



Consumer Health Services

A Division of the WY Dept. of Agriculture

Wyoming Poultry and Poultry Product Exemptions

2009

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Introduction

There is an increasing interest of small poultry producers, also called “growers,” to raise, slaughter, and process their poultry on their farms and sell the poultry directly to retailers, hotels, restaurants, institutions, wholesale markets, as well as customers directly from his/her own farm or at farmers’ markets. This guide is helpful to producers or businesses in determining whether their slaughter or processing operations would require State inspection, as mandated in the Poultry Products Inspection Act (PPIA).

In addition, this guidance material can serve as a quick reference for State inspection personnel who have questions about whether a poultry operation qualifies for an exemption in the PPIA. This guidance does not address exemptions related to livestock product (e.g., meat from cattle, swine, sheep, goat, and equine) because the Federal Meat Inspection Act does not provide exemptions similar to those provided in the PPIA.

The 1957 Wholesome Poultry Products Act (Public Law 90 – 492), which is commonly referred to as the Poultry Products Inspection Act (PPIA) was passed by Congress to ensure that only wholesome poultry that is not adulterated and not misbranded enters interstate or foreign commerce. The 1957 Act mandated Federal inspection at businesses that slaughter poultry or process poultry products that enter interstate or foreign commerce. Congress amended the Act in 1968, extending the mandate for Federal inspection to all businesses that slaughter or process poultry for shipment within a State, when the State does not enforce requirements “at least equal to” the Federal inspection requirements in the PPIA. Because of this amendment, any business in any State that slaughters or processes poultry for use as human food is required to do so under Federal or State inspection, unless the slaughter or processing operations at the business meets certain exemption criteria in the Act.

What does exempt mean?

The term “exempt” means that certain types of poultry slaughter and processing operations qualify to operate without the benefit of State inspection on a daily basis, and grant of State inspection is not required. Such operations are exempt from continuous bird-by-bird inspection and the presence of inspectors during the slaughter of poultry and processing of poultry products. However, a facility operating under such an exemption is not exempt from all requirements of the Act. It was not the intent of Congress to mandate State inspection of an owner’s private holdings of poultry or to mandate inspection at businesses that slaughter or process a small amount of poultry. Therefore, the PPIA exempts some poultry slaughter and some processing operations from certain requirements of the Act.

The Act **does not** exempt any person slaughtering or processing poultry from the provisions requiring the manufacturing of poultry products that are not adulterated and not misbranded. Thus, all businesses slaughtering or processing poultry for use as human food, including exempt operations, must produce poultry product that is not adulterated or misbranded.

What is Slaughter? The term slaughter refers to the act of killing poultry for use as human food.

Exemptions: Raw poultry products **only** are permissible under the following exemptions.

The regulatory provisions found in Title 9 of the Code of Federal Regulations (CFR) 380.10 cover eight types of exempt poultry slaughter and processing operations. Two of these exemptions may pertain to Wyoming producers and will be discussed in this module.

1. Custom slaughter/processing for personal use growers
2. Slaughtering/processing no more than 1,000 birds in a calendar year

The slaughter and processing of poultry must be conducted in a manner which ensures carcasses and products are wholesome, not adulterated, and properly marked, labeled, and packaged. In accordance with 9 CFR 381.10, 381.13, and 381.14 of the regulations, the following are the basic requirements for operations claiming exemption from the inspection requirement of the PPIA.

Custom Slaughtering and Processing Exemption

The *Custom Poultry Slaughtering and Processing Exemption* applies to a business or person who slaughters and processes poultry belonging to someone else for the personal use of the owner of the poultry.

The business provides a service, not a product, to a customer and **must not engage in the business of buying or selling poultry products capable of use as human food**. The custom slaughter business may slaughter or process an unlimited number of birds when the birds are delivered by the owner and it meets the following criteria.

1. The custom slaughterer does not engage in the business of buying or selling **poultry products** capable for use as human food.
2. The slaughtered or processed poultry is for the personal use of the grower/owner of the poultry and the grower/owner may **not** sell or donate the custom slaughtered poultry to another person or institution.
3. The poultry is healthy when slaughtered.
4. The slaughter or processing at the custom facility is conducted in accordance with the sanitary standards, practices, and procedures that produce poultry products that are sound, clean, and fit for human food (not adulterated). Food Safety Inspection Service (FSIS) *Sanitation Performance Standard Guidelines* are available on the FSIS website to assist custom operators in meeting sanitation requirements of 9 CFR 416.1 through 416.5.

5. The product packaging must bear:
 - a. The owner's name
 - b. The owner's address
 - c. The statement, "Exempt P.L. 90-492"
 - d. The statement, "Not for Sale"

These four items are in lieu of all the required features of a label for inspected and passed poultry products. Also, instead of the Federal law 90-492, a State law may be cited when the inspection of the slaughter and processing of poultry is exempted under the authority of a State law, and the operations are reviewed by the Wyoming Department of Agriculture (WDA) Consumer Health Services (CHS).

Custom Slaughter Exemption Notes:

- If any of the five criteria are not met, the owner of the facility is not eligible for this exemption.
- Selling live poultry to a customer does not disqualify a business from the Custom Slaughter Exemption. For example, a custom slaughterer may sell live poultry to a person and then custom slaughter the bird. However, a person who custom slaughters poultry may **not** buy or sell poultry products used for human food.
- A person operating under a Custom Slaughter Exemption may slaughter and process poultry of his or her own raising provided such slaughtered poultry is for his or her exclusive consumption, or consumption by members of his or her household, nonpaying guests, and employees.
- A person who is a custom slaughterer and who is also a poultry grower may raise and sell his or her live poultry to poultry businesses not associated with his or her custom slaughter business.

Producer/Grower 1,000 Bird Limit Exemption

Under the *Producer/Grower 1,000 Bird Limit Exemption*, a person may slaughter and process (on his or her premises) poultry that he/she raised and he/she may distribute such poultry without mandatory daily inspection. The limited provisions of the Act apply to poultry growers who slaughter no more than 1,000 birds in a calendar year for use as human food, and meet the following criteria.

1. The producer or grower slaughters no more than 1,000 healthy birds of his/her own raising in a calendar year.
2. The producer or grower sells/distributes **only** poultry product produced from poultry raised on his/her own farm.
 - a. **Birds shall be raised from not more than one week of age.**

3. Slaughter and processing are conducted under sanitary standards, practices, and procedures that produce products that are sound, clean, fit for human food, and not adulterated.
4. Records - The producer or grower keeps records necessary for the effective enforcement of the Act. Records include slaughter records and records covering the sales of poultry products to customers. These records are subject to review by the United States Department of Agriculture (USDA) FSIS, or by the WDA – CHS to determine compliance with the requirement for sales not to exceed 1,000 poultry in a calendar year. Record of age verification must be kept on site to ensure birds are being purchased/raised less than one week of age. If birds are purchased from outside the producer’s own operation, the source of the purchased birds must be kept on record.
5. Producers may sell products produced under the Producer/Grower – 1,000 Limit Exemption **intrastate** (within the state of Wyoming) to retailers, hotels, restaurants, institutions, wholesale markets, as well as customers directly from his/her own farm or at farmers’ markets.
6. The poultry products may **not** move in **interstate** commerce, where the exchange or transportation of poultry products is between states and/or U.S. territories as specified in 9 CFR 381.10 (c)(3).

There is no requirement for poultry products produced under the Producer/Grower 1,000 bird exemption to bear the “Exempt P.L. 90-492” statement if all the provisions in 9 CFR 381.10 (c)(1), (2), and (3) are met. Currently, safe handling instructions are required on exempt poultry products sold in commerce, but this may be subject to change. The producer’s name and address are required on all product packaging.

Producer/Grower – 1,000 Limit Exemption Notes:

- If any of the six criteria are not met, the owner of the poultry is not eligible for this exemption.
- Records necessary for the effective enforcement of the Act include slaughter records and records covering the sales and/or purchases of poultry products to and/or from customers. State employees review such records to determine compliance with the requirement of the sale of no more than 1,000 poultry in a calendar year.

Notice: A person or business may slaughter or process poultry under an exemption if the operation qualifies for the exemption. However, a slaughterer or processor of poultry **may not simultaneously operate under more than one exemption**, unless granted an exemption by WDA – CHS.

Summary Table of Poultry Exemptions and Limitations

Criteria	Custom	Producer/Grower – 1,000 Bird Limit
Slaughter Limit	NONE	YES 1,000
Processing	YES	YES
75 lb Sale Limit to Consumer	NO SELLING	NO LIMIT
150 lb Limit to HRI	NO SELLING	NO LIMIT
25% of Total product / 75% HRI Sale	NO SELLING	NO LIMIT
HRI Dollar Limitation	NO SELLING	NO
Can Sell to any Consumer (household, consumer, hotel, or restaurant, or similar Institution)	NO	YES
Can sell to HRI	NO	YES
Sells poultry they slaughter or process to distributors for resale	NO	YES
May Sell to Retail Stores	NO	YES
Processed poultry sold & distributed to <i>Intrastate</i> Consumers	NO	YES
Processed poultry sold at store & distributed to <i>Interstate</i> Consumers	NO	NO
Safe handling Instructions	NO	YES
PL 90-492	YES	NO



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List of Requirements For Poultry Slaughter and Processing Facilities

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Glossary

Amenable Species – Any species regulated in the Federal Meat Inspection

Act (FMIA) or the Poultry Products Inspection Act (PPIA), which includes, but is not exclusive of: beef, pork, goat, sheep, chicken, turkey, ratites, etc. Federal inspection is required for interstate sales. State or federal inspection is required for intrastate sales.

Custom – An operation that is “exempt” from inspection with limitations. An operation may provide a service of slaughtering and/or processing for the owner of that animal or product, without the benefit of inspection. This is allowed providing it is for his or her exclusive consumption, or consumption by members of his or her household, nonpaying guests, and employees. All custom products must be identified as “Not For Sale.”

Federal – An operation that slaughters and/or processes meat or poultry products under the inspectional supervision of United States Department of Agriculture (USDA) employees. These products may be sold wholesale between any State, Territory or District of Columbia. These products may also be exported to other countries.

Food Animals – Domestic animals such as cattle, swine, sheep, goats, rabbits, poultry and ratites intended for use as human food. Also included in this definition are captive game animals, such as bison, whitetail deer and other animals of a normally wild type that are raised in captivity intended for use as human food. Additionally, captive game birds, which are farm-raised game birds, such as pheasants, quail, wild turkeys, waterfowl and exotic birds that are intended for use as human food.

Poultry – Domestic fowl such as chickens, ducks, geese, turkeys, guineas and squab that are intended for use as human food.

Interstate Meat & Poultry Sales – Amenable species must have federal inspection to be sold or shipped across state lines. Non-amenable species must have federal or state inspection to be sold or shipped across state lines. As it stands, meat products may be posted on a web page to be sold, providing the product has been inspected. If a person orders a meat product from outside of Wyoming, and the product is an amenable species of the Federal Meat Inspection Act (FMIA), then the product must bear the **Federal** mark of inspection to be shipped. If the product is from a non-amenable species of the FMIA (i.e.: exotic species such as buffalo), then only **State** inspection is required for shipping. If the product is going to be shipped through the postal system, then the product must bear the **Federal** legend to cross the Wyoming State line. If the product is not going to cross the Wyoming State line, then **State** inspection is allowed.

Meat – Edible muscle and other edible parts of a food animal.

Non-Amenable Species – Any species that is not regulated in the FMIA or PPIA, but falls under a voluntary inspection program. These species may include, but are not limited to bison, rabbits, reindeer, etc. Non-amenable species may be sold through interstate commerce

with State inspection, whereas, USDA inspection is required for amenable species.

Voluntary Inspection – In Wyoming, amenable and non-amenable species are treated the same. Therefore, inspection is required for the sale of any species of animal.

Wyoming Intrastate Sales – The sale of any product within the State of Wyoming.

Wyoming State Inspected Establishments – An operation that slaughters and/or processes meat or poultry products under the inspectional supervision of Wyoming Department of Agriculture Consumer Health Services employees. These products may be sold as retail and/or wholesale within the boundaries of Wyoming.

Application Process

Approval

1. Approval from the department needs to be granted prior to opening for business (9 CFR 304.1). State inspected and custom plants must meet all of the following requirements:
 - a. Floor plan and specifications
 - b. Letters of guarantee
 - c. Apply for food establishment license
 - d. Inedible permit
 - e. Water & Sewage approval if on municipal supply
 - f. Septic Approved
 - g. Well approved and sampled
2. After the above requirements have been met, approval from Consumer Health Services will be granted within a minimum of two weeks.

Design of Establishment

Layout

1. Determining the layout of the building, the placement of rooms and equipment, product flow and people traffic patterns are very important when designing an establishment.
2. A poorly designed establishment will affect your productivity, and result in congested operations that can lead to unsanitary conditions.

Flow of Operations

1. The flow or direction in which product moves within the plant is an important factor that can have an enormous influence on sanitation, as well as the food safety of finished products.
2. All raw poultry products should be considered as potentially microbiologically contaminated and handled accordingly.
3. The flow of air and people should move progressively in a direction from the cleanest areas toward less clean areas without backtracking.

Separation of Custom and Exempt Operations and Product

1. In the circumstance that WDA/CHS has granted multiple exemptions to an establishment, the following guidelines for operation and product separation shall be practiced.
 - a. Slaughter of custom birds shall be done on a separate day than exempt birds, or at the end of the shift when the exempt birds have all been slaughtered.
 - b. Custom product shall be kept separate when stored in the cooler as follows:
 - i. Custom product shall not be touching or come in contact with exempt product.
 - ii. When stored on a shelf, custom product shall be stored below exempt product.
 - c. Custom product shall be processed on a separate day, or at the end of the shift when the exempt product has been finished being processed.

Vehicular Areas Outside the Building

1. Special care should be given in the design of vehicular areas outside your building, to prevent unsanitary conditions that might contaminate product in your establishment.
2. The following should be considered:
 - a. Areas outside the building where vehicles are loaded or unloaded should be paved with concrete or a similar hard surface. Hard surfaces allow these areas to be kept clean and reduce the potential for water puddles or dust.

Construction

Materials

1. Care should be taken when selecting construction materials for the establishment.
2. The following are considerations that should be taken when selecting materials.
 - a. Production and storage areas need to be constructed with materials that are readily and thoroughly cleanable.
 - b. In order to be readily and thoroughly cleaned, building construction materials in production and storage areas must be:
 - i. Rigid and durable
 - ii. Non-toxic and non-corrosive
 - iii. Impervious to moisture
 - iv. A light, solid color such as white
 - v. Smooth or textured with an easily cleaned, open pattern
3. Consider the following guidelines for selecting construction materials:
 - a. In non-production and non-storage areas, building construction materials should be easy to thoroughly clean.

- b. Special consideration should be given before using wood as a construction material.
- c. Wood surfaces must not be exposed in areas where there is high moisture.
- d. All wood surfaces in other areas must be sealed so they are resistant to staining, easily cleanable, and non-absorbent.

Floors

1. Floors in areas where product is handled or stored should be constructed of durable, easily cleanable materials, and be impervious to moisture. Commonly used materials are concrete, quarry tile, brick, and synthetic material.
2. Floors should be installed and maintained to reduce the likelihood of cracks, depressions, or other low areas that would accumulate moisture.
3. Floors where operations are conducted should have a slip-resistant surface. Good results are obtained by using brick or concrete floors with abrasive particles embedded in the surface. Concrete floors should have a rough finish.
4. Floors should be sloped bearing minimal depressions where water may stand.

Coving/Curbs

1. Coving is used at the wall-floor juncture, column (post) floor juncture, and equipment support-floor juncture to provide a smooth transition for ease of cleaning and inspection.
2. Consider the following guidelines when using coving or curbs:
 - a. Coving in production and storage areas should include the following criteria:
 - i. All seams should be tight-fitting and sealed to eliminate all cracks and crevices, which may shelter insects, vermin and microorganisms.
 - ii. The coving should eliminate any sharp angles that allow the accumulation of materials.
 - b. Curbs should be provided to protect walls and wall finishes.
 - c. Curbs should be high enough to protect the walls from pallets, trucks, or containers used in the establishment.
 - d. Coving should be provided at the base of the curb.

Interior Walls Including Posts and Partitions

1. To prevent product from becoming contaminated by contact with interior walls, care needs to be taken in selection of materials for the finished surface of walls.
2. Consider the following guidelines when selecting a finish:
 - a. Interior walls in areas where product is stored or handled should be finished with materials that can be thoroughly cleaned and is impervious to moisture.
 - b. Examples are glazed brick, glazed tile, smooth concrete, and fiberglass reinforced paneling.

- c. Walls should have a smooth texture, not one that is rough or uneven.
- d. Fasteners for wall-covering material should be solid, smooth headed, and not have recesses, which allow the collection of foreign materials.

Ceilings

1. Ceilings in areas where product is stored or handled should be constructed to prevent the collection of dirt or dust that might sift through from the areas above or fall from overhead collecting surfaces onto equipment or exposed products.
2. It is recommended that ceilings and overhead structures be maintained free of sealing paint or plaster, dust, condensate, leaks, and other materials or defects.
3. Ceilings in areas where product is stored or handled should be constructed and finished with materials that can be thoroughly cleaned and are moisture resistant.
4. Examples of such materials are smooth concrete and fiberglass reinforced paneling.

Doorways and Types of Doors

1. Doors are barriers that allow the movement of product and people, but also present a barrier to contamination such as dirt, insects, and other vermin as well as the microbiological hazards that they carry.
2. The door type, construction materials and room in which the door is located are all important considerations when doors are installed in the establishment.
3. Doors are important in maintaining sanitary conditions especially in production and storage areas.
4. Consider the following guidelines for the most effective doors:
 - a. They are impervious to moisture.
 - b. They are high and wide enough to allow the movement of exposed product through the doorways without it coming into contact with the door or jamb.
 - c. They are rigid and durable, and the junctions at jambs, walls, and floors are sealed to eliminate all cracks and crevices for debris, insects, and dirt to collect.
5. In selecting a type of door for your establishment, you need to consider the location of the door and whether or not product will be traveling through it.
6. Exterior doors used as exits need not be self-closing if they are:
 - a. Solid and tight-fitting.
 - b. Designated by the appropriate fire protection authority for use only when an emergency exists.
 - c. Restricted so they are not used for entrance or exit from the building for purposes other than designated emergency exit use.

Ventilation

1. There should be enough ventilation for all areas of the establishment including workrooms, processing, packaging, and welfare rooms to ensure sanitary conditions.
2. A good ventilation system is important to the production of wholesome poultry products.
3. Without controlling the quality of the air coming into the establishment, products may become contaminated with dust, insects, odors, or condensation.
4. The following should be considered when designing your ventilation system:
 - a. The ventilation system should be designed so that turbulence is avoided. The longer the distance the air has to flow, the greater the resistance the air encounters not only from static air, but also from solid objects such as walls, equipment, people, and product.
 - b. Heating, ventilating, and air conditioning systems shall be designed and installed so that make-up air intake and exhaust vents do not cause contamination of food, food-contact surfaces, equipment, or utensils.
 - c. Exhaust ventilation hood systems, which include hoods, fans, guards, and ducts, in food preparation and ware-washing areas shall be designed to prevent grease or condensation from draining or dripping onto food, equipment, utensils, linens, and single-service and single-use articles.
 - d. To keep rooms free of excessive heat, steam, condensation, vapors, obnoxious odors, smoke, and fumes, mechanical ventilation should be used to bring in fresh air to areas where natural ventilation is inadequate.
 - e. A good ventilation system should direct air flow away from exposed cooked product areas.
 - f. Filters or other grease extracting equipment shall be designed to be readily removable for cleaning and replacement if not designed to be cleaned in place.

Plumbing

Water System

1. If a private well is used to supply water to the facility, the information on the well and sample results shall remain on file. (Required information may be obtained through the State Engineers Office)
2. If the facility is on a public water system, then a letter of verification from the city is needed.
3. The facility must meet the requirements of the Wyoming Food Safety Rule Chapter 8 and 9 CFR 416.
 - a. Water must be distributed throughout the plant under adequate pressure and in quantities sufficient for all operating needs.
 - b. Vacuum breakers (or a device in a water supply line, which opens when there is loss of pressure allowing air to enter to prevent back-

siphonage or back flow) of an acceptable type shall be installed on all water or steam lines connected to various pieces of equipment throughout the plant.

- c. Municipal systems are sampled once per year and private systems are sampled twice per year by CHS staff.

Water Supply

1. Potable water shall be obtained from an approved source that is a public water system or a nonpublic water system that is constructed, maintained, and operated according to law (Wyoming Food Rule Chapter 8 Section 1-10).
2. Approved water systems shall be received from the source through the use of an approved public water main or one or more of the following that shall be constructed, maintained, and operated according to law:
 - a. Nonpublic water main, water pumps, pipes, hoses, connections, and other appurtenances.
 - b. Water transport vehicles.
 - c. Water containers.
3. A drinking water system that has had a seasonal shutdown or an extended period of disuse shall be flushed and disinfected before being placed in service after construction, repair, or modification and after an emergency situation, such as a flood, that may introduce contaminants to the system.
4. Water from a public water system shall meet 40 CFR 141 National Primary Drinking Water Regulations and water from a nonpublic water system shall meet the standards set by the Wyoming Food Rule.
5. Water from a nonpublic water system shall be sampled and tested at least semi-annually.
6. The most recent sample report for the nonpublic water system shall be retained on file in the establishment or processing plant.
7. Water under pressure shall be provided to all fixtures, equipment, and nonfood equipment that are required to use water except that water in response to a temporary interruption of a water supply need not be under pressure.
8. Cross-connections are PROHIBITED and they may appear in many forms and in unsuspected places. Reversal of pressure and flow in the water system may be unpredictable. Plumbing cross-connections between a potable and non-potable water supply may constitute a serious public health hazard.
9. Once a cross-connection exists, any situation that causes a pressure differential with the potable line having the lower pressure can result in contamination of the entire water distribution system and potable water supply.
10. Some areas that you should consider providing some form of protection from backflow and back siphonage include the following:
 - a. Water supply to pens for wash down or livestock watering.
 - b. Water supply to compressor cooling systems, cooling towers, and boiler rooms.
 - c. Water supply to cleanup systems, clean in place systems, etc.

- d. Water supply to hose connections.
- 11. Various mechanical anti-backflow devices are available to prevent backflow into a potable water supply system.
- 12. There are six basic types of approved devices that can be used to correct cross-connections, and they are:
 - a. Air gap
 - b. Barometric loops
 - c. Vacuum breakers-both atmospheric and pressure type
 - d. Double check valves with intermediate atmosphere vent
 - e. Double check valve assemblies
 - f. Reduced pressure principal backflow preventers
 - g. Specific requirements concerning backflow can be found in local building and board of health codes.

Hose Connections and Hoses

- 1. There should be an adequate number of hose connections with steam and water mixing valves or hot water connections provided throughout the establishment for cleaning purposes.
- 2. Hose connections are important in promoting routine cleaning of the establishment.
- 3. Consider the following guidelines when determining how many hose connections, location of hose connections, and storage of hoses:
 - a. The number of hose connections depends on the number of drains.
 - b. If a shut-off nozzle is provided on the hose after the hot and cold water-mixing valve, the vacuum breaker at the hose connection to the mixing valve will not work.
 - c. Vacuum breakers should be installed on the hot and cold water supplies prior to the mixing valve to prevent such problems.
 - d. Hose connections should be provided with vacuum breakers to prevent back siphonage.

Floor Drains

- 1. All parts of floors where operations are conducted should be well drained.
- 2. There are two basic types of drains, point drains and trench drains.
 - a. Point drains (most commonly used) are located in strategic points in the room with the floor sloped toward the drain. The wastewater flows over the surface of the floor until it reaches the drain.
 - b. Trench drains involve a trough or trench that collects the waste from a larger area and directs the flow to a drain opening. The flooring is sloped toward the trench.
- 3. The location of floor drains depends upon many factors such as the type of task conducted in the space, the geometric shape of the area drained and equipment locations.
- 4. Floor drains should not be located under equipment because it makes them inaccessible to cleaning

5. Each floor drain should be equipped with a deep seal trap and vented properly to the outside.
6. All drainage lines must comply with local code requirements. They should be installed and maintained to be leak proof.
7. Secure drain covers, in addition to keeping out pests, also serve to prevent blockage of the traps and drainage lines with product scraps or other material too large to flow freely.
8. Cleanouts should be installed in the drainage system to prevent sewer blockages.
9. The following guidelines should be considered when installing cleanouts:
 - a. Cleanouts should be located so they are readily accessible, and can be used without constituting a threat of contamination to edible products.
 - b. To help avoid water pooling, cleanouts should be located on the “high lines” of floor slopes and away from traffic patterns.

Slaughter and Processing Establishment Requirements

Floor Plans

1. The floor plans must be drawn to scale/dimension and include blueprints and specifications (9 CFR 416.1 – 416.6)
 - a. They must show equipment location including
 - i. Material used on the floors, walls and ceilings
 - ii. Slope of floors to floor drains
 - iii. Plumbing detail including back flow prevention devices and cleanup hose connection shall be provided.

Equipment

1. Equipment and materials should comply with the Wyoming Food Safety Rule for direct food contact.
2. Equipment and utensils used for handling and preparing edible product or ingredients in any official establishment should be easily cleanable so that it will not be a source of contamination.
3. The following guidelines should be considered when selecting equipment:
 - a. All direct product contact surfaces should be smooth and maintained free of pits, cracks, crevices, scale and rust, they should be corrosion and abrasion resistant, non-absorbent, shatterproof, nontoxic, and not capable of migrating into food products.
 - b. Food contact surfaces shall not be painted.
 - c. Construction materials that are sources of contamination and are prohibited include cadmium, antimony or lead as plating or the plated base material. Lead exceeding five percent in an alloy, enamelware or porcelain used for handling and processing product is prohibited.
 - d. Equipment should be designed and installed in such a way that foreign materials, such as lubricants, heat exchanger media, condensate,

cleaning solutions, sanitizers and other nonfood materials, do not contaminate food products.

- e. Equipment is self-draining or designed to be evacuated of water.
- f. Clean-in-place equipment should have sanitation procedures that are as complete and effective as those for cleaning and sanitizing disassembled equipment.

Slaughter

1. Any commercial equipment that is intended for use in an inspected facility shall meet the requirements of the Wyoming Food Safety Rule, Chapter 4 and Chapter 6, and 9 CFR 416.1 – 416.6.
 - a. All equipment must be smooth and easily cleanable as well as maintained in good working order.
 - b. An approved hand-washing sink equipped with hot and cold running water and stocked with soap and paper towels shall be available (9 CFR 307.2m3). More information in the Sink section.
 - c. An approved knife sterilizer, which is large enough to sterilize the entire food contact surface of the largest knife or saw being used, shall be available (9 CFR 307.2f).

Processing

1. Any commercial equipment that is intended for use in an inspected facility shall meet the requirements of the Wyoming Food Safety Rule, Chapter 4 and Chapter 6, and 9 CFR 416.1 – 416.6.
 - a. All equipment must be smooth and easily cleanable as well as maintained in good working order.
 - b. A certified scale must be used for all products sold by weight (9 CFR 317.20). Contact the Wyoming Department of Agriculture, Technical Services Division for details and a license.
 - c. An approved hand-washing sink equipped with hot and cold running water and stocked with soap and paper towels shall be available and conveniently located (9 CFR 307.2m3). More information in the Sink section.

Coolers and Freezers

1. The facility must meet the requirements found in the Wyoming Food Safety Rule, Chapter 9.
 - a. The floors, walls, and ceiling within the coolers/freezers shall be made of a smooth easily cleanable surface.
2. Coolers and freezers shall be large enough to meet the needs of the operation.
3. Coolers shall have an adequate number of floor drains.
4. Product should be stored in a manner that will eliminate conditions that may lead to contamination of product.
5. The following guidelines will help in preventing contamination:
 - a. Coolers and freezers, including doors, should be constructed of materials that can readily and thoroughly cleaned, durable, rigid, impervious to moisture, non-toxic, and non-corrosive.

- b. Freezer doors should be constructed and installed to seal tightly to prevent accumulation of frost.
- c. Coolers and freezers should be equipped with floor racks, pallets or other means to ensure protection of product from contamination on the floor.

Restrooms

1. The facility must meet the requirements of the Wyoming Food Safety Rule Chapter 8 section 47-61.
 - a. There shall be at least one, and not fewer than the number of toilets required by the Uniform Plumbing Code, as amended, shall be provided.
 - b. Restrooms shall be completely enclosed and constructed with a tight fitting, self-closing door.

Sinks

1. The facility must meet the requirements in the Wyoming Food Safety Rule Chapter 8 and 9 section 15.
 - a. All prep and clean up sinks must be plumbed with an indirect drain.
 - b. A three-compartment sink with drain boards, utensil racks, or tables on each end shall be provided for utensil/equipment washing, rinsing and sanitizing.
 - c. A separate sink is required for any food preparation.
 - d. Hand washing sinks shall be installed to allow convenient use by employees in food preparation, food dispensing and ware washing areas and in bathrooms.
 - e. Hand washing sinks in establishments shall be provided with hot and cold water tempered by means of a mixing valve or combination faucet, have soap, and single use towels and must be foot or knee operated.
 - f. A utility or service sink must be installed in facilities not equipped with adequate floor drains.

Sewage Disposal

1. Use of a septic system requires a letter of approval from the Department of Environmental Quality (DEQ) or local authority that the system will handle the intended use.
2. There needs to be efficient drainage and plumbing systems that are appropriately sized, installed and maintained for the prompt removal of liquid and suspended solid wastes from the processing environment.
3. Drainage lines should be located so that if leakage occurs, it will not affect product or equipment.
4. If connected to a city sanitary sewer system, a letter from the city stating disposal of this kind of waste is approved.
5. The facility must meet the requirements of the Wyoming Food Safety Rule Chapter 8 and 9 CFR 416.1 – 416.6.

- a. Soil lines from the toilet bowls or urinals may not be connected with other drainage lines in the plant and may not discharge into a grease trap.
 - b. All parts of floors where wet operations are conducted should be well drained.
 - c. One drainage inlet should be provided for each 400 square feet of floor area and the required slope is ¼ inch per foot.
 - d. Floor drains must be installed in carcass or drip coolers for easy clean up.
6. Sewage, one of the most dangerous sources of human pathogens, should never be allowed to come into contact with products, equipment, utensils or any food contact surfaces.
 7. When installing an establishment sewage treatment facility, consider the following guidelines:
 - a. The system should be large enough to handle the amount of sewage that the establishment produces and accommodate future increases.
 - b. If a private septic tank, pretreatment, or treatment system is used it should be designed and operated to prevent contamination of products.

Lighting

1. Adequate, well-distributed artificial lighting is required in all places where natural lighting is insufficient (9 CFR 307.2m2).
 - a. The overall intensity of artificial illumination should be no less than 30 foot-candles.
 - b. In all areas where inspections are made, the intensity shall be no less than 50 foot-candles.
2. Light fixtures in all food preparation, storage, and utensil washing areas shall be shielded or utilize shatterproof type bulbs (Wyoming Food Safety Rule Chapter 9 section 16 & 17 and 9 CFR 307.2m2).
3. Lighting is critical to maintaining a sanitary environment for slaughter and processing operations. Without adequate lighting, unsanitary conditions are often difficult to see and correct.
4. When selecting and installing lighting systems, consider the following requirements:
 - a. Light fixtures in rooms where exposed poultry is handled must be shielded or utilize shatterproof bulbs to preclude contamination of products with broken glass. Light fixtures should be designed to prevent the collection of dirt, product, and debris on lamp surfaces.
 - b. Lighting must be intense enough to allow both the establishment and inspection personnel to see unsanitary conditions and product contamination.

Poultry Storage

1. The facility must meet the requirements found in the Wyoming Food Safety Rule Chapter 3.
 - a. Adequate refrigeration facilities are required for all poultry/food products. A temperature of 41°F is required for product storage.
 - b. Plastic strip doors are NOT approved in exposed product areas.
 - c. All products must be stored to prevent cross contamination.
 - d. A calibrated thermometer must be placed in each cold storage unit.

Non-Poultry Storage

1. Packaging materials and ingredients should be stored in a sanitary environment to eliminate or reduce conditions that may lead to contamination of product.
2. Adequate storage facilities are required for all non-meat storage items including spices, paper products, utensils, etc.
3. All items must be properly labeled and protected from contamination and should not be stored on the floor.
4. Dry storage materials should be stored in a room dedicated to dry storage only.
 - a. Packaging materials must be stored on racks or pallets and shall not be stored on the floor.

Inedibles

1. The facility must meet the requirements of 9 CFR 381.95.
 - a. All condemned materials must be denatured.
 - b. A separate and distinct area with sufficient ventilation shall be provided to house all inedible products before disposal or before being picked up for rendering.
 - c. The area must be completely closed off to all edible product areas.
 - d. Inedible barrels must be properly labeled, leak proof, and maintained in a sanitary manner. They must not be used for any other purpose.

Denaturant

1. Condemned carcasses, parts or other products must be destroyed in the presence of an inspector.
2. Approved disposal methods are incineration, if approved by local or state laws, or a commercial denaturant as described in 9 CFR 381.95 (c).

Chemicals

1. The facility must meet the requirements of the Wyoming Food Safety Rule, Chapter 7, section 17, and Chapter 9, section 27.
 - a. All chemicals must be approved.

- b. Toxic items such as insecticides, rodenticides, caustics, cleaning items, and medicines shall be stored separately from any food or food contact utensils.
- c. An approved chemical list shall remain on file to be reviewed annually.
- d. If 180°F water is not available in the processing portion of the plant, approved chemical sanitizer must be used on all equipment and utensils.

Rodent and Insect Control

- 1. The facility must meet the requirements of the Wyoming Food Safety Rule Chapter 8 and 9 CFR 416.2a.
 - a. Effective means should be provided to exclude rodents and insects.
 - b. Only approved rodent and insects controls shall be utilized.
 - c. A diagram of the facility with locations of traps or glue boards shall remain on file.
 - d. Surveys shall be conducted on a routine basis.
- 2. To prevent drainage lines from becoming entrances into the plant for pests, including rats and mice, all lines must be equipped with effective rodent screens.
- 3. If windows and doors are kept open for ventilation they must be screened to protect against the entry of insects and rodents by:
 - d. Sixteen (16) mesh to one (1) inch (16 mesh to 25.4 mm) screen.
 - e. Properly designed and installed air curtains to control flying insects.
 - f. Or other effective means.

Outside Premises

- 1. The facility must meet the requirements of the Wyoming Food Safety Rule Chapter 8 section 63-86 and 9 CFR 416.2a.
 - a. The outside premises shall be maintained free of litter and unnecessary material.
 - b. All rodent harborage including weeds and bushes shall be removed and maintained throughout the year.
 - c. The garbage area shall be properly located and maintained in a sanitary manner.

Transportation Vehicles

- 1. Delivery vehicles must be clean and maintained in a sanitary manner.
- 2. All transportation or delivery vehicles must meet temperature guidelines for the product being transported.
- 3. Product must maintain internal temperatures $\geq 41^{\circ}$ F or kept frozen.

Employee Health

- 1. The facility shall follow the personal hygiene required according to 9 CFR 416.5 and the Wyoming Food Safety Rule.

2. Occupational Safety and Health Administration requirements can be obtained from the Occupational Safety and Health Administration office at: (307) 777-7786.

Wyoming Food Safety Rule

1. In addition to federal meat plant requirements, equipment and food safety need to meet the requirements of the Wyoming Food Safety Rule.
2. A copy of the Wyoming Food Safety Rule can be obtained from:
Consumer Health Services
2219 Carey Ave.
Cheyenne, WY 82002
(307) 777-7211
3. It can also be viewed online at <http://wyagric.state.wy.us/chs/contact.htm>
4. A copy of the Code of Federal Regulations, Title 9 Parts 200-end can be purchased from:
Superintendent of Documents
US Government Printing Office
Washington D.C. 20402
5. It can also be viewed online at http://www.fsis.usda.gov/regulations_&_policies/index.asp

Slaughter Establishments

Slaughter Area

1. Poultry must be slaughtered in accordance with good commercial practices in a manner that will result in thorough bleeding of the carcasses and ensure that breathing has stopped prior to scalding [9 CFR 381.65 (a)].
2. The slaughter area is one of the most difficult areas to keep sanitary because of the nature of slaughter operations.
3. According to 9 CFR 381.65 (b), blood from the killing operation must be confined to a relatively small area.
4. Slaughter area shall be a separate area from processing areas.
5. The following guidelines should be considered when designing and constructing slaughter areas to minimize contamination of carcasses:
 - a. The slaughter area should be separated from the outside by a full height partition or wall made of impervious material.
 - b. Any doors to the outside of the slaughter area should be self-closing to minimize the risk of contamination, including contamination by vermin.
 - c. Slaughter areas should have floor space arranged to facilitate the sanitary conduct of operations.

Live Bird Holding Pens

1. In addition to preventing contamination of the slaughter area, proper design and construction of holding pens shall prevent injury to the birds. The facility must meet the requirements of 9 CFR 313.1 a, b

2. Consider the following facility guidelines when designing and constructing holding pens:
 - a. Holding pens should be located outside the slaughter room to prevent contamination of products from dust, odors and other contaminants.
 - b. If possible, the holding pens should be separated from the slaughter room by full height partitions to prevent birds from escaping.
 - c. Gates and fences should have smooth surfaces that are easily cleaned.
 - d. Pens shall be free of sharp or protruding objects, which could cause injury or pain to the birds.
 - e. Hose connections should be provided for cleanups.
 - f. Floors of the pens, ramps and runways should be sloped for drainage and cleaning.
 - g. The birds in the pens shall have access to water at all times and if they are kept longer than 24 hours, they shall have access to feed (9 CFR 313.2).

Custom Meat Exemptions

Approval

1. All establishments that are custom processing shall follow and abide by Wyoming Food Safety Rule.
2. They shall follow the Rule on
 - a. Construction
 - b. Sanitation
 - c. Humane Treatment of Animals
 - d. Food Handling
 - e. Personal Hygiene

Custom-exempt Slaughter and Processing

1. Slaughtering and processing services are provided for the birds' owner and the poultry is for the owner's personal use only.
2. All sales transactions must be on a live-bird basis and must take place between the buyer and the seller prior to slaughter. The custom poultry plant operator and the bird's owner cannot be involved in the sale of retail cuts, primals, or carcasses from birds slaughtered under custom exemption.
3. Custom poultry product must bear the plant's name and address, along with the statement, "Exempt P.L. 90-492," as well as, "**Not for Sale.**"
4. Slaughtering must take place in a licensed meat plant or on the animal owner's premises.
5. State-inspected and exempt slaughter plants may operate under custom exemption as well.