(ii) The chart below specifies the initial values of width of windows (n) and Acceptable Limit (AL) for each product class.

	Moving sum rules		
Commodity	Target (per- cent posi- tive for <i>Sal-</i> <i>monel-</i> <i>la</i>)	Win- dow size (n) in days	Ac- cepta- ble limit (AL)
Steers/Heifers Raw Ground	1	82	1
Beef	4	38	2
Cows/Bulls	1	82	1
Hogs Fresh Pork Sau-	18	17	4
sages	12	19	3

(e) Corrective action. (1) Establishments failing to meet Acceptable Limits will be presumed to have process control deficiencies. In such instances, a complete review by the establishment of the production process is required. A written report of the evaluation, including the reason for process failure and proposed corrective actions, will be submitted to the Inspector in Charge within 14 days from the day the process exceeded the limits. This report shall be updated on a weekly basis until the moving sum procedure indicates the process is in control.

(2) During the time the results fail to meet the Acceptable Limits, sampling should be conducted at a rate of two specimens or more per day. The sampling rate will return to normal when the establishment meets Acceptable Limits indicating the process is in control.

PART 318—ENTRY INTO OFFICIAL ESTABLISHMENTS; REINSPECTION AND PREPARATION OF PRODUCTS

5. The authority citation for part 318 would continue to read as follows:

Authority: 7 U.S.C. 138f; 7 U.S.C. 450, 1901-1906; 21 U.S.C. 601-695; 7 CFR 2.17, 2.55.

* 6. Part 318 would be amended by adding a new §318.25 to read as follows:

§318.25 Temperatures and chilling requirements for carcasses and raw meat products.

(a) Definitions:

*

Processing authority. A person or organization having expert knowledge of food processing procedures, having access to facilities for evaluating the safety of such procedures, and

designated by the establishment to perform certain functions as indicated in this section.

Raw meat product. Any meat, meat food product, or meat byproduct that has not received treatment, such as cooking, to make it ready to eat.

Ready-to-eat-process. Any process, such as cooking, applied to a raw meat product that effectively inactivates infective pathogenic hazards that may be in or on the product.

Ready-to-eat product. Any food that is safe for human consumption without additional treatment.

(b) *Time and temperature* requirements. (1) All carcasses and raw meat products from such carcasses shall be cooled to surface temperatures of 50°F (10°C) or below within 5 hours and 40°F (4.4°C) or below within 24 hours from the time the carcasses exit the slaughter floor, unless such product immediately enters a ready-to-eat process or is part of a hot-boning operation, as prescribed in paragraph (b)(2) of this section. Raw product removed from the carcass on the slaughter floor not entering a ready-toeat process or hot-boning operation, e.g., livers, hearts, and heads with cheek meat, shall be placed in a chiller within 1 hour of removal from the carcass.

(2) Establishments that separate raw meat from the bone before cooling the carcasses (hot-boning) shall cool such raw meat until it reaches an internal temperature of 50°F (10°C) or below within 5 hours of initial separation, and 40°F within 24 hours, except that raw meat from a hot-boning operation may enter a ready-to-eat process at the establishment within 5 hours of initial separation.

(3) Carcasses or raw meat products received at official establishments shall register an internal temperature of 40°F or below.

(4) Establishments shall maintain carcasses or raw meat products in their possession or under their control at a temperature of 40°F or below. Product may not be released into commerce unless chilled to this temperature.

(5) Establishments may use a processing authority to develop time and temperature limits microbiologically equivalent to those provided in paragraphs 318.25 (b)(1) through (b)(4). Any such time and temperature alternatives must be included in the establishment's written plan, as provided in §318.25(c) of this section.

(c) Temperature monitoring and written plans. (1) Establishments shall monitor the temperature of raw meat at the control points as set forth in the establishment's written plan required by

paragraph (c)(3) of this section. Establishments shall make the temperature monitoring records available to the Program employees and shall retain records up to 6 months after the temperature measurement or until such time as may otherwise be specified by the Administrator.

(2) To demonstrate compliance with the time and temperature requirements set forth in this section, establishments shall use temperature measuring devices readable and accurate to 2°F (0.9°C).

(3) Establishments shall develop, implement, and place on file a written plan for complying with the time and temperature requirements set forth in this section. Establishments shall make their plans and records, created under the plans, available to Program employees upon request. Each plan shall identify the establishment's control points, i.e., points designated in the production process after the chilling procedure where temperatures are measured; monitoring procedures, including frequency within a day's operation; records; standards for the control points, including cooling rate and holding temperature; corrective actions, including a system for separating and identifying noncomplying products; and, when applicable, the name of the processing authority.

PART 320-RECORDS, **REGISTRATION, AND REPORTS**

7. The authority citation for part 320 would continue to read as follows:

Authority: 21 U.S.C. 601-695; 7 CFR 2.17, 2.55.

8. Section 320.1 would be amended by adding new paragraphs (b) (11), (12), (13) and (14) to read as follows:

§ 320.1 Records required to be kept. *

* * (b) * * *

(11) Standard operating procedures (SOP's) for sanitation, and daily records, as prescribed in § 308.3 of this subchapter.

(12) Temperature control plans and records, as required by § 318.25 of this subchapter.

(13) A written protocol for sampling raw product for pathogen testing, as required by § 318.25 of this subchapter.

(14) HACCP plans and records, as required by part 326 of this subchapter.

9. Section 320.3 would be amended by adding new paragraphs (c), (d) and (e) to read as follows:

§ 320.3 Record retention period.

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