

TABLE 1.—GENERIC HACCP PLAN CRITICAL CONTROL POINTS FOR BEEF SLAUGHTER AND FABRICATION

Process/step	CCP	Critical limits	Monitoring procedure/frequency	Corrective action	Records	Verification
Skinning	CCP(1) ...	≤20% of carcasses with dressing defects.	Operator observes effectiveness of skinning process for each carcass. Visual analysis should be conducted under adequate lighting per USDA requirements.	Add operators ... Reduce chain speed. Conduct carcass trimming.	Random post-skinning carcass examination log.	Examination of random carcasses after skinning is complete using sampling plan sufficient to assure process control. Supervisory review of records. Initially, conduct microbiological analyses for aerobic mesophiles and/or <i>Enterobacteriaceae</i> to establish baseline data on expected bacterial numbers. Periodic follow-up analyses and trend analysis to verify process control. Review control charts to confirm that sampling frequency is sufficient to detect 20% defect criteria.
Post-skinning Spray Wash and Bactericidal Spray.	CCP(2) ...	Washing: 1. 90–100°F. 2. 345–2070 kPa (50–300 psi). Bactericidal Spray: 1. Organic acid: 1–2%. 115–130°F. 2. Chlorine: 50 ppm. Ambient temperature. 3. 70–275 kPa (10–40 psi) 4. Other applications per USDA–FSIS guidelines.	Continuous monitoring of temperature, pressure and bactericidal rinse concentration..	Washing: adjust temperature or pressure. Bactericidal spray: adjust temperature, pressure or concentration Examine and repair equipment as needed.	Post-skinning wash spray and bactericidal spray log. Log of preventative maintenance.	Supervisory review of records. Periodic microbiological analyses for aerobic mesophiles and/or <i>Enterobacteriaceae</i> coupled with trend analysis to confirm adequacy of process in comparison to data collected at CCP(1). Periodic testing of equipment to ensure it is operating according to design specifications.
Evisceration	CCP(3) ...	0% occurrence of the following defects for a single carcass: Fecal material, ingesta, urine or abscesses.	Employee observes contamination and routes contaminated carcass for immediate trimming.	1. Trained employee immediately trims defect area on carcass. 2. Add operators. 3. Reduce chain speed. 4.4. Sanitize soiled evisceration tools with 180°F water. 5. Sanitize soiled clothing 120°F water or appropriate sanitizer.	Random post-evisceration carcass examination log.	Supervisory review of records and operations. Random examination of carcasses after evisceration using a sampling plan sufficient to assure process control.