

STATE OF WASHINGTON

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OCT 27 1961

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DOCKET # 914 FILE # 13

STATE OF WASHINGTON
DEPARTMENT OF AGRICULTURE
Olympia

ORDER NO. 869

(Superseding Order No. 865)

EFFECTIVE November 26, 1961

STATE OF WASHINGTON

FILED

OCT 24 1961

CODE REVISER'S OFFICE

DOCKET # FILE #

REGULATIONS GOVERNING CUSTOM SLAUGHTER PLANTS

16-21
I, Virgil Cunningham, Acting Director of Agriculture of the State of Washington by virtue of the authority vested in me under Chapter 204, Laws of 1959 (Chapter 16.49 RCW) after due notice as provided under Chapter 34.04 and 42.32, RCW, and a public hearing held in Olympia on October 4, 1961, do promulgate the following regulations:

PART I - DEFINITIONS

Regulation 1. For purposes of regulations contained in these regulations the following definitions as they appear in Chapter 204, Laws of 1959 shall apply:

- (a) "Carcass" means all or any parts, including viscera, of a slaughtered meat food animal capable of being used for human food.
- (b) "Department" means the department of agriculture of the State of Washington.
- (c) "Director" means the director of the department or his duly appointed representative.
- (d) "Equipment" means all machinery, fixtures, containers, vessels, tools, implements, and apparatus used in and about an establishment and vehicles used to transport meat.
- (e) "Meat" means the carcass, parts of carcass, meat and meat food products derived in whole or in part from meat food animals.
- (f) "Meat by-product" means any edible part other than meat which has been derived from one or more meat food animals.
- (g) "Person" means a natural person, individual, firm, partnership, corporation, company, society, and association, and every officer, agent or employee thereof. This term shall import either the singular or the plural as the case may be.
- (h) "Meat food animal" hereinafter known as animal means live cattle, sheep, swine, goats, horses, mules or burros.
- (i) "Operator" includes any owner, lessee, or manager of an establishment.
- (j) "Unwholesome" includes meat products which may be diseased, contaminated, putrid, unsound, unhealthful, or otherwise unfit for human food and meat animals which may be unfit for slaughter for any reason which would make meat products from them unfit for human food.
- (k) "Custom slaughtering establishment" means any slaughtering establishment licensed to operate under Chapter 16.49 RCW as amended.
- (l) "Roll stamping" or "Stamped" means roll stamping the full length of each half or quarter of a carcass derived from a meat food animal slaughtered by a custom slaughterer with the words "Not Inspected - Custom Plant No. _____," in letters not less than three-eighths of an inch in height.

PART II - SANITATION

Regulation 2. Establishments or premises on or in which animals are slaughtered or held or in which products are prepared or handled shall be maintained in a sanitary condition. Compliance with the requirements specified in regulations 3 through 31 will be deemed necessary for minimum sanitary conditions.

Regulation 3. Sufficient light: There shall be sufficient light consisting of not less than 20 foot candles of over-all intensity of artificial illumination in all operating rooms.

Regulation 4. Adequate ventilation: There shall be adequate ventilation for all rooms and compartments to prevent condensation of moisture and to carry off odors and vapors.

Regulation 5. Adequate drainage: There shall be a sufficient number of drains to carry off waste accumulations and water according to the volume of slaughter and other relevant factors. Each, including blood drains shall be equipped with a deep seal (P-, U-, or S- shaped) trap; shall be a minimum inside diameter of 4 inches and shall be provided with rodent screens and be properly vented to the outside air. Unless otherwise specified in these regulations, all plumbing shall conform to applicable requirements of the plumbing codes effective within the particular jurisdiction, or, in their absence, to the requirements of recognized plumbing codes such as the National Plumbing Code ASA A40.8, or the Western Plumbing Official's Association, Uniform Plumbing Code, Waste disposal facilities shall conform to the requirements of the Pollution Control Commission. Domestic sewage shall be disposed of in conformity with the requirements of the jurisdictional health department. Toilet soil lines shall be separate from slaughterhouse drainage lines to a point outside the buildings and drainage from toilet bowls and urinals shall not be discharged into a grease catch basin.

Regulation 6. Water Supply: There shall be sufficient water to meet all operating demands. The water shall pass the test prescribed for potability in the "Drinking Water Standards" promulgated by the United States Public Health Service, Department of Health, Education and Welfare, New Standards of 1961. Water shall be delivered from plant outlets at a minimum flow pressure of 45 pounds per square inch. The water supply shall be effectively protected against contamination and pollution.

Regulation 7. Hot Water: The following shall be provided:

- (a) Hot water of at least 180°F. at hose outlets, sufficient in amount to thoroughly clean all surfaces and equipment which are subject to contamination by the dressing or handling of diseased carcasses, their viscera and parts.
- (b) Hot water of at least 140°F. at hose outlets sufficient in amount to assure thorough cleaning of all rooms and equipment in addition to those mentioned in 7 (a) above.
- (c) Hose connections for cleanup purposes at such places as are necessary to assure thorough cleaning of all rooms and equipment. Suitable racks or reels for storing the hose when not in use.

Regulation 8. Impervious surfaces: Floors in rooms in which flushing of the floors with water is required for adequate cleaning must be constructed of impervious material susceptible to proper cleaning such as concrete, tile or paving brick. They must be finished so as to enable proper cleaning. Walls in operating departments must be surfaced with a material which is susceptible to being properly cleaned to the height which the surface becomes soiled under normal operating conditions. Wooden structures are absorbent and difficult to keep clean, hence their use must be kept at a minimum. Ceilings must be smooth finished and capable of being properly cleaned. All coolers must be ceiled. All exposed wood surfaces must be smooth and painted or properly sealed.

Regulation 9. Slaughtering facilities and minimum dimensions: Slaughtering departments must have adequate floor space for the rate of slaughter and be arranged to assure sanitary conduct of operations. There must be sufficient clearance from the lowest point of all carcasses suspended from the dressing rail to the floor to avoid contamination of the carcasses.

Regulation 10. Cooler facilities: Adequate refrigerated facilities for the chilling and storage of carcasses and products shall be provided. The carcass chill cooler and holding coolers must have mechanical refrigeration capable of maintaining a temperature of 35°F. or lower, when loaded to capacity. When overhead refrigerating facilities are provided, insulated drip pans must be installed beneath them, and the pans properly connected to the drainage system or to other suitable facilities. If wall coils are installed, a drip gutter of impervious material and connected with the drainage system must be installed beneath the coils. In no event shall the clearance between a hanging carcass and the floor be less than that necessary to avoid contamination from the floor.

Regulation 11. Sterilizing Facilities: Properly located sterilizing receptacles constructed of rust resisting metal and of sufficient size for complete immersion of butcher tools, and other implements shall be provided in the slaughter room, and at other places where operations are likely to result in the contamination of such equipment and utensils. Such receptacles shall be provided with a means of heating the water contained therein to 180°F. and maintaining it at that temperature during the entire operation. The sterilizers must be constructed so that they may be drained after each day's use.

Regulation 12. Lavatory facilities: Lavatory facilities shall be maintained at such places as necessary to assure cleanliness for all persons handling meat products. Such facilities must include hot and cold running water, liquid soap and towels and must be maintained in a clean and sanitary condition.

Regulation 13. Flush toilet and dressing room facilities: A modern conveniently located flush type toilet shall be furnished. Such facilities must be fly-tight, properly ventilated, and heated. The toilet room must not open directly into any room where products are prepared, processed, stored or handled. The doorway between the toilet room and intervening room must have a tight, full-height self-closing door. If the toilet room is not an outside room, it must be properly vented to the outside and forced ventilation provided.

Regulation 14. Inedible and condemned storage and handling facilities:

- (a) Adequate facilities for the sanitary handling and storage of inedible offal and for sterilizing equipment in which inedible materials are transported shall be provided. These shall include one or more properly located enclosed rooms. Hot and cold water shall be provided at outlets in the inedible handling room. The necessary doors communicating inedible storage rooms with rooms where edible products are handled shall be metal clad, self-closing and tight fitting. Vertical hide, pelt, and inedible viscera chutes connecting edible product departments with inedible product departments must be covered with a hood with a self-closing door and vented to the outside with a vent stack at least 10" in diameter.
- (b) A separate refrigerated room capable of maintaining a temperature of 40°F. or less shall be provided for the storage of inedible material at plants which store such material for a period longer than 24 hours. Such rooms shall be of sanitary construction and shall have impervious floors, walls, and ceiling. The floors shall be water-tight and shall be properly sloped and provided with drains leading to the plant sewage disposal system.

- (c) Rooms and compartments in which inedible meat is rendered, shall be fly-tight, and shall be separated from other rooms wherein products are handled, by walls equipped with a tight, self-closing door.
- (d) All tanks and equipment used for rendering or preparing inedible meat shall be in rooms or compartments separate from those used for rendering or preparing edible products.
- (e) Tanks, fertilizers, driers and other equipment used in the preparation of inedible meat shall be properly equipped with condensers and other appliances which will acceptably suppress odors incident to such preparations.

Regulation 15. Rooms, compartments, etc., to be clean and sanitary: Rooms, compartments, places, equipment, and utensils used for preparing, storing, or otherwise handling any meat, and all other parts of the establishment, shall be kept clean and in sanitary condition. All equipment must be thoroughly cleaned following each day's operations. There shall be no handling or storing of materials which create an objectionable condition in rooms, compartments, or places where meat is prepared, stored or otherwise handled. Sawdust, if used in coolers, must be changed whenever soiled.

Regulation 16. Operations and procedures to be clean and sanitary: Operations and procedures involving the preparation, storing or handling of any meat shall be strictly in accord with clean and sanitary methods.

- (a) The slaughter floor shall be kept reasonably free of blood, fat, scraps, etc. Water shall not be permitted to splash from the floor upon unprotected carcasses on the bed or on the half hoist. The bed shall be reasonably clean before the carcass is lowered. Clean water-tight metal containers in good repair and free from objectionable odors, shall be provided at convenient locations for the reception of feet, tails, ears, pizzles, or other inedible material. Evisceration must be performed in such manner as to avoid contamination of the carcass with ingesta or fecal material.
- (b) Carcasses must be washed with water under pressure from a spray nozzle. Towels, rags, cloths, brushes of any kind, or water dipped out of a drum or containers are not permissible. Metal drums or containers of water shall not be used for washing hands, tools, or parts of carcasses, nor for flushing the floor. A carcass which has been contaminated by manure (in excessive quantities) or by pus must have the contaminated portion removed by trimming before being washed.
- (c) Inedible material must not be placed on the slaughter room floor and must be placed in suitable water-tight containers or vehicles until removed from the slaughter room.
- (d) Skinned beef heads must not be permitted to come in contact with the floor. The horns, hornbutts, muzzles, and all pieces of hide must be removed before the head is washed. If meat from the head is to be saved, the head must be thoroughly washed individually, and flushed in a head flushing cabinet. This must include a thorough flushing of the mouth, nostrils, and pharynx while the head is hanging in an inverted position. In removing front feet of cattle and calves, care should be taken to expose as little of the flesh of the foreshank as possible.
- (e) If meat from calf and vealer heads is to be saved, the heads must be washed individually and flushed (nostrils, mouth, pharynx) in an inverted position in a head flushing booth after all of the horns and hide have been removed from the head. Calves which are of such size that there is not a clearance of at least 8" above the floor, or whose viscera cannot be

transferred manually and unaided to the inedible room, must be skinned and eviscerated as cattle. Calves dressed hide-on must be thoroughly washed and cleaned prior to making any incision into the carcass other than the sticking wound, except that the heads of calves and vealers slaughtered by the "Kosher" method should be skinned prior to washing the carcasses.

- (f) In slaughtering lambs and sheep, the pelt must be removed and the carcass thoroughly washed and cleaned before any incision is made for evisceration. Adequate precautions must be taken to prevent soilage of the carcass when removing the pelt.
- (g) Hog carcasses must be thoroughly washed, cleaned, and singed (when necessary) to remove all hair, scale, scurf, dirt and toenails on the slaughtering floor before any incision is made, other than the stick wound. The forefeet when discarded in the slaughtering department need not be cleaned. Hog heads left on the carcass or saved intact must be thoroughly washed and flushed (nostrils, mouth and pharynx) and have ear tubes and eyelids removed.
- (h) Inedible products handling operation.
 - (1) Paunches shall not be opened in the slaughtering department, except when a power-operated paunch lift table is provided for this purpose.
 - (2) Except under conditions approved by the department, no inedible offal shall be stored in rooms where edible meat products are handled.
 - (3) Receptacles used for inedible meat in rooms in which edible products are handled must be in good repair and must be properly sanitized before being used. Inedible and condemned material not rendered at the plant must be held in water-tight metal containers in the inedible offal storage room pending removal to a rendering plant.
 - (4) Openings between edible and inedible department must be kept closed at all times, except when in actual use, to prevent the entrance of undesirable odors to the slaughtering department.
- (i) Carcass chilling operation: Carcasses must be removed from the slaughter room to the chill cooler immediately after dressing and washing is completed. Improperly washed or unclean carcasses may not be brought into the coolers.

Coolers must not be loaded beyond their capacity to properly chill the carcasses and edible offal. Maximum cooler capacity for carcass chilling and holding purposes is based on available rail space in the coolers. Thirty inches of rail space should be allowed for each beef carcass and 18 inches of rail space allowed for each hog carcass.

Regulation 17. Rooms and compartments free from dust and odors:

The rooms and compartments in which any meat is prepared or handled shall be free from dust and odors from dressing and toilet rooms, catch basins, hide cellars, casing rooms, inedible tank and fertilizer rooms and livestock shackling and holding pens.

Regulation 18. Rooms and compartments free of steam and vapors:

Rooms and compartments in which animals are slaughtered or any product is processed or prepared shall be kept sufficiently free of steam and vapors to insure clean operations. The walls, ceiling, and overhead structures of rooms and compartments in which products are prepared, handled or stored shall be kept reasonably free from moisture

Regulation 19. Equipment susceptible to cleaning; That for inedible products marked: Equipment and utensils used for preparing, processing, and otherwise handling products shall be of such materials and construction as will make them susceptible to being readily and thoroughly cleaned. Cutting boards may be of hardwood or synthetic materials but equipment such as the framework of boning or cutting tables, scalding vats, hog gambreling tables, offal racks, and trees, product storage racks, and product trucks must be of rust resisting metal or other impervious material. Trucks and receptacles used for inedible materials shall be of similar construction and shall bear some conspicuous and distinctive mark, and shall not be used for handling edible meat products.

Regulation 20. Scabbards for knives: Scabbards and similar devices for the temporary retention of knives, steels, triers, etc., shall be constructed of rust resisting metal or other impervious materials, shall be of a type that may be readily cleaned and shall be kept clean.

Regulation 21. Persons keeping hands and implements clean: Persons who dress or handle diseased carcasses or parts shall, before handling or dressing other carcasses or parts, cleanse their hands with soap and hot water, and rinse them in clean water. Implements used in dressing diseased carcasses, shall be thoroughly cleansed in boiling water or in a prescribed disinfectant, followed by rinsing in clean water. The persons who handle meat shall keep their hands clean and after visiting the toilet rooms or urinals shall wash their hands before handling any products or implements used in the preparation of meat.

Regulation 22. Clothing Clean: Shrouds, aprons, frocks, and other outer clothing worn by persons who handle products shall be of cleanable material. Only clean garments shall be worn. Cattle shrouds must be laundered after each use.

Regulation 23. Insanitary practices Prohibited: Such practices as spitting on whetstones; spitting on the floor; placing skewers, tags, or knives in the mouth; inflating lungs or casings or testing with air from the mouth receptacles intended as containers or any products are prohibited. Care shall be taken to prevent the contamination of products with perspiration, hair, cosmetics, medicaments, or other material. All persons working in departments where exposed edible meat is handled must wear head coverings.

Regulation 24. Protective Coverings for Products: Products shipped from establishments shall be wrapped or otherwise adequately protected against contamination or soilage from harmful chemicals, dust, dirt, insects, and the like. No vehicle which has been used for transporting material likely to soil or contaminate meat shall be used to transport meat unless first thoroughly cleaned and if necessary, disinfected.

Regulation 25. Burlap wrapping for meat; Meat Wrapped in, To be previously Wrapped in Paper or Cloth: The use of burlap as a wrapping for meat will not be permitted unless the meat is first wrapped with a good grade of moisture resistant paper or cloth of a kind which will prevent contamination with lint or other foreign matter.

Regulation 26. Slack Barrels and Similar Containers and vehicles and Cars for Products, Paper in Contact with Product:

- (a) When necessary to avoid contamination of meat with wood splinters, slack barrels and similar containers and vehicles shall be lined with suitable material of good quality before packing.
- (b) Slack barrels and similar containers in which meat is transported shall be kept in a clean and sanitary condition.
- (c) Paper used for converting or lining slack barrels and similar containers and vehicles shall be of a kind which does not tear during use, but remains intact when moistened by the meat and does not disintegrate.

Regulation 27. Second Hand Containers: Second hand containers may be used as containers of meat providing:

- (a) If of non-pervious material such as wood and cardboard, they are clean and properly lined and show no evidence of contamination from decomposed material, harmful chemicals, vermin excreta and the like; provided that such containers used for meat which is properly wrapped need not be lined. Those showing evidence of contamination may not be used even though reconditioned.
- (b) If of impervious material such as steel drums they are capable of being maintained in a sanitary condition and are thoroughly cleaned before being used.

Regulation 28. Flies, Rats, Other Vermin; Baits, Poisons:

Every practicable precaution shall be taken to keep establishments free of flies, rats, mice and other vermin. All windows and doors opening to the outside shall be screened with No. 16 mesh or finer screen. Louvers should be screened only on the top of the baffle so that debris will not collect. Sprays containing DDT or other approved residual-acting chemicals must not be used in edible products departments. The use of poisons for any purpose in rooms or compartments where any unpacked meats are stored or handled is forbidden, except under such restrictions and precautions as the department may prescribe. The use of bait poisons in hide cellars inedible compartments, out-buildings, or similar places, or in storerooms containing canned or tierced products is not forbidden, but only those approved by the department may be used. So-called rat viruses shall not be used in any part of an establishment or the premises thereof.

Regulation 29. Animals Excluded from Rooms Where Edible Products handled, stored or prepared: Animals other than those in the process of slaughter shall be excluded from rooms in which edible products are handled, stored or prepared.

Regulation 30. Outer Premises, Docks, Driveways, Approaches, Pens, Alleys, Etc.; Fly Breeding Material, Nuisances: The outer premises of every establishment, embracing docks and areas where vehicles are loaded, and the driveways, approaches, yards, pens, and alleys shall be kept clean and in orderly condition. The accumulation on the premises of establishments of any material in which flies may breed, such as hog hair, bones, paunch contents, or manure, is forbidden, no nuisance shall be allowed in any establishment or on its premises.

Regulation 31. Employee Health:

- (a) **Employment of Diseased Persons:** No person shall work, nor shall any operator permit any person to work, in any room or rooms where meat is processed, stored, sold, when such person is infected with any disease or condition, transmissible to or through food; provided; further, the department may require any person so working to be examined by a physician licensed to practice medicine in this state for the existence of any such disease or condition and provide a statement signed by such physician reciting freedom therefrom.
- (b) Every person employed in a slaughterhouse who may contribute to the transmission of infectious diseases through the nature of his contact with meat and/or equipment and facilities shall obtain and place on file with the person in charge of such establishment, a Food and Beverage Service Worker's Permit as prescribed by Chapter 69.06 RCW and the Rules and Regulations promulgated pursuant thereto.

PART III - ASSIGNMENT, STAMPING, RECORD KEEPING AND CONDEMNATION OF MEAT

Regulation 32. Schedule of Days and Hours of Operation to be Submitted: A schedule of days of operation must be submitted to the department for approval. Operations may not be conducted on days and hours other than those approved without obtaining advance approval of the department.

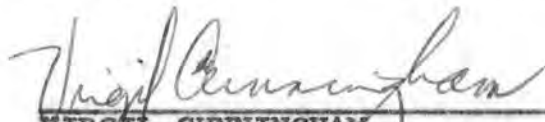
Regulation 33. Assignment of Official Number: An official number shall be assigned to each establishment. Such numbers shall be used to identify all carcasses at that establishment as required by Regulation 34.

Regulation 34. Carcasses and Parts to be Stamped: Each custom slaughter plant operator shall obtain from the department an official number. The outer surface of each quarter of each carcass and all edible parts of a meat food animal slaughtered by a custom slaughterer shall be roll stamped with the official custom slaughterer's number and the words "Not Inspected - Custom Plant No. _____," in letters not less than three-eighths inch in height before leaving the establishment where slaughtered. No person shall transport on the highways, meat slaughtered at a custom slaughter establishment unless it is stamped as herein provided. There shall be an interval no greater than one-half inch between each line of the words "Not Inspected - Custom Plant No. _____."

Regulation 35. Proof of Ownership to be Kept by Operator: The operator of any custom slaughtering establishment shall have in his possession certificates of permit or other satisfactory proof of ownership of all roll stamped carcasses or parts thereof in his establishment, and such proof of ownership must be kept on file for a period of six (6) months after receipt of the carcass or part of carcass.

Regulation 36. All Meat Received to be Handled, Stored, and Prepared so as to Prevent Contamination of Other Meat: The department shall condemn and make unfit for human consumption any meat which upon examination is found to be unwholesome or which creates an insanitary condition on the premises and/or which may make unwholesome other meat being handled, stored or prepared on such premises.

I hereby certify that the foregoing is a true and correct copy of the regulations promulgated by the Department of Agriculture.



VIRGIL CUNNINGHAM
Acting Director of Agriculture
State of Washington

Signed at Olympia, Washington

Date: October 27, 1961