

EstNbr	EstName	MOINbr	Date	Task Code	TaskName	Status	MOI Agenda
M13289+P963	Cargill Meat Solutions	NRD4522024226G	26FEB2020	04C05	Poultry Good Commercial Practices	Finalized	<p>GCP Good Commercial Practice MOI Day, Date and Time of Meeting: Wednesday 2/26/2020 from approximately 2225 to 2232 (CST) Place Meeting Held: Est. P963 SPHV office Persons Attending: FSIS Attendee - (b)(6) (b)(6) Cargill Protein Attendee - (b)(6) Evisceration Area (b)(6) Author of this Meeting Report: (b)(6) Date this Meeting Report was Written: Wednesday 2/26/2020 Subject: GCP Good Commercial Practice MOI. Background concerning this Poultry Good Commercial Practice (GCP) Non-Regulatory Issue: On Wednesday February 26 from 2210 to 2214 CST, I performed a Poultry Good Commercial Practices (GCP) PHIS task by observing carcasses prior to entering the scald tank on the kill line. At 2214 during the check, I observed 1 live bird that had a small cut on the right side of its neck, was conscious, eyes open, neck curved upward, looking around, and alert. This was a smaller than average hen for the lot. I stopped the kill line, and a team lead in the area removed this live bird from kill the line 2 at 2214, before the bird would have entered the scald tank. He immediately examined the cut, and summoned Live Receiving (b)(6) to the area. The hen bled out approximately 90 seconds after she was removed from the line. From where she was removed from the line to the scald tank takes approximately 20-30 seconds. (b)(6) saw the deceased bird and immediately began investigating the cause. While waiting on (b)(6) I observed carcasses on the kill line and did not find any other live birds. There was 1 backup harvester present during my observations. Discussion notes for the meeting with Plant management on Wednesday February 26, 2020 between 2225 and 2232 hrs concerning this GCP incident: I met with Evisceration Area (b)(6) in the SPHV office from 2225-2232. During this meeting I described my observations concerning this incident as outlined above. I then told (b)(6) that due to the results of observation of the kill process and no other live birds seen prior to the scald tank, the 1 live bird I had observed and had removed from the kill line at 2214 before it entered the scald tank during the GCP check today was deemed to be an isolated incident and not a loss of plant killing process control. Thus, I will issue a Poultry Good Commercial Practice MOI in lieu of a GCP NR concerning this incident as per guidance in FSIS Directive 6110.1 dated 7/3/2018. At this time, (b)(6) stated they were investigating the root cause of the incident and would let IPP know the results of the investigation.</p>

Table: MOIs in Response to FOIA2020-471

EstNbr	EstName	MOINbr	Date	Task Code	TaskName	Status	MOI Agenda
M18866+P55 1	Jennie-O Turkey Store Sales, LLC	WJL1616120 026G	26DEC2019	04C05	Poultry Good Commercial Practices	Finalized	<p>December 26, 2019 I, (b)(6) went to live hang to do a good commercial practices verification task. When I arrived in live hang, a truck was just coming off the hoist. I stood to the side while the truck drove off the hoist. It was about 3:37 pm. Immediately after the truck drove off the hoist, I saw movement on the hoist. I observed a turkey flapping and twitching on the end of the hoist. The turkey was located directly in the path of the wheels. The turkey was severely injured. The head was missing. The skin over the abdominal and thoracic cavities was torn away. The abdomen was torn open and viscera hanging out. The turkey was crushed and dead. It appeared the turkey had been run over by the truck. While I was present, I did not observe any establishment employees checking for live birds in the area, as outlined in their ante mortem program. An employee removed the turkey carcass from the hoist and set it aside. I notified the hang and kill (b)(6) (b)(6) and brought him back to the hoist at about 3:39 pm. I showed him the carcass and where the carcass had been on the hoist. I described my observations. I informed (b)(6) of the establishment's failure to follow good commercial practices by allowing a live turkey to be run over by a truck. I informed him of my intent to issue this MOI. (b)(6) offered as a corrective measure to retrain the live hang crew.</p>

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M18866+P55 1	Jennie-O Turkey Store Sales, LLC	WJL4022023 004G	04FEB2020	04C05	Poultry Good Commercial Practices	Finalized	<p>During night shift production the 29th of January 2020 while performing Good Commercial Practice verification beginning at 4:40am, the following was observed: Observations were made of 5cm to 30+ cm bruising identified near the ankle joints and along the length of drums and fractured and bruised wings at elbow joints post pickers and post bleedout. Over a 5 minute period with the line speed varying from 40-45bpm, 65 carcasses had either drum bruising and/or wing fractures. The bruising was dark purple to red in color signifying an acute and recent ante-mortem event causing the bruising. Observations in the live haul offloading area included the four slides from the front passenger side offloading space on the catwalk in the live haul area missing. Slides are used to decrease the force required for offloading and to assist transfer of live turkeys from the trailers to the conveyor leading to the CO2 gas stunner. The live haul offloader was observed unloading turkeys without the use of the slides, with the turkeys repeatedly hitting the bar leading onto the conveyor with legs. Compared to the other offloading crew, the crewmember was using more force to remove the turkeys: quicker movements with offloaded live birds having enough momentum to hit the back of the conveyor tunnel wall. The four missing slides were found beneath the CO2 stunner, and communication with live haul (b)(6) identified the four slides as being out of commission due to needing maintenance repair. Over the course of 3 minutes, I demonstrated to him observations of bruising and fractured wings on the post-picking line and concerns with injury at offloading based on what I'd observed in live haul. I also communicated with night shift (b)(6) of the observations and GCP concerns. Verbal corrective actions given at 5:20am included adding an additional two people to the offloading crew so the offloader working without slides had additional support for the turkeys being offloaded. After a company break, I returned to live haul to observe corrective actions. No corrective actions were instituted at 5:45am and bruising continued to be observed post-pickers. Respectfully submitted by (b)(6) (b)(6) relief</p>

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EstNbr	EstName	MOINbr	Date	Task Code	TaskName	Status	MOI Agenda
M20322+P20322	Equity Group Eufaula Div LLC	ATF4804013315G	15JAN2020	04C05	Poultry Good Commercial Practices	Finalized	On Wednesday, January 15, 2020, at approximately 0348 hours, while performing Good Commercial Practices observations, on line 3, at the entrance of the scalders, I observed a live bird enter the scalders. The bird had its neck arched back, and slightly tucked towards the shoulders. The eyes were open, and blinking I observed the head moving, and it was aware of its surroundings. It was breathing, and there was no noticeable blood or cut of the neck. There were no other additional live birds observed to enter the scalders. I immediately notified the live hang (b)(6). The aforementioned observations were discussed with Evis. (b)(6) at approximately 0430 hours. Reference Federal Register Docker #04-037N.
M20322+P20322	Equity Group Eufaula Div LLC	ATF0313052127G	27MAY2020	04C05	Poultry Good Commercial Practices	Finalized	On 05/27/2020, at approximately 1138 while performing my Good Commercial Practices at the entrance of the scalders on Line 3, (b)(6) and myself observed four uncut, live birds pass by at approximately 1138 (pair #1) and 1139 (pair #2). I noted that the birds were breathing and alert to their surroundings. At the point of observation, the establishment has no further humane measures in place to ensure that all breathing has stopped prior to entering the scalders. I visually followed the birds as they entered and exited the head puller (prior to the entrance of the scalders) and into the scalders where both sets of pairs entered still breathing. I immediately notified 1st Shift (b)(6) and Live Hang (b)(6) of my observations. After notification, the establishment elected to immediately suspend hanging operations. In speaking with (b)(6) it was determined that the backup killer was a newly trained employee performing this specific job for the first time. Management replaced this employee with an experienced employee and resumed operations. At approximately 1208, once corrective actions were in place, (b)(6) and myself performed an additional, extended GCP check to ensure that corrective actions were effective. No further deficiencies were observed. (b)(6) stated that in the future when there is a newly trained/hired employee, they will have a second trained individual at the backup kill position to ensure training effectiveness. Equipment effectiveness was also evaluated and no obvious issues were noted. No other vulnerabilities were noted during today's production.

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EstNbr	EstName	MOINbr	Date	Task Code	TaskName	Status	MOI Agenda
M20322+P20322	Equity Group Eufaula Div LLC	ATF3007062305G	05JUN2020	04C05	Poultry Good Commercial Practices	Finalized	<p>On 06/05/2020, at approximately 0641 while performing my Good Commercial Practices at the entrance of the scalders on the single kill line for Lines 1 & 2, I observed four uncut, live birds pass by at approximately 0642 (2 birds approximately 15 birds apart) and 0643 (2 birds approximately 10 birds apart). I noted that the birds were breathing and alert to their surroundings. At the point of observation, the establishment has no further humane measures in place to ensure that all breathing has stopped prior to entering the scalders. I visually followed the birds as they entered and exited the head puller (prior to the entrance of the scalders) and into the scalders where all four birds entered still breathing. I immediately notified 1st Shift (b)(6) and Live Hang (b)(6) of my observations. (b)(6) stated the experienced backup killer had gone on break and a less experienced backup killer had taken their spot. He stated in the future, when the less experienced employees are filling that position, they will move a third person on the line to ensure that all birds are appropriately cut. In addition, he stated that retraining would be conducted with that particular employee. At approximately 0714, once corrective actions were in place, I performed an additional, extended GCP check to ensure that corrective actions were effective. No further deficiencies were observed. Equipment effectiveness was also evaluated, and no obvious issues were noted (large variation in bird size observed). No other vulnerabilities were noted during today's production.</p>
M2130+P2130	Cooper Farms Processing	HEF2803015122G	22JAN2020	04C05	Poultry Good Commercial Practices	Finalized	<p>On January 22, 2020 at approximately 4:15 AM while performing a routine GCP task, I (b)(6) was passing through the live hang area where stunned turkeys are shackled on a conveyor belt (approximately 3-4 feet in height from the floor), and observed an employee push a stun failure (fully conscious turkey) off of the belt, causing the turkey to fall on top of several other conscious turkeys that were already sitting on the concrete floor directly opposite the belt from the employee. I spoke with (b)(6) about what I observed. An SOP for proper handling of conscious birds was to have been implemented in December 2017.</p>

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M2130+P2130	Cooper Farms Processing	HEF2003071202G	02JUL2020	04C05	Poultry Good Commercial Practices	Finalized	<p>On June 29th 2020 at approximately 1:00 AM while performing antemortem inspection on the live haul trailers in the cooling sheds, I, (b)(6) observed a loose, live turkey that was sitting on the ground directly beneath a cage that was partially open. The height of the cage was three cages up from the bottom of the trailer (approximately 8' from the ground), and there were no visible injuries on the bird. This type of cage door is hinged in the middle, and the bottom half of the door was stuck in the folded-up position. There were multiple other live turkeys still present in the cage. I informed an establishment supervisor of this finding, and the bird was placed back into the trailer by live hang employees. Previously, I have observed multiple instances of live turkeys being able to open this type of cage door from the inside. In each case, the turkey is on its back with its head facing the cage door and with its feet over its head, grasping the bars on the bottom half of the door. As the turkey pulls with its feet in this position, it causes the cage door to fold up and inwards at the hinge in the middle, allowing the turkey to begin pushing itself out of the cage while on its back. This type of cage door is only present on the newer live haul trailers.</p>

EstNbr	EstName	MOINbr	Date	Task Code	TaskName	Status	MOI Agenda
M27389+P27389+V27389	Pitman Farms	NCO5414035324G	24MAR2020	04C05	Poultry Good Commercial Practices	Finalized	<p>On 03/24/2020 at approximately 07:39hrs while performing a routine Good Commercial Practice (GCP) task. I (Inspection Plant Personnel) observed 1 conscious chicken. The bird was walking around on the eastside of bleed-line B platform. The platform is approximately 20 feet above floor operations in live-hang. At approximately 07:40 line B was stopped, leaving 2 rows of stunned and bleed chickens on the line. The back-up bleeder employee was getting ready to go to break. I informed him of the bird walking around, he then grabbed it by one leg, hung on the bleed-line and cut the throat. After the employee left for break I continued to make observations for bleed-line B. At 07:43hrs I found a conscious chicken hanging, after the back-up stunner, kill machine and back-up bleeder. The bird was in the second row, at south end of line B, and made reactive movement by trying to right itself, flapping its wings, and blinking when I waved my hand near the bird. When the back-up bleeder employee returned at approximately 07:47hrs, I showed him the conscious bird, he removed from the line by one leg, re-hung it near his work station and cut the throat. At that time, he observed another bird hanging with the throat not cut in the middle row, near his work station. When he grabbed it by the head it flapped as he cut the throat. The establishment performs CO2 stunning and these birds were not stunned properly, the back-up stunner failed, the kill machine failed, and back-up bleeder failed. The actions taken to cut the throats and prevent the 2 birds from entering the scalding tank was necessary, because prior to being scalded there is a head remover station before any scalding begins. The close time in observations did not allow me to find management before the employee returned from break. The company went to mass break, and the supervisor of live-hang went to break too. At approximately 07:50hrs I did inform line (b)(6) of my observations, he understood the observations and would inform the live-hang supervisor immediately. I informed (b)(6) that I would be documenting and Memorandum of Interview (MOI) for the GCP findings.</p>

