECORDS.** The operator of any establishment, or any other premises doing custom slaughter or custom processing shall keep records and submit reports as required by the department.

(3) **FARM SLAUGHTER AND GAME ANIMALS.** Animals slaughtered on the farm, and game animals or other animals used for meat, may be processed at establishments under the same provisions as Custom Slaughter, provided they are clean, apparently wholesome, and are handled, stored, and prepared so as to prevent the contamination of other food products handled, stored, or prepared at the establishment.

(4) **REQUEST FOR INSPECTION.** When inspection is requested for custom slaughter, a request by the owner shall be submitted to the establishment. When inspection is furnished for custom slaughter, it shall be done at regularly scheduled times. Any other inspection shall be done at the overtime rate and shall be charged to the establishment. Custom animals inspected shall be subject to all other regulation in this chapter.

(5) **HORSE SLAUGHTER.** The slaughter of horses, mules and other equines and the preparation and handling of the products thereof shall be conducted in establishments separate from those used for the slaughter and preparation of other products. All carcasses, parts, meat, meat food products, or other products thereof shall be conspicuously labeled, marked, branded, or tagged "Horse Meat" or "Horse Meat Product" by a method approved by the department.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (1) (b) and (5), Register, September, 1972, No. 201, eff. 10-1-72; am. (1) (b) and (5), Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.10 Inspection marks and establishment numbers. (1) ESTABLISHMENT NUMBER. An official number shall be assigned to each establishment where continuous state meat inspection is conducted. Such numbers shall be used to identify all meat and meat products inspected and passed. Two or more establishments under the same ownership may be granted the same official numbers, provided a serial letter is added in each case to identify each establishment and the products thereof.

(2) **INSPECTION MARKS.** (a) All carcasses that have been inspected and found to be sound, healthful, wholesome, and fit for human food shall be marked, "Wis. Inspected and Passed". Each primal part of a carcass, beef cod fat, beef kidney fat, each liver, beef tongue and beef heart shall be so marked.



(b) Carcasses or parts that have been inspected and found to be fit for human food or use only after cooking shall be tagged and/or marked, "Passed for Cooking."

(c) Carcasses or parts that have been inspected and found to be suitable for human food or other use only after proper refrigeration shall be tagged or marked, "Retained for Refrigeration."

(d) Carcasses, parts or meat products that have been inspected and found to be unfit for human food shall be marked or tagged, "Wis. Insp'd and CONDEMNED."

**WIS. INSP'D AND
CONDEMNED**

(e) Carcasses, parts, viscera or meat products held for further examination by an inspector to determine its disposal shall be tagged, "Wis. Retained," or placed under department holding order.

(f) Only harmless ink approved by the department shall be used in marking carcasses or parts thereof.

(3) **INSPECTED PROCESSED PRODUCTS.** All meat food products processed for sale under department inspection shall plainly bear a legible official inspection mark on the label reading "WIS. DEPT. AGR. INSPECTED" and the establishment number. Where limitations of space apply, the word "INSPECTED" may be abbreviated as "INSP'D." Labels within the meaning of this subsection means a display of any printing, lithographing, embossing, sticker, seals, or other written, printed or graphic matter upon the immediate package or container of any product, not including package liners.



(4) **CONTROL AND USE OF BRANDS AND MARKING DEVICES.** All brands and devices, except custom processed brands, for marking articles with the inspection legend shall be used only under the supervision of a department employee, and when not in use for marking, shall be kept locked in properly equipped lockers or compartments the keys of which shall not leave the possession of a department employee.

(5) **INSPECTION MARKS; FORGING, COUNTERFEITING, IMPROPER USE AND HANDLING.** (a) No person shall forge, counterfeit, simulate, or falsely represent, or without proper authority, use, detach, or knowingly or wrongfully alter, deface, or destroy any of the marks, stamps, tags, labels, or other identification devices provided for herein.

(b) Any additional brands required shall be furnished by the establishment.

(c) No person or establishment shall, without the express written approval of the department, create, or order the manufacture of any brands, stamps, or devices which incorporate the official Wisconsin inspection legend, or facsimile thereof.

(d) The control and title of any brands, whether furnished by the department, or manufactured for the establishment with the approval of the department, shall in the event of discontinuance of inspection in the establishment, remain with the department.

Ag 47.11 Prescribed treatment of pork and products containing pork to destroy trichinae. (1) **PRODUCTS.** Products named in this subsection and products of the character thereof, containing pork muscle tissue (including hearts, pork stomachs, and pork livers), or the pork muscle tissue which forms an ingredient of such products, shall be effectively heated, refrigerated, or cured to destroy any possible live trichinae; bologna; frankfurts; viennas; smoked sausage, knoblach sausage; mortadella; all forms of summer or dried sausage, including mettwurst; ground meat mixtures containing pork and beef, veal, lamb, mutton or goat meat and prepared in such a manner that they might be eaten rare or without thorough cooking; flavored pork sausage such as those containing wine or similar flavoring materials; cured pork sausage; sausage containing cured and/or smoked pork; cooked loaves; roasted, baked, boiled, or cooked hams; pork shoulders, or pork shoulder picnics; Italian-style hams; Westphalia-style hams; smoked boneless pork shoulder butts; cured meat rolls, capocollo (capicola, capacola); coppa; fresh or cured boneless pork shoulder butts, hams, loins, shoulders, shoulder picnics, and similar pork cuts, in casings or other containers in which ready-to-eat delicatessen articles are customarily enclosed (excepting Scotch-style hams); breaded pork products, cured boneless pork loins; boneless back bacon; smoked pork cuts such as hams, shoulders, loins and pork shoulder picnics (excepting smoked hams and smoked pork shoulder picnics which are specially prepared for distribution in tropical climates or smoked hams delivered to the armed services). Cured boneless pork loins shall be subjected to prescribed treatment for destruction of trichinae prior to being shipped from the establishment where cured.

(2) **TREATMENT.** Treatment shall consist of heating, refrigeration, curing, as follows:

(a) *Heating.* 1. All parts of the pork muscle tissue shall be heated to a temperature not lower than 137° F., and the method used shall be one known to insure such a result. On account of differences in methods of heating and in weights of products undergoing treatment it is impracticable to specify details of procedures for all cases.

2. Procedures which insure proper heating of all parts of the product shall be adopted. It is important that each piece of sausage, each ham, and other product treated by heating in water be kept entirely submerged throughout the heating period; and that the largest pieces in a lot, the innermost links of bunched sausage or other massed articles, and pieces placed in the coolest part of a heating cabinet or compartment or vat be included in the temperature tests.

(b) *Refrigerating.* 1. At any stage of preparation and after preparatory chilling to a temperature of not above 40° F. or preparatory freezing, all parts of the muscle tissue of pork or pork product containing such tissue shall be subjected continuously to a temperature not higher than one of those specified in Table 1, the duration of such refrigeration at the specified temperature being dependent on the thickness of the meat or inside dimensions of the container.

TABLE 1—REQUIRED PERIOD OF FREEZING AT TEMPERATURE INDICATED

°F.	Temperature	
	Group 1 Days	Group 2 Days
5.....	20	30
—10.....	10	20
—20.....	6	12
—30 or below.....	momentary attainment	

2. Group 1 comprises product in separate pieces not exceeding 6 inches in thickness, or arranged on separate racks with the layers not exceeding 6 inches in depth, or stored in crates or boxes not exceeding 6 inches in depth, or stored as solidly frozen blocks not exceeding 6 inches in thickness.

3. Group 2 comprises product in pieces, layers, or within containers, the thickness of which exceeds 6 inches but not 27 inches, and product in containers including tierces, barrels, kegs, and cartons having a thickness not exceeding 27 inches.

4. The product undergoing such refrigeration or the containers thereof shall be so spaced while in the freezer as will insure a free circulation of air between the pieces of meat, layers, blocks, boxes, barrels, and tierces in order that the temperature of the meat throughout will be promptly reduced to not higher than 5° F., —10° F., or —20° F., as the case may be.

(c) *Curing*. 1. Sausage. Sausage may be stuffed in animal casings, hydrocellulose casings, or cloth bags. During any stage of treating the sausage for the destruction of live trichinae, except as provided in Method 5, these coverings shall not be coated with paraffin or like substance, nor shall any sausage be washed during any prescribed period of drying. In the preparation of sausage, one of the following methods may be used:

a. Method No. 1. The meat shall be ground or chopped into pieces not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than 3½ pounds of salt to each hundred weight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After being stuffed, sausage having a diameter not exceeding 3½ inches, measured at the time of stuffing shall be held in a drying room not less than 20 days at a temperature not lower than 45° F., except that in sausage of the variety known as pepperoni, if in casings not exceeding 1½ inches in diameter measured at the time of stuffing, the period of drying may be reduced to 15 days. In no case, however, shall the sausage be released from the drying room in less than 25 days from the time the curing materials are added, except that sausage of the variety known as pepperoni, if in casings not exceeding the size specified, may be released at the expiration of 20 days from the time the curing materials are added. Sausage in casings exceeding 3½ inches, but not exceeding 4 inches, in diameter at the time of stuffing, shall be held in a drying room not less than 35 days at a temperature not lower than 45° F., and in no case shall the sausage be released from the drying room in less than 40 days from the time the curing materials are added to the meat.

b. Method No. 2. The meat shall be ground or chopped into pieces not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than $3\frac{1}{2}$ pounds of salt to each hundred weight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After being stuffed, the sausage having a diameter not exceeding $3\frac{1}{2}$ inches, measured at the time of stuffing, shall be smoked but not less than 40 hours at a temperature not lower than 80° F., and finally held in a drying room not less than 10 days at a temperature not lower than 45° F. In no case, however, shall the sausage be released from the drying room in less than 18 days from the time the curing materials are added to the meat. Sausage exceeding $3\frac{1}{2}$ inches, but not exceeding 4 inches, in diameter at the time of stuffing, shall be held in a drying room, following smoking as above indicated, not less than 25 days at a temperature not lower than 45° F., and in no case shall the sausage be released from the drying room in less than 33 days from the time the curing materials are added to the meat.

c. Method No. 3. The meat shall be ground or chopped into pieces not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than $3\frac{1}{2}$ pounds of salt to each hundred weight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After admixture with the salt and other curing materials and before stuffing, the ground or chopped meat shall be held at a temperature not lower than 34° F. for not less than 36 hours. After being stuffed the sausage shall be held at a temperature not lower than 34° F. for an additional period of time sufficient to make a total of not less than 144 hours from the time the curing materials are added to the meat, or the sausage shall be held for the time specified in a pickle-curing medium of not less than 50° strength (salometer reading) at a temperature not lower than 44° F. Finally, the sausage having a diameter not exceeding $3\frac{1}{2}$ inches, measured at the time of stuffing, shall be smoked for not less than 12 hours. The temperature of the smokehouse during this period at no time shall be lower than 90° F.; and for 4 consecutive hours of this period the smokehouse shall be maintained at a temperature not lower than 128° F. Sausage exceeding $3\frac{1}{2}$ inches, but not exceeding 4 inches, in diameter at the time of stuffing shall be smoked, following the prescribed curing, for not less than 15 hours. The temperature of the smokehouse during the 15-hour period shall at no time be lower than 90° F., and for 7 consecutive hours of this period the smokehouse shall be maintained at a temperature not lower than 128° F. In regulating the temperature of the smokehouse for the treatment of sausage under this method, the temperature of 128° F. shall be attained gradually during a period not less than 4 hours.

d. Method No. 4. The meat shall be ground or chopped into pieces not exceeding one-fourth of an inch in diameter. A dry-curing mixture containing not less than $2\frac{1}{2}$ pounds of salt to each hundred weight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After admixture with the salt and other curing materials and before stuffing, the ground or chopped sausage shall be held as a compact mass, not more than 6 inches in depth, at a temperature not lower than 36° F., for not less than 10 days. At the termination of the holding period, the sausage shall be stuffed in casings or cloth bags not exceeding $3\frac{1}{2}$ inches in diameter measured at the time of stuffing. After being stuffed, the sausage shall be held in a

drying room at a temperature not lower than 45° F. for the remainder of a 35-day period, measured from the time the curing materials are added to the meat. At any time after stuffing, if a concern deems it desirable, the product may be heated in a water bath for a period not to exceed 3 hours at a temperature not lower than 85° F., or subjected to smoking at a temperature not lower than 80° F., or the product may be both heated and smoked as specified. The time consumed in heating and smoking, however, shall be in addition to the 35-day holding period specified.

e. Method No. 5. The meat shall be ground or chopped into pieces not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than 3½ pounds of salt to each hundred weight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After being stuffed the sausage shall be held for not less than 65 days at a temperature not lower than 45° F. The coverings for sausage prepared according to this method may be coated at any stage of the preparation before or during the holding period with paraffin or other substance approved by the director of the division.

2. Capocollo (capicola, capacola). Boneless pork butts for capocollo shall be cured in a dry-curing mixture containing not less than 4½ pounds of salt per hundred weight of meat for a period of not less than 25 days at a temperature not lower than 36° F. If the curing materials are applied to the butts by the process known as churning, a small quantity of pickle may be added. During the curing period the butts may be overhauled according to any of the usual processes of overhauling, including the addition of pickle or dry salt, if desired. The butts shall not be subjected during or after curing to any treatment designed to remove salt from the meat, except that superficial washing may be allowed. After being stuffed, the product shall be smoked for a period of not less than 30 hours at a temperature not lower than 80° F., and shall finally be held in a drying room not less than 20 days at a temperature not lower than 45° F.

3. Coppa. Boneless pork butts for coppa shall be cured in a dry-curing mixture containing not less than 4½ pounds of salt per hundred weight of meat for a period of not less than 18 days at a temperature not lower than 36° F. If the curing mixture is applied to the butts by the process known as churning, a small quantity of pickle may be added. During the curing period the butts may be overhauled according to any of the usual processes of overhauling, including the addition of pickle or dry salt if desired. The butts shall not be subjected during or after curing to any treatment designed to remove salt from the meat, except that superficial washing may be allowed. After being stuffed, the product shall be held in a drying room not less than 35 days at a temperature not lower than 45° F.

4. Hams. In the curing of hams either of the following methods may be used:

a. Method No. 1. The hams shall be cured by a dry-salt curing process not less than 40 days at a temperature not lower than 36° F. The hams shall be laid down in salt, not less than 4 pounds to each hundred weight of hams, the salt being applied in a thorough manner to the lean meat of each ham. When placed in cure, the hams may be

pumped with pickle if desired. At least once during the curing process the hams shall be overhauled and additional salt applied, if necessary, so that the lean meat of each ham is thoroughly covered. After removal from cure the hams may be soaked in water at a temperature not higher than 70° F. for not more than 15 hours, during which time the water may be changed once; but they shall not be subjected to any other treatment designed to remove salt from the meat, except that superficial washing may be allowed. The hams shall finally be dried or smoked not less than 10 days at a temperature not lower than 95° F.

b. Method No. 2. The hams shall be cured by a dry-salt curing process at a temperature not lower than 36° F. for a period of not less than 3 days for each pound of weight (green) of the individual hams. The time of cure of each lot of hams placed in cure should be calculated on a basis of the weight of the heaviest ham of the lot. Hams cured by this method, before they are placed in cure, shall be pumped with pickle solution of not less than 100° strength (salometer), about 4 ounces of the solution being injected into the shank and a like quantity along the flank side of the body bone (femur). The hams shall be laid down in salt, not less than 4 pounds of salt to each hundred weight of hams, the salt being applied in a thorough manner to the lean meat of each ham. At least once during the curing process the hams shall be overhauled and additional salt applied, if necessary, so that the lean meat of each ham is thoroughly covered. After removal from the cure the hams may be soaked in water at a temperature not higher than 70° F. for not more than 4 hours, but shall not be subjected to any other treatment designed to remove salt from the meat, except that superficial washing may be allowed. The hams shall then be dried or smoked not less than 48 hours at a temperature not lower than 80° F., and finally, shall be held in a drying room not less than 20 days at a temperature not lower than 45° F.

5. Boneless pork loins and loin ends. a. In lieu of heating or refrigerating to destroy trichinae in boneless loins, the loins shall be cured for a period of not less than 25 days at a temperature not lower than 36° F. by the use of one of the following methods:

1. Method No. 1. A dry-salt curing mixture containing not less than 5 pounds of salt to each hundred weight of meat.

2. Method No. 2. A pickle solution of not less than 80° strength (salometer) on the basis of not less than 60 pounds of pickle to each hundred weight of meat.

3. Method No. 3. A pickle solution added to the approved dry-salt cure provided the pickle solution is not less than 80° strength (salometer).

b. After removal from cure, the loins may be soaked in water for not more than 1 hour at a temperature not higher than 70° F. or washed under a spray but shall not be subjected, during or after the curing process, to any other treatment designed to remove salt.

c. Following curing, the loins shall be smoked for not less than 12 hours. The minimum temperature of the smokehouse during this period at no time shall be lower than 100° F., and for 4 consecutive hours of this period the smokehouse shall be maintained at a temperature not lower than 125° F.

d. Finally, the product shall be held in a drying room for a period of not less than 12 days at a temperature not lower than 45° F.

(3) **GENERAL INSTRUCTIONS.** When necessary to comply with these instructions, the smokehouses, drying rooms, and other compartments used in the treatment of pork to destroy trichinae shall be suitably equipped, by the establishment, with accurate automatic recording thermometers. Inspectors in charge are authorized to approve for use in sausage smokehouses, drying rooms, and other compartments, such automatic recording thermometers as are found to give satisfactory service.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; r. (4) Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.12 Canning with heat processing and hermetically sealed containers; cleaning containers; closure; code marking; meat processing; incubation. (1) Containers shall be cleaned thoroughly immediately before filling, and precaution must be taken to avoid soiling the inner surfaces subsequently.

(2) Containers of metal, glass or other material shall be washed in an inverted position with running water at a temperature of at least 180° F. The container-washing equipment shall be provided with a thermometer to register the temperature of the water used for cleaning the containers. In lieu of cleaning with hot water the use of efficient jet-vacuum type equipment for cleaning cans and jars is permitted before filling.

(3) Nothing less than perfect closure is acceptable for hermetically sealed containers. Heat processing shall follow promptly after closing.

(4) Careful inspection shall be made of the containers by competent establishment employees immediately after closing, and containers which are defectively filled, defectively closed or those showing inadequate vacuum, shall not be processed until the defect has been corrected. The containers shall again be inspected by establishment employees when they have cooled sufficiently for handling after processing by heating. The contents of defective containers shall be condemned unless correction of the defect is accomplished within 6 hours following the sealing of the containers or completion of the heat processing, as the case may be, except that if the defective condition is discovered during an afternoon run the cans of product may be held in coolers at a temperature not exceeding 38° F. under conditions that will promptly and effectively chill them until the following day when the defect may be corrected; short vacuum or overstuffed cans of product which have not been handled in accordance with the above may be incubated under division supervision, after which the cans shall be opened and the sound product passed for food; and short vacuum or overstuffed cans of product of a class permitted to be labeled, "Perishable, keep under refrigeration," and which have been kept under adequate refrigeration since processing may be opened and the sound product passed for food.

(5) Canned products shall not be passed unless after cooling to atmospheric temperature, they show the external characteristics of sound cans; that is, the cans shall not be overfilled; they shall have concave sides, excepting the seam side, and all ends shall be concave;

there shall be no bulging; the sides and ends shall conform to the product; and there shall be no slack or loose tin.

(6) All canned products shall be plainly and permanently marked on the containers by code or otherwise with the identity of the contents and date of canning. The code used and its meaning shall be on record in the office of the inspector in charge.

(7) Canned product must be processed at such temperature and for such period of time as will assure keeping without refrigeration under usual conditions of storage and transportation when heating is relied on for preservation, with the exception of those canned products which are processed without steam-pressure cooking by permission of the meat inspection division of the department, and labeled "Perishable, keep under refrigeration."

(8) Lots of canned product shall be identified during their handling preparatory to heat processing by tagging the baskets, cages or cans with a tag which will change color on going through the heat processing or by other effective means so as to positively preclude failure to heat process after closing.

(9) (a) Facilities shall be provided to incubate at least representative samples of the product of fully processed canned product. The incubation shall consist of holding the canned product for at least 10 days at about 98° F.

(b) The extent to which incubation tests shall be required depends on conditions such as the record of the establishment in conducting canning operations, the extent to which the establishment furnishes competent supervision and inspection in connection with the canning operations, the character of the equipment used, and the degree to which such equipment is maintained at maximum efficiency. Such factors shall be considered by the inspector in charge in determining the extent of incubation testing at a particular establishment.

(c) In the event of a failure by an establishment to provide suitable facilities for incubation of test samples, the inspector in charge may require holding of the entire lot under such conditions and for such period of time as may, in his discretion, be necessary to establish the stability of the product.

(d) The inspector in charge may permit lots of canned product to be shipped from the establishment prior to completion of sample incubation when he has no reason to suspect unsoundness in the particular lots, and under circumstances which will assure the return of the product to the establishment for reinspection should such action be indicated by the incubation results.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71.

Ag 47.13 Time of inspection. (1) **DAYS AND HOURS.** Each establishment shall notify the department in writing of the hours or days of the week in which slaughtering or processing is conducted. The department, for the most efficient and economic utilization of inspector personnel, may require that all slaughtering and processing operations be confined to certain hours or days and establish inspection schedules designating the hours or days in which slaughtering or processing operations may be conducted.

(2) (a) **OVERTIME INSPECTION.** Establishments requiring overtime inspections shall reimburse the department at uniform rates commensurate with actual costs as determined by the department.

(b) "Overtime" for the purposes of this chapter means any time when meat inspection personnel are requested to work in an establishment, as follows:

1. Each Saturday or Sunday.
2. New Year's Day, Memorial Day, Independence Day, Labor Day, Thanksgiving Day, Christmas Day. If any such holiday falls on Sunday, the succeeding Monday shall be a holiday.
3. The afternoons before Christmas and New Year's Day.
4. Good Friday—½ day.
5. Before 6 a.m. or after 6 p.m.
6. In excess of 40 hours of "straight time" in any calendar week.
7. At any time other than a regularly scheduled slaughter period.

(3) **ABSENCE OF INSPECTOR.** Whenever the inspector assigned by the department or any cooperating agency is not present at the commencement of slaughtering operations for which inspection is required, no person shall slaughter any animals or poultry for the purpose of selling the products thereof for human food without notifying and receiving instructions from the department concerning procedures to be followed or action to be taken with respect to slaughtering operations. The department shall take all steps possible to provide alternative inspection to facilitate continuation of operations without the imposition of any undue burden on such slaughtering operations.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (2) (a), Register, September, 1972, No. 201, eff. 10-1-72; am. (1) and cr. (3), Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.14 County and municipal inspection. Counties and municipalities desiring to enter into a cooperative agreement pursuant to section 97.20(5), Wis. Stats., for approved county or municipal inspection shall make application to the department in writing. The department shall investigate and evaluate the county or municipal meat inspection and enforcement program. If in the opinion of the department the county or municipal inspection and enforcement programs are in substantial accord with inspection carried on by the department, a cooperative agreement may be approved.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71.

Ag 47.15 Appeals. Appeals from the decision of any department inspector may be made to the department by the operator of any establishment.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71.

Ag 47.16 Antemortem inspection. (1) **SCOPE OF INSPECTION.** All animals shall receive an antemortem inspection on the day of slaughter at the establishment where they are to be slaughtered.

(2) **FACILITIES FOR INSPECTION.** (a) Pens where animals are held for inspection shall have adequate natural or artificial light during the hours inspection is performed.

(b) Pens, stocks or chutes shall be provided where individual animals can be examined conveniently and safely.

(c) Establishments shall provide personnel to assist in the handling and restraining of animals being examined.

(3) **SUSPECT ANIMALS.** (a) All animals that, on antemortem inspection, do not plainly show but are suspected of being affected with any disease or condition which may cause condemnation in whole or in part on postmortem inspection, shall be tagged "Suspect" so as to retain their identity until final postmortem inspection has been made. No animal tagged "Suspect" shall have tag removed except by a departmental employe or under his supervision.

(b) No animal classified "Suspect" shall be released for a purpose other than slaughter, without prior approval of the department. The reason for requesting the release shall be submitted in writing and signed by the owner of the animal.

(4) **ANTEMORTEM CONDEMNATION.** All animals plainly showing on antemortem inspection any disease or condition that would cause the carcass to be unfit for human consumption, shall be condemned. Condemned animals shall be marked "Wis. inspected and condemned" and shall not be slaughtered in the establishment. Such animals shall be disposed of under the supervision of the department.

(5) **ANIMALS SUBJECT TO CONDEMNATION.** (a) Animals received in a dead or dying condition shall be condemned. Causes for condemnation on antemortem inspection may include, but is not limited to, severe manifestations of the following conditions:

1. Elevated temperature
2. Cripples and downers
3. Malignant neoplasms
4. Multiple abscesses
5. Immaturity
6. Emaciation
7. Icterus
8. Polyarthritis
9. Central nervous diseases
10. Edema or anasarca

(b) Swine with temperatures 106° F. or higher, and cattle, sheep and goats with temperatures 105° F. or higher, will be condemned or held for a reasonable period of time for observation. Animals not returning to normal temperature ranges will be condemned. Those returning to normal temperatures may be admitted to slaughter at the discretion of the inspector.

(c) Animals that are known reactors to the tuberculin test shall be marked and treated as suspects.

(d) Animals suspected of having been treated or exposed to any substance in a manner which may impart a biological residue or reaction that may make the edible tissues of the animal unwholesome or otherwise unfit for human food, shall be marked "Suspect." The animals shall be held under custody of department employee or other responsible official supervision until it can be expected that metabolic processes have reduced the residue or reaction sufficiently to make the tissues of the animal fit for human food.

(e) Any animals with vesicular condition or other reportable disease shall be reported immediately to state and federal animal health officials. Such animals will be held back from slaughter for further observation and diagnostic tests. Final disposition of these animals shall be dependent upon the identification of the disease.

(6) **EMERGENCY SLAUGHTER.** (a) Animals accidentally injured may be slaughtered on an emergency basis if they are submitted for slaughter within 24 hours after the injury was incurred. In all cases of emergency slaughter, the animals shall be inspected immediately before slaughter. When the necessity for emergency slaughter exists, the establishment shall notify the meat inspector so that such inspection may be made. In the absence of a department inspector, a licensed practicing veterinarian may be called at the establishment's expense, and such veterinarian shall submit a written statement of his findings to the department.

(b) All animals submitted for emergency slaughter shall be accompanied by a certificate signed by the owner or custodian of the animal at the time of injury providing the following information:

1. Name and address of owner or custodian.
2. Type of injury, including time and date the injury was incurred.
3. Any drugs administered to the animal within 30 days prior to its submission for emergency slaughter, either as a feed additive, or in treatment of the injury, and the last date such drugs were administered.

(7) **ANIMALS HELD FOR TREATMENT.** Animals with symptoms of disease which appear amenable to treatment may be held for treatment and observation at the slaughter establishment separate and apart from other animals on the premises, under the supervision of the inspector.

(8) **DOWNER ANIMALS.** (a) Animals which are unable to stand or walk unassisted (downer animals) and which do not qualify for emergency slaughter may be received and slaughtered only during regularly scheduled times when a veterinarian employed by the department is on duty.

(b) Any downer animal submitted for slaughter shall be accompanied by a certificate signed by the owner or custodian of the animal providing the following information:

1. Name and address of owner or custodian.

2. Date that the animal became a downer and the cause of the animal's condition, if known.

3. Any drugs administered to the animal within 30 days prior to its submission for slaughter, either as a feed additive, or in treatment for any condition, and the last date such drugs were administered.

(c) Downer animals may be received for slaughter and processing only at plants maintaining adequate facilities for the humane unloading, transport, and holding of such animals. Facilities shall include separate holding pens and skids, mats, or trucks for the moving of downer animals. Downer animals shall not be dragged by the neck, or subjected to any other unnecessary mistreatment or abuse. All downer animals shall be unloaded prior to antemortem inspection. Such inspections may not be performed on the truck.

(d) Downer animals shall be held for 24 hours for further observation where the cause of the animal's condition cannot be readily determined. Animals which have been treated with drugs for which the prescribed withdrawal time has not been observed shall be condemned or held until the withdrawal times have been met.

(e) Downer animals condemned on antemortem inspection shall be killed and injected with carbolic or cresylic acid or other approved denaturant and sent to rendering. Under no circumstances will animals condemned on antemortem inspection be dressed out on the premises.

(f) Any trimming of carcasses on postmortem inspection shall be done before the carcass enters the chill cooler.

(g) Facilities or equipment coming in contact with any condemned animal or part thereof shall be thoroughly cleaned and sanitized before further slaughtering or processing operations are resumed.

(h) Downer animals purchased or acquired by livestock dealers or other persons and held for treatment prior to slaughter shall, when submitted for slaughter, be accompanied by a certificate, conforming to the requirements under paragraph (b), both from the prior owner or custodian of such animals and the livestock dealer or other person treating such animals with respect to any drugs or antibiotics administered by them within 30 days prior to the submission of such animals for slaughter.

(9) **FALSE CERTIFICATES.** It shall be unlawful for any person or his agent, in the sale or shipment of animals to a slaughtering establishment, to make or submit any false or misleading statement, representation or certificate concerning the ownership, identity, origin or health status of such animals, or of any drugs, biologics or antibiotics administered to such animals.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (6) and cr. (8), Register, September, 1972, No. 201, eff. 10-1-72; am. (6) (b) 3, (7), (8) (b) 3, (8) (d) and cr. (8) (b) and (9), Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.17 Postmortem inspection. (1) **SCOPE OF INSPECTION.** A careful postmortem examination and inspection shall be made of the carcasses and parts of all animals slaughtered at establishments operating under state meat inspection. Such inspection and examination shall be made at the time of slaughter. All animals and parts of animals shall be identified in such manner that the identity of all

parts is maintained until after postmortem inspection has been completed. When whole carcasses are condemned, all parts are condemned.

(2) FACILITIES FOR CONDUCTING POSTMORTEM INSPECTION. Each establishment under state meat inspection shall furnish:

(a) Natural or artificial lighting, or a combination may be used. A minimum of 50 foot candles of light shall illuminate the material examined at an inspection point. At least 20 foot candles of illumination shall be supplied elsewhere in an operating room.

(b) Soap from dispensers, hot water, and clean, disposable towels shall be supplied for inspectors' use, conveniently located at inspection points.

(c) Head racks shall be provided for the examination of head lymph nodes, tongue and the muscles attached to the mandible.

(d) Offal carts with pluck pans or other suitable pans or tables shall be provided for the examination of the abdominal and thoracic organs.

(e) Sanitary, water-tight trucks or receptacles for holding and handling diseased carcasses, parts and other inedibles shall be so constructed as to be readily cleaned. Such trucks or receptacles shall be plainly marked "inedible" and shall not be utilized for edible products.

(f) Compartments and receptacles in such number and in such locations as may be required, shall be provided for carcasses and meat products that are held for further inspection. They shall be so constructed and equipped that they may be securely locked with locks furnished by the department, the keys remaining in the custody of the department. Every such compartment or receptacle shall be plainly marked "Wis. Retained."

(g) Locked storage space shall be provided for stamps, brands and other inspection supplies. Desk or suitable table space shall be provided for writing and other clerical duties associated with inspection at the establishment. Each inspector shall be provided with a metal locker at least 15 x 18 x 60 inches for storing clothing and personal effects.

(3) INSPECTION PROCEDURES. (a) The head, tongue, tail, thymus gland, all viscera and all parts, and blood to be used in the preparation of meat food products or medicinal products, shall be held in such manner as to preserve their identity until a postmortem examination has been completed. Spermatic cords shall be removed from hog carcasses and pizzles shall be removed from all carcasses. The heads of cattle shall be removed in a manner to avoid contamination from paunch contents. The skinned heads shall not be permitted to come in contact with the floor. The horns and all pieces of hide shall be removed before the heads are flushed and washed. All carcasses and parts shall be presented in a manner suitable for inspection.

(b) Each carcass, parts, detached inedible parts and organs, in which any lesion of disease or other condition is found that might render the meat or organ unfit for food purposes, and which for that

reason would require a subsequent inspection, shall be retained by the inspector at the time of inspection. The identity of every such retained carcass, parts, detached inedible part and detached organ shall be maintained until the final inspection has been completed. Retained carcasses shall not be washed or trimmed unless authorized by the inspector.

(c) Such devices and methods as are approved by the department may be used for the temporary identification of retained carcasses, parts, detached inedible parts or organs. In all cases the identification shall be further established by affixing "Wis. Retained" tags as soon as practicable and before final inspection. These tags shall not be removed by any person other than a department employee.

(d) Each carcass or part that is found on final inspection to be unsound, unhealthful, unwholesome or otherwise unfit for human food shall be conspicuously marked "Wis. Inspected and Condemned." Condemned detached organs and parts of such character that they cannot be so marked shall be placed immediately in trucks or receptacles which shall be plainly marked "Condemned." All condemned carcasses and parts for non-food use shall be condemned and disposed of under the supervision of a department employee by rendering, denaturing, or other manner as prescribed.

(e) Carcasses and parts found to be sound, healthful, wholesome, and fit for human food shall be marked "Wis. Inspected and Passed."

(f) Carcasses and parts passed for cooking shall be conspicuously marked or tagged "Passed for Cooking."

(g) In all cases where carcasses showing localized lesions are passed for food, the diseased parts shall be removed before the "Wis. Retained" tag is taken from the carcass. Such diseased parts shall be condemned.

(h) Carcasses found before evisceration to be affected with anthrax shall be condemned. Detached inedible parts and organs found to be affected with anthrax shall be condemned. The parts of any carcass contaminated with anthrax-infected material through contact with soiled instruments, or otherwise contaminated, shall be immediately condemned. The scalding vat water through which hog carcasses affected with anthrax have passed, shall be immediately drained into the sewer. All parts of the scalding vat shall be cleaned and disinfected. That portion of the slaughtering department, including bleeding area, scalding vat, gambrelling bench, floors, walls, posts, platforms, saws, cleavers, knives, hoods, and other equipment, as well as employes' boots, and aprons, that have become contaminated through contact with anthrax-infected material shall be cleaned immediately and disinfected. When a disinfectant solution has been applied to equipment that will afterwards contact meat, the equipment shall be rinsed with clean water before again being used.

(i) When a calf carcass is to be dressed with the skin or hide left on, the skin or hide shall be thoroughly washed and cleansed before any incision is made for the purpose of removing any part or for evisceration.

(j) All hair, scurf, dirt, hoofs and claws shall be removed from the hog carcasses, and the carcasses thoroughly washed and cleansed, before any incision is made for inspection or evisceration.

(k) The sternum of each carcass shall be split and spread apart at the time of slaughter, so as to expose the lungs, heart, liver and thoracic cavity, in order to allow proper inspection and drainage.

(l) Carcasses or parts shall not be inflated with air. Transferring the caul or other fat from a fat to a lean carcass is prohibited.

(m) When only a portion of a carcass is to be condemned because of bruises, bruised portion shall be removed immediately. No carcass shall be stamped "Wis. Inspected and Passed" until the bruised portion has been removed.

(n) Lungs affected with disease, or pathology, or chemical or biological residue shall be condemned and denatured, and shall not be used for animal feed.

(o) Lungs shall not be saved as edible meat products.

(p) Lactating mammary glands and diseased mammary glands of cattle, sheep, swine and goats shall be removed without opening the milk ducts or sinuses. If pus or other objectionable material is permitted to come in contact with the carcass, the part thus contaminated shall be removed and condemned. Lactating mammary glands of cattle, sheep, swine and goats shall not be saved for edible purposes.

(q) Tonsils shall be removed and shall not be used as ingredients of meat food products.

(r) No blood which comes in contact with the surface of the body of an animal or is otherwise contaminated shall be collected for food purposes. Only blood from animals, the carcasses of which are inspected and passed, may be used for meat food products. The defibrination of blood intended for food purposes shall not be performed with the hands.

(s) Clotted blood shall be removed from hog hearts.

(t) Inspectors shall make such incisions or inspections as are essential to determine the presence, character, and extent of any condition that might have a bearing in the disposition of the carcass or any part.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (3) (n) and (r), Register, September, 1972, No. 201, eff. 10-1-72

Ag. 47.18 Disposition of diseased carcasses and parts. (1) GENERAL. (a) Cause for condemnation on postmortem inspection may include but is not limited to the following conditions:

1. Pyemia
2. Bacteremia
3. Viremia
4. Toxemia
5. Septicemia

6. Generalized anasarca or edema
7. Biological residues or reactions
8. Extreme hemorrhaging or bruising
9. Polyarthritis
10. Icterus
11. Anemia
12. Uremia
13. Sex or other offensive odors
14. Suffocation or incomplete bleeding
15. Extensive parasitism, such as cysticerocosis or sarcosporidiosis
16. Tuberculosis
17. Malignant neoplasms
18. Emaciation
19. Unborn or stillborn animals
20. Immaturity
21. Encephalitis

(b) Parts of carcasses may be condemned for:

1. Contamination with filth, hair, chemicals or other offensive materials
2. Abscesses
3. Localized parasitism
4. Localized infections, such as chronic pneumonia
5. Bruises, hemorrhages, and fractures
6. Non-malignant neoplasms
7. Granuloma
8. Cirrhosis, necrosis, or other forms of degeneration
9. Pigmentation
10. Dermatitis

(2) TUBERCULOSIS. The following procedures shall apply to the disposition of carcasses of livestock, based on the difference in the pathogenesis of tuberculosis in swine, cattle, sheep, goats, and equines:

(a) *Carcasses condemned.* The entire carcass of swine, cattle, sheep, goats, and equines shall be condemned if any of the following conditions occur:

1. When the lesions of tuberculosis are generalized. Tuberculosis is considered to be generalized when the lesions are distributed in a

manner made possible only by entry of the bacilli into the systemic circulation.

2. When on antermortem inspection the animal is observed to have a fever found to be associated with an active tuberculosis lesion on postmortem inspection.

3. When there is an associated cachexia.

4. When a tuberculosis lesion is found in any muscle or intermuscular tissue, or bone, or joint, or abdominal organ (excluding the gastro-intestinal tract) or in any lymph node as a result of draining a muscle, bone, joint, or abdominal organ (excluding the gastro-intestinal tract).

5. When the lesions are extensive in tissues of either the thoracic or abdominal cavity.

6. When the lesions are multiple, acute, and actively progressive.

7. When the character or extent of the lesions otherwise is not indicative of a localized condition.

(b) *Organs or other parts condemned.* An organ or other part of a swine, cattle, sheep, goat, or equine carcass affected by localized tuberculosis shall be condemned when it contains lesions of tuberculosis or when the corresponding lymph node contains lesions of tuberculosis.

(c) *Carcasses of cattle passed without restriction for human food.* Carcasses of cattle may be passed without restriction for human food only when the carcass of an animal not identified as a reactor to a tuberculin test administered by federal or state animal officials or an accredited veterinarian is found free of tuberculosis lesions during postmortem inspection.

(d) *Portions of carcasses and carcasses of cattle passed for cooking.* 1. When a cattle carcass reveals a tuberculosis lesion or lesions not so severe or so numerous as the lesions described in paragraph (a) of this section, the unaffected portion of the carcass may be passed for cooking if the character and extent of the lesions indicate a localized condition, and if the lesions are calcified or encapsulated, and provided the affected organ or other part is condemned.

2. When the carcass of a cattle identified as a reactor to a tuberculin test administered by federal or state animal health officials or an accredited veterinarian is found free of lesions of tuberculosis, the carcass may be passed for cooking.

(e) *Portions of carcasses and carcasses of swine passed without restriction for human food.* Swine carcasses found free of tuberculosis lesions during postmortem inspection may be passed for human food without restriction. When tuberculosis lesions in any swine carcass are localized and confined to one primary seat of infection, such as the cervical lymph nodes, the mesenteric lymph nodes, or the mediastinal lymph nodes, the unaffected portion of the carcass may be passed for human food without restriction after the affected organ or other part is condemned.

(f) *Portions of carcasses of swine passed for cooking.* When the carcass of any swine reveals lesions more severe or more numerous than those described in paragraph (e) of this section, but not so severe or so numerous as the lesions described in paragraph (a) of this section, the unaffected portions of such carcass may be passed for cooking if the character and extent of the lesions indicate a localized condition, and if the lesions are calcified or encapsulated, and provided the affected organ or other part is condemned.

(g) *Carcasses of sheep, goats, and equines passed without restriction for human food.* Carcasses of sheep, goats, and equines may be passed without restriction for human food only if found free of tuberculosis lesions during postmortem inspection.

(h) *Portions of carcasses of sheep, goats, and equines passed for cooking.* If a carcass of any sheep, goat, or equine reveals a tuberculosis lesion or lesions that are not so severe or so numerous as the lesions described in paragraph (a) of this section, the unaffected portion of the carcass may be passed for cooking if the character and extent of the lesions indicate a localized condition, and if the lesions are calcified or encapsulated, and provided the affected organ or other part is condemned.

(i) *Carcasses and parts passed for cooking; utilization for food purposes after cooking.* Carcasses and parts passed for cooking may be used for the preparation of meat food products, provided all such carcasses or parts are heated to a temperature not lower than 170° F. for a period of not less than 30 minutes either before being used in or during the preparation of the finished product.

(3) HOG CHOLERA. The carcasses of all hogs affected with hog cholera shall be condemned.

(5) SWINE ERYSIPELAS. Carcasses affected with swine erysipelas which is acute or generalized, or which show systemic change, shall be condemned.

(6) DIAMOND-SKIN DISEASE. Carcasses of hogs affected with diamond-skin disease when localized and not associated with systemic change may be passed for food after removal and condemnation of the affected parts, provided such carcasses are otherwise in good condition.

(7) ARTHRITIS. (a) Carcasses affected with arthritis which is localized and not associated with systemic change may be passed for food after removal and condemnation of all affected parts. Affected joints with corresponding lymph nodes shall be removed and condemned. In order to avoid contamination of the meat which is passed, a joint capsule shall not be opened until after the affected joint is removed.

(b) Carcasses affected with arthritis shall be condemned when accompanied by evidence of systemic involvement.

(8) ANASARCA OR GENERALIZED EDEMA. (a) Carcasses of cattle found on postmortem inspection to be affected with anasarca in advanced stages and characterized by an extensive or well-marked generalized edema shall be condemned.

(b) Carcasses of cattle, including their detached parts and organs, found on postmortem inspection to be affected with anasarca to a lesser extent than in paragraph (a) of this subsection, may be passed for food after removal and condemnation of the affected tissues provided the lesion is localized.

(9) **ACTINOMYCOSIS AND ACTINOBACILLOSIS.** (a) The definition of generalization as outlined for tuberculosis in subsection (2) (a) shall apply for actinomycosis and actinobacillosis, and carcasses of animals so affected shall be condemned.

(b) Carcasses of animals in a well-nourished condition showing uncomplicated localized lesions of actinomycosis or actinobacillosis may be passed after the infected organs or parts have been removed and condemned, except as provided in paragraphs (c) and (d) of this subsection.

(c) Heads affected with actinomycosis or actinobacillosis, including the tongue, shall be condemned, except that when the disease of the jaw is slight, strictly localized, and without suppuration, fistulous tracts, or lymph node involvement, the tongue, if free from disease may be passed, or when the disease is slight and confined to the lymph nodes, the head, including the tongue, may be passed after the affected nodes have been removed and condemned.

(d) When the disease is slight and confined to the tongue, with or without involvement of the corresponding lymph nodes, the head may be passed after removal and condemnation of the tongue and corresponding lymph nodes.

(10) **ANTHRAX, BLACKLEG OR MALIGNANT EDEMA.** Carcasses of animals affected with anthrax, blackleg, or malignant edema shall be condemned.

(11) **NEOPLASMS.** An individual organ or other part of a carcass affected with a neoplasm shall be condemned. If there is evidence of metastasis or the general condition of the animals has been adversely affected by the size, position or nature of the neoplasm, the entire carcass shall be condemned.

(12) **EPITHELIOMA OF THE EYE.** (a) Carcasses of animals affected with epithelioma of the eye, or the orbital region shall be condemned in their entirety if one of the following three conditions exists:

1. The affection has involved the osseous structures of the head with extensive infection, suppuration and necrosis;

2. There is metastasis from the eye, or the orbital region, to any lymph node including the parotid lymph node, internal organs, muscles, skeleton, or other structures, regardless of the extent of the primary tumor; or

3. The affection, regardless of extent is associated with cachexia or evidence of absorption or secondary changes.

(b) Carcasses of animals affected with epithelioma of the eye, or the orbital region, to a lesser extent than as described in paragraph (a) of this section may be passed for human food after removal and condemnation of the head, including the tongue, provided the carcass is otherwise normal.

(13) **PIGMENTARY CONDITION; MELANOSIS, XANTHOSIS, OCHRONOSIS; DISPOSITION OF CARCASSES AND PARTS.** Carcasses of animals showing generalized pigmentary deposits shall be condemned. Affected parts of carcasses showing localized pigmentary deposits of such character as to be unwholesome or otherwise unfit for food shall be removed and condemned.

(14) **ABRASIONS, BRUISES, ABSCESES, PUS.** All slight, well-limited abrasions, when without lymph node involvement, shall be carefully excised, leaving only sound, normal tissue, which may be passed. Any organ part of a carcass which is badly bruised or which is affected by an abscess, or a suppurating sore shall be condemned; and when the lesions are of such character or extent as to affect the whole carcass, the whole carcass shall be condemned. Portions of carcasses which are contaminated by pus or other diseased material shall be condemned.

(15) **BRUCELLOSIS.** Carcasses affected with localized lesions of brucellosis may be passed for food after the affected parts are removed.

(16) **INFECTED CARCASSES.** (a) All carcasses of animals so infected that consumption of the products thereof may give rise to food poisoning shall be condemned. This includes all carcasses showing signs of:

1. Acute inflammation of the lungs, pleura, pericardium, peritoneum or meninges.
2. Septicemia or pyemia, whether puerperal, traumatic, or without any evident cause.
3. Gangrenous or severe hemorrhagic enteritis or gastritis.
4. Acute diffuse metritis or mammatis.
5. Phlebitis of the umbilical veins.
6. Salmonellosis.
7. Septic or purulent traumatic pericarditis.
8. Any acute inflammation abscess, or suppurating sore, if associated with acute nephritis, fatty and degenerated liver, swollen soft spleen, marked pulmonary hyperemia, general swelling of lymph nodes, diffuse redness of the skin, cachexia, icteric discoloration of the carcass, or the like, either singly or in combination.

(b) Implements contaminated by contact with carcasses affected with any of the diseased conditions mentioned in this section shall be thoroughly cleaned and disinfected. Carcasses or parts of carcasses contaminated by contact with such diseased carcasses shall be condemned unless all contaminated tissues are removed within 2 hours.

(17) **NECROBACILLOSIS, PYEMIA, SEPTICEMIA.** Necrobacillosis may be regarded as a local affection at the beginning, and carcasses in which lesions are so localized may be passed for food if in a good state of nutrition, after removing and condemning those portions affected with necrotic lesions. When emaciation, cloudy swelling of the parenchymatous tissue of organs or enlargement of the lymph nodes is associated with the affection, and the disease has progressed beyond

the condition of localization, the entire carcass shall be condemned. When pyemia or septicemia are present, the carcass shall be condemned.

(18) **CASEOUS LYMPHADENITIS.** (a) A thin carcass showing well-marked lesions in the viscera and the skeletal lymph nodes, or such a carcass showing extensive lesions in any part shall be condemned.

(b) A thin carcass showing well-marked lesions in the viscera with only slight lesions elsewhere or showing well-marked lesions in the skeletal lymph nodes with only slight lesions elsewhere, may be passed for cooking.

(c) A thin carcass showing only slight lesions in the skeletal lymph nodes and in the viscera may be passed without restriction.

(d) A well-nourished carcass showing well-marked lesions in the viscera and with only slight lesions elsewhere or showing well-marked lesions confined to the skeletal lymph nodes with only slight lesions elsewhere may be passed without restriction.

(e) A well-nourished carcass showing well-marked lesions in the viscera and the skeletal lymph nodes may be passed for cooking; but where the lesions in the well-nourished carcass are both numerous and extensive, it shall be condemned.

(f) All affected organs and nodes of carcasses passed without restriction or passed for cooking shall be removed and condemned. The term "thin" as used in this section shall not be held applicable to a carcass which is anemic or emaciated.

(19) **ICTERUS.** Carcasses showing any degree of icterus with a parenchymatous degeneration of organs, the result of infection or intoxication, and those which show a pronounced yellow or greenish yellow discoloration without evidence of infection or intoxication, shall be condemned. Other carcasses affected with icterus-like discoloration which disappears upon chilling, may be passed for food. If the discoloration does not disappear upon chilling, the meat from the carcasses may be passed for use in comminuted meat food product or for rendering.

(20) **SEXUAL ODOR OF SWINE.** (a) Carcasses of swine which give off a pronounced sexual odor shall be condemned.

(b) The meat of swine carcasses which gives off a sexual odor less than pronounced may be passed for use in comminuted cooked meat food product or for rendering. Otherwise it shall be condemned.

(21) **MANGE OR SCAB.** Carcasses of animals affected with mange or scab in advanced stages, showing cachexia or extensive inflammation of the flesh, shall be condemned. When the disease is slight, the carcass may be passed after removal of the affected portion.

(22) **HOGS AFFECTED WITH URTICARIA, TINEA TONSURANS, DEMODEX, FOLLICULORUM OR ERYTHEMA.** Carcasses of hogs affected with urticaria (nettle rash), tinea tonsurans, demodex folliculorum, or erythema may be passed after detaching and condemning the affected skin, if the carcass is otherwise fit for food.

(23) **TAPEWORM CYSTS (CYSTICERCUS BOVIS) IN CATTLE.** Carcasses of cattle affected with tapeworm cysts shall be disposed of as follows:

(a) Infested carcasses shall be condemned if infestation is extensive or if the musculature is edematous or discolored. Infestation shall be considered extensive if cysts are found in 2 or more of the usual inspection sites plus 2 or more muscle tissue locations exposed by incision.

(b) Carcasses showing a lesser degree of infestation than described above may be passed for food after lesions have been excised, provided that such carcasses are appropriately identified and retained under department control at a temperature of not higher than 15° F. for not less than 10 days, or in the case of boned meat in properly identified and retained containers for a period of not less than 20 days at temperatures not higher than 15° F. Alternatively, such carcasses or meat therefrom may be heated throughout to a temperature of not less than 140° F., under positive control of a program inspector.

(c) Edible viscera and offal shall be disposed of in the same manner as the rest of the carcass from which derived unless any lesions of *Cysticercus bovis* is found in their by-products, in which case they shall be condemned. This shall not include the lungs, fat, muscles of the esophagus and the heart, which shall be subjected to heat or cold as described. The intestines, esophagi, and bladders from beef carcasses affected with tapeworm cysts which have been passed for food or passed for food after refrigeration or heating, may be used for casings.

(24) HOGS AFFECTED WITH TAPEWORM CYSTS (*CYSTICERCUS CELLULOSAE*). Carcasses of hogs affected with tapeworm cysts (*Cysticercus cellulosae*) may be passed for cooking, but if the infestation is excessive, the carcass shall be condemned.

(25) PARASITES NOT TRANSMISSIBLE TO MAN; TAPEWORM CYSTS IN SHEEP, HYDATID CYSTS; FLUKES, GID BLADDERWORMS. (a) In the disposal of carcasses, edible organs, and other parts of carcasses infested with parasites not transmissible to man, the following rules shall apply: If lesions are localized and can be completely removed, the non-affected portion of the carcass, organ or other part of the carcass may be passed for food after removal and condemnation of the affected portions. If an organ part of a carcass has numerous lesions caused by parasites, or if the character of the infestation is such that complete extirpation of the parasitic infestation is not possible, the affected part shall be condemned. If parasites are found to be distributed in a carcass in such a manner or to be of such character that their removal and the removal of the lesions caused by them is impracticable, no part of the carcass shall be passed for food.

(b) In the case of sheep carcasses affected with tapeworm cysts (*Cysticercus ovis*, sheep measles) such carcasses may be passed after the removal and condemnation of the affected portions; provided the cysts are not so generally distributed and so numerous that their removal would be impracticable, in which case the entire carcass shall be condemned.

(c) Carcasses found infested with gid bladderworms (*Coenurus cerebralis*, *Multiceps multiceps*) may be passed after condemnation of the affected organ.

(d) Organs or parts of carcasses infested with hydatid cysts (*Echinococcus*) shall be condemned.

(e) Livers infested with flukes or tapeworms shall be condemned.

(26) **EMACIATION.** Carcasses of animals too emaciated to produce wholesome meat, with serous infiltration of muscle tissues, or serous or mucoid degeneration of the fatty tissue, shall be condemned. A gelatinous change of the fat about the heart and kidneys of well-nourished carcasses and mere leanness shall not be classed as emaciation.

(27) **CARCASSES OF YOUNG ANIMALS.** Carcasses of young calves, pigs, kids, and lambs are unwholesome and shall be condemned if:

(a) The meat has the appearance of being water-soaked, is loose, flabby, tears easily, and can be perforated with the fingers.

(b) Its color is grayish red.

(c) Good muscular development as a whole is lacking, especially noticeable on the upper shank of the leg, where small amounts of serous infiltrates or small edematous patches are sometimes present between the muscles.

(d) The tissue which later develops as the fat capsule of the kidneys is edematous, dirty yellow, or grayish red, tough, and intermixed with islands of fat.

(28) **UNBORN AND STILLBORN ANIMALS.** All unborn and stillborn animals shall be condemned and no hide or skin thereof shall be removed from the carcass within a room in which edible products are handled.

(29) **ANIMALS SUFFOCATED OR SCALDED ALIVE.** All animals which have been suffocated in any way and hogs which have entered the scalding vat alive shall be condemned.

(30) **LIVERS.** (a) Livers affected with carotenosis shall be condemned.

(b) Cattle livers and calf livers showing the conditions sometimes designated as "telangiectatic," "sawdust," or "spotted" shall be disposed of as follows:

1. When any or all of the conditions are extensive and involve one-half or more of an organ, the whole shall be condemned.

2. When any or all of the conditions are slight in an organ, the whole organ shall be passed without restriction.

3. When any or all of the conditions are extensive and involve less than one-half of the organ, while in the remainder of the organ the conditions are slight, the remainder shall be passed without restriction and the other portion shall be condemned.

(31) **ANEMIA.** Carcasses of animals too anemic to produce wholesome meat shall be condemned.

(32) **MUSCULAR CONDITIONS.** (a) If muscular lesions are found to be distributed in such a manner or to be of such character that removal is impracticable, the carcass shall be condemned.

(b) Lesions localized in such a manner and of such a character that the affected tissues can be removed, the non-affected parts of the

carcass may be passed for food after the removal and condemnation of the affected portion.

(33) **COCCIDIOIDAL GRANULOMA.** (a) Carcasses which are affected with generalized coccidoidal granuloma, or which show systemic changes because of such disease shall be condemned.

(b) Carcasses affected with localized lesions of this disease may be passed for food after the affected parts are removed and condemned.

(34) **ODORS, FOREIGN AND URINE.** (a) Carcasses which give off a pronounced odor of medicinal, chemical, or other foreign substance shall be condemned.

(b) Carcasses which give off a pronounced urine odor shall be condemned.

(c) Carcasses, organs or parts affected by odor to a lesser degree than that described in paragraphs (a) and (b) of this subsection and in which the odor can be removed by trimming or chilling may be passed for food.

(35) **RADIATION.** Meat from animals to which radioactive material has been administered for research, experimental or veterinary purposes shall be condemned if any radioactive material retained in the meat has not decayed to the normal radiation background level. The normal radiation background level shall mean the radiation background of similar samples of meat from animals to which radioactive material has not been administered when measured in the same manner as the meat from the animal to which radioactive material has been administered.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71; am. (2), Register, September, 1972, No. 201, eff. 10-1-72; r. (4), Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.19 Humane slaughter. (1) All slaughtering of livestock shall be accomplished by humane methods as defined by section 95.80, Wis. Stats.

(2) Methods of slaughter recognized as being humane include:

(a) Captive bolt devices.

(b) Electrical stunning.

(c) CO₂ gas chamber.

(d) Gun shot.

(e) Rabbinical slaughter procedure (koshering).

(3) Any method which involves penetration of the skull cavity by projectile (bullet) or bolt, thereby carrying hair, bone fragments, skin, dirt or lead fragments into the brain, renders the brain of such animal unsuitable for food.

(4) Heads, head meat and cheek meat, the tongue excluded, from animals killed by gunshot shall not be saved for food purposes.

(5) In no instance shall animals be shackled and hoisted, stuck, or cut before being rendered insensible to pain, except as accomplished in Rabbinical Slaughter Procedures.

History: Cr. Register, September, 1971, No. 189, eff. 10-1-71.
Register, April, 1975, No. 232

Ag 47.20 Obstruction of department employes. (1) The obstruction of any department employe in the performance of his duties, by the owner or operator of any establishment or his associates or employes, shall be cause for license revocation or denial. Obstruction or denial of access for inspection purposes in establishments where inspection is required as a condition to the sale of meat or meat food products shall further be grounds for the immediate suspension or withdrawal of inspection services on notice or order of the department.

(2) The term "obstruction" includes verbal or physical abuse, the making of threats, the use of offensive language, the use of physical restraint or any other act which impedes, interferes with or impairs the capacity of a department inspector or employe to perform an orderly and full inspection as required by law.

(3) When inspection services are withdrawn under subsection (1), the owner or operator of the establishment concerned may upon written request demand a hearing thereon within 10 days after suspension or withdrawal of inspection services. Such request shall not serve to stay the suspension or withdrawal of inspection services.

History: Cr. Register, September, 1972, No. 201, eff. 10-1-72.

Ag 47.30 Frozen food lockers and processor. Frozen food locker and frozen food processing plants, subject to licensing under section 99.10, Wis. Stats., shall be constructed, maintained and operated in conformity with this chapter.

(1) **RESTRICTIONS.** (a) The processing of any food not intended for human consumption is prohibited in a frozen food locker or frozen food processing establishment.

(b) No food products, materials or other substances having any strong or characteristic odor which would adversely affect the quality of meat products, poultry products, or meat food products shall be processed or stored at any frozen food locker or processing plant, or in any way commingled with such meat products, poultry products, or meat food products.

(c) No unwrapped food product shall be placed in any storage locker.

(d) The storage of food not intended for human consumption is prohibited unless such foods are contained in non-permeable, sealed packages and containers and are stored separate and apart from any food for human consumption.

(2) **PRODUCT IDENTIFICATION.** (a) All packages of foods placed or stored in any frozen food locker by the owner or operator of the plant for individual customers shall be clearly marked so as to identify the product and the owner thereof. Products cut, wrapped and frozen by the operator of a food processing plant and placed in a frozen food locker by such operator, shall be further marked to include the date of processing.

(b) Products cut, wrapped or frozen by the operator of a frozen food processing plant shall, prior to storage or delivery to the customer, be marked "NOT FOR SALE" in block letters not less than $\frac{3}{8}$ inch in height.

(c) Any food not intended for human consumption held at any food locker or processing plant shall be plainly and conspicuously marked or labeled by the plant operator "NOT FOR HUMAN CONSUMPTION" in block lettering not less than $\frac{3}{8}$ of an inch in height.

History: Cr. Register, April, 1975, No. 232, eff. 5-1-75.

Ag 47.45 Mobile slaughterers. (1) **REGISTRATION; IDENTIFICATION NUMBER.** No person shall engage in business as a mobile slaughterer, as defined in section Ag 47.02(33), without registering with the department his name and address, including the business name and address. Each person registered as a mobile slaughterer shall be assigned an official identification number.

(2) **PRODUCT IDENTIFICATION.** (a) *Brands.* Each mobile slaughterer shall provide an approved metal stamp or brand incorporating his assigned identification number and bearing the words "NOT FOR SALE", of a design which conforms with the stamp or brand as prescribed under section Ag 47.09(1)(b), for use in the marking and identification of carcasses and products.

(b) *Identification and marking of product.* All carcasses of animals slaughtered by a mobile slaughterer shall immediately after slaughter and prior to their removal from the premises at which slaughtered, be legibly stamped or branded on each side, quarter, or other part thereof with the stamp or brand as prescribed under paragraph (a).

(3) **FACILITIES AND SANITATION.** (a) *Facilities and equipment.* The inside surfaces of trucks, vans or trailers used in the processing or transportation of carcasses or other products, shall be so designed and constructed as to be capable of being readily and thoroughly cleaned and be maintained in a sanitary condition.

(b) *Utensils and tools.* Utensils and tools used for mobile slaughter operations shall be cleaned after each use, and more frequently as necessary to keep them in a clean and sanitary condition. Facilities shall be available for the thorough cleaning and sanitizing of equipment and utensils. Sanitizing of equipment and utensils may be accomplished either by the use of hot water or a sanitizing solution. Where a sanitizing solution is used, it shall be followed by a thorough rinsing with clean water.

(c) *Personnel.* Personnel engaged in the slaughtering and handling of carcasses and products shall wear clean and washable outer clothing, and shall wash and rinse their hands sufficiently during the operations to prevent contamination of carcasses and products.

(d) *Water supply.* Potable water in sufficient quantity for the thorough washing and cleaning of carcasses and equipment shall be available during slaughtering operations.

(4) **TRANSPORTATION OF CARCASSES.** Transportation of carcasses or products shall be in accordance with the provisions of section Ag 47.06. If inedible product generated in the slaughtering operation is to be transported on the same vehicle with edible product, such inedible product shall be transported in waterproof and tightly covered containers, or in separate waterproof compartments, so as to prevent spillage or leakage of liquid wastes, or the contamination of edible product.

(5) **DISPOSITION OF UNWHOLESOME, ADULTERATED OR MISBRANDED PRODUCTS.** Any carcasses or products resulting from a mobile slaughtering operation shall be fully subject to the provisions of section Ag 47.07 relating to the seizure, retention, condemnation and disposition of unwholesome, adulterated or misbranded products.

(6) **RECORD KEEPING; REPORTS.** Mobile slaughterers shall maintain monthly records of all animals slaughtered by them, including the name and address of the owners of animals slaughtered, a description of the animals slaughtered, and the disposition of carcasses or product derived from such slaughtering operation transported by the mobile slaughterer. Monthly reports shall be submitted to the department for those months slaughtering operations were conducted on forms prescribed for this purpose not later than the 10th day of each ensuing month.

History: Cr. Register, April, 1975, No. 232, eff. 5-1-75.

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