Preoperational procedures prescribed in the Sanitation SOP's must be completed

before the start of operations.

(3) The establishment shall develop and maintain a daily record of completion of all sanitation Standard Operating Procedures. Daily records, including any deviations from regulatory requirements and corrective actions taken, shall be maintained by the establishment for a minimum of 6 months.

(b) [Reserved]

Subpart I—Operating Procedures

19. Section 381.66 would be amended by revising paragraph (b) to read as follows:

§ 381.66 Temperatures and chilling and freezing procedures.

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(b) General chilling requirements—(1) 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 poultry product. Any poultry or poultry 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 poultry 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.

(2) Time and temperature

requirements.

- (i) All poultry and poultry products that are slaughtered and eviscerated in the official establishment shall be chilled immediately after processing to reach surface temperatures of 50 °F (10°C) or below within 1.5 hours and 40°F (4.4°C) or below within 24 hours from the time that the carcasses exit the slaughter line, unless such product immediately enters a ready-to-eat process or a hot-boning operation, as prescribed in paragraph (b)(2)(ii) of this section. Raw product removed from the carcass on the slaughter line, such as giblets, shall be placed in a chiller within 1 hour of removal from the carcass.
- (ii) Establishments that separate raw poultry from the bone before cooling the carcasses (hot-boning) shall cool such raw poultry until it reaches an internal temperature of 50°F (10°C) or below within 1.5 hours of initial separation,

except that raw poultry from a hotboning operation may enter a ready-toeat process at the establishment within 1.5 hours of initial separation.

- (iii) Carcasses or raw poultry products received at official establishments shall register an internal temperature of $40^{\circ}F$ or below.
- (iv) Establishments shall maintain raw poultry carcasses and 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.
- (v) Establishments may use a processing authority to develop time and temperature limits microbiologically equivalent to those provided in paragraphs 381.66(b)(2)(i) through (b)(2)(iv). Any such time and temperature alternatives must be included in the establishment's written plan, as provided in § 381.66(b)(3) of this section.
- (3) Temperature monitoring and written plans. (i) Establishments shall monitor the temperature of raw poultry at the control points as set forth in the establishment's written plan required by paragraph (b)(3)(iii) of this section. Establishments shall make the temperature monitoring records available to 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.
- (ii) 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).
- (iii) 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.

20. Subpart I would be amended by adding a new § 381.69 to read as follows:

§ 381.69 Treating carcasses to reduce bacteria.

- (a) General. Raw poultry carcasses shall be treated at least once at any point during the slaughter and dressing operation, but prior to entering the chiller to reduce levels of bacteria on carcass surfaces.
- (b) Treatment methods. Official establishments may use any of the following treatment methods to reduce bacteria, provided that equipment has been approved under § 381.53, and that operation of the method results in full compliance with the Act and this part.
- (1) Any chlorine compound approved by the Administrator and administered to raw, unchilled whole poultry carcasses or major carcass portions at 20 to 50 parts per million (ppm) in the intake water at the final wash. The chlorinated water must contact all carcass surfaces. The Administrator will prepare a list containing compounds approved for use in official establishments. A copy of the list may be obtained from the Compounds and Packaging Branch, Product Assessment Division, Regulatory Programs, Food Safety and Inspection Service, U.S. Department of Agriculture, Washington, DC 20250-3700.
- (2) Hot water applied such that the temperature of the water at the carcass surface is $\geq 165^{\circ}F$ ($\geq 74^{\circ}C$) for ≥ 10 seconds. The hot water must contact all carcass surfaces.
- (3) Any antimicrobial compound listed in the table in § 381.147(f)(4) and permitted for use on poultry products may be used under the conditions specified therein. The antimicrobial compound must be administered so that it contacts all carcass surfaces.
- (4) Any antimicrobial compound approved for use in poultry or poultry products as a food additive or processing aid by the Food and Drug Administration and listed in title 21 of the Code of Federal Regulations, parts 73, 74, 81, 172, 173, 182, or 184 may be used, provided the owner or operator has received approval for such use from the Administrator in accordance with § 381.147(f)(2) of this part. Any such antimicrobial compound must be administered so that it contacts all carcass surfaces.
- (5) If the application or use of an antimicrobial treatment is determined by the Inspector in Charge to not conform to approved parameters, the establishment shall make necessary adjustments within 15 minutes. If adjustments are not made within 15 minutes, the establishment shall suspend the treatment and shall not process carcasses until appropriate adjustments are made. If a second