

GEORGIA DEPARTMENT OF CORRECTIONS		
Standard Operating Procedures		
Functional Area: CORRECTIONS DIVISION/ FACILITIES OPERATIONS	Reference Number: IVM01-0006	Revises Previous Effective Date:
Subject: Abattoir Operation		12/15/02
Authority: DONALD/ADAMS	Effective Date: 9/01/04	Page 1 of 17

I. POLICY:

- A. The slaughter facilities shall produce quality products that will meet the official guidelines of the United States Department of Agriculture (USDA) Food and Drug Administration, and the Georgia Department of Agriculture Meat Inspection Division's rules, regulations, and directives as may be required;
- B. Facilities will have uniform methods of operation.
- C. The facilities will provide beef or pork to the meat processing unit at the Food Distribution Unit in Milledgeville for use in institutional Food Service statewide.
- D. Abattoirs will operate in compliance with federal and agricultural requirements with a Georgia Department of Agriculture inspector on site at each abattoir.
- E. Abattoirs will follow technical guidelines established herein for efficient operations as a correctional entity.

II. APPLICABILITY:

Rogers SP.

III. RELATED DIRECTIVES:

OCGA 40-7-1, 40-5-6B

IV. DEFINITIONS:

Abattoir: A facility where animals are slaughtered for ultimate use as food for human consumption.

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V. ATTACHMENTS:

None

VI. PROCEDURE:

A. Abattoir:

1. The Abattoir operates under the general direction of the State Farm Administrator. Production goals are set cooperatively by the State Farm Administrator, Food Distribution Unit Administrator and the Food and Farm Services Manager in the context of the Food Service Master Menu needs. The Food and Farm Services Information Resources Manager will provide technical guidance as needed.
2. Abattoir facilities are operated under inspection and certification of the Georgia Department of Agriculture and the United States Department of Agriculture.
3. All sanitation methods, pesticides and rodent control is the procedure recommended by and approved through inspection by the Georgia Department of Agriculture and the United States Department of Agriculture.
4. All detailed procedures used in the Georgia Department of Corrections abattoir facilities are those recommended by and required under inspection of the United States Department of Agriculture and the Georgia Department of Agriculture. Technical procedures described herein are not to be considered all-inclusive, but are those that have been approved and agreed upon by Food and Farm Services to establish uniformity and consistency in facilities.
5. Supervision and control of inmates is determined by security classification and is conducted in adherence to departmental and institutional rules and regulations.
6. All abattoir staff in non-security positions shall be acutely aware of the need for inmate security at all times and shall support correctional officers in

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security-related functions if it is necessary for the maintenance of security. Said staff shall also observe all facility rules concerning security in all contexts, and shall seek clarification from supervisors or correctional officers when in doubt concerning some security aspect of their operation.

7. All staff shall hold the care and health of animals handled in the operation to be of utmost importance. Animal abuse or mistreatment by inmates or staff shall be vigorously prohibited and dealt with in an appropriate manner if it occurs. Offenders shall not be allowed to work in a Georgia Department of Corrections abattoir if they have any known history of animal abuse.
8. The entire slaughter process shall at all times meet at least the minimum of established slaughter house methods pertaining to humane slaughter. The supervisor of the slaughter process shall have the responsibility to insure humane procedures are followed.

B. Receiving Livestock for Slaughter

1. Cattle are brought to the abattoir by cattle truck, unloaded, and placed in holding pens by lot number, which is assigned at this time. Once received at the abattoir, if not slaughtered as planned, cattle are not to be placed back in the herd.
2. Swine are received by truck from the Swine Unit immediately prior to slaughter, and are not usually held for any period of time. If not slaughtered as planned after being received, animals are not to be placed back in Swine Unit.
3. Animals are weighed by truckload immediately prior to delivery at the abattoir, with the following information being recorded on Scale Ticket, which is consecutively pre-numbered:
 - a. Load: Number and description of animals (i.e. 12 Stocker Cattle)

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- b. From: Name of Institution and unit (i.e. Rogers SP Swine Unit; or if purchased, name and/or location of market)
 - c. Gross: Total weight of truck and animals (automatically recorded by scale)
 - d. Tare: Weight of truck when animals have been unloaded (automatically recorded by scale)
 - e. Net: Calculated total weight of animal, obtained by subtracting tare weight from gross weight.
 - f. Employee responsible for weighing signs the scale ticket.
 - g. Scale ticket consists of original and one copy. Original is attached to Slaughter Report, and copy is retained in file.
4. Each Slaughter Plant will complete a Meat Processing Production report for each shipment in accordance with GDC Meat Processing inventory control book.

C. Slaughter Process

1. Beef Cattle

- a. Cattle to be slaughtered should have a live weight in excess of 900 pounds. Exceptions should only be made for cattle, which have reached their maximum weight and have not attained this poundage.
- b. Meat Plant personnel will be responsible for handling the captive bolt stunning device. Use of inmate labor is strictly prohibited in this process.
- c. Sticking (Exsanguination): After the animal is hoisted, make an incision through the hide only, between the point of the brisket and the jaw. Insert the knife in front of the brisket at a 45° angle, and sever the carotid arteries and jugular vein.

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- d. Rodding the Weasand: This separation of the esophagus from the trachea must be made to allow the abdominal cavity organs and contents and the esophagus to be pulled out of the body cavity separately from the thoracic cavity organs without breakage during evisceration. This step can take place on the skinning cradle after the brisket has been split. A knot is made in the esophagus, or a string or rubber band is put around it to prevent spillage of rumen contents.
- e. Heading: Open the hide from one horn to one nostril. Continue the opening from the stick down through the center of the jaw and skin out one side of the face. Skin out the front of the face. Turn the head and skin to the opposite side. Grasp the jaw in one hand, bend the head back on its poll, and remove the head by cutting through the Adam's apple and the atlas joint.
- f. Shanking or Legging: Place the skinning rack under the withers, and lower the animal onto the rack. The feet must be removed prior to opening up the hide to prevent contamination of the carcass with manure and dirt dropped from the hooves. Open the hide on the rear of the foreshank and the rear of the hindshank, continuing the cut to the midline to be made on the belly from the neck to the bung. On the foreshank sever the tendon to release tension by cutting across the shank. Skin out the shanks in order to see the joint clearly, and remove them from the flat, smooth joint below the knee and hock. This joint is at the enlargement, about 1-inch below the knee joint, just where it tapers down to the cannon h-bone. You have found the correct joint if you expose the flat bones in each joint face. If you expose three rounded bones in each joint, you are too high into the knee joint itself. On the hock, it is about 1 inch from where the taper takes place. A decided groove is evident when the knife rests at the proper spot. It is

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especially important to remove the hindshank at the proper location below the hock joint itself in order to preserve the tendon anchors for carcass hanging. (Cut around to either side, then grasp the shank near the foot, and give a sharp thrust downward and outward from the stifle joint.)

- g. Siding: Open the hide down the middle from the stick opening to the bung. Open the hide in an M configuration over the brisket by cutting the hide diagonally from the point of the brisket to the inside base of the foreshank on each side. (Siding can be started at the fore end or rear end. To side, grasp the hide firmly with an upward pull, and with long, smooth strokes of the skinning knife, remove the hide down over the sides. The bevel of the knife must be flat to the hide to avoid making cuts or scores.)
- h. Opening: After the hide has been sided down to the rail on the skinning rack on each side, the brisket is opened. Cut through the fat and muscle of the brisket at its center with a knife, and then saw through the sternum.
- 1) Once the chest cavity is opened, rod the weasand; that is, separate the esophagus from the trachea.
 - 2) A beef tree (a large, spreading gambrel) or beef trolleys, designed to operate in conjunction with a power lift and spreader, may be inserted in the hocks so that the carcass can be raised to a convenient height for splitting the aitch bone, bunging, tailing, and removing the hide from the round and rump. In the case of a male, the pizzle (penis) must be removed first. Cut it loose from the belly wall and back to its origin at the pelvic junction. Do not cut it off while pressure is on the urinary bladder, or the carcass will become contaminated with

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urine. With the pizzle out of the way, proceed first with your knife to separate the rounds. Each top round muscle is covered with a tough membrane, and where the two join over the high point of the pelvis, they form a decidedly heavy, white appearing membrane. Follow the membrane with your knife, and avoid cutting into the muscle. When you reach the pelvis, use the saw and carefully saw through the center of the aitchbone.

- 3) In bunging a male, pull the pizzle taut posteriorly, and loosen the anus by cutting completely around it. Be careful while severing all supporting connections that the intestine itself is not punctured. When bunging a female, you must grasp the anum itself, in lieu of the penis to hold it steady for bunging. Once loosened, the bung is tied with a cord and pushed through into the abdominal cavity, where it can be reached from the belly side.
- 4) To remove the tail, skin around its base and sever the tail two joints from the body. By placing a paper towel over the skinned base stub, the tail can be easily pulled out the remainder of the way.
- 5) Before eviscerating, you should completely remove the hide from the carcass. Removal of the hide from the back is called backing. This operation consists of running the knife around the back between the hide and the carcass and letting the hide drop of its own weight. The hide may also be removed by cutting in from either side as a completion of the siding operation.
 - i. Evisceration: Insert the handle of the knife in the abdominal cavity with the blade leaning upward and your fist protecting the intestines

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and rumen. Open the belly cavity, using one continuous motion.

- 1) Loosen the fat and membrane that hold the bung gut and bladder to backbone, and cut the ureters that connect the kidneys and the bladder. The kidneys and kidney fat remain in a beef carcass. The reason is largely custom, although the kidney fat does protect the valuable tenderloin muscle from drying out and darkening during aging. Loosen the liver with the hands, and then sever it from the backbone with a knife. Place on an inspection tray for observation by inspector. Following inspection, remove the gall bladder by cutting across the top of the bile duct at the center of the liver and peeling it, rather than cutting it out.
 - 2) Pull the previously loosened esophagus up through the diaphragm to allow the abdominal viscera to fall freely into the inspection cart.
 - 3) The membrane separating the abdominal from the thoracic cavity is called the diaphragm and consists of the diaphragm muscle and the membrane joining the muscle. Cut out only the membrane, as the diaphragm muscle is good, edible meat and is commonly known as the skirt or hanging tenderloin. The organs that lie in the thoracic cavity are called the pluck and consist of the heart, lungs, and windpipe.
- j. Halving (Splitting): Splitting the beef into sides by sawing through the exact center of the backbone may be accomplished by using a hand or electric beef splitting saw. (Using a hand saw, stand on the belly side of the carcass, and saw through the caudal vertebrae to the sacrum and through the sacrum and the lumbar vertebrae. Special care should be taken to split each superior spinous process of each

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vertebra. Since the feather bones in the dorsal region (rib area) of the backbone are quite long and narrow, it is desirable to first saw through the main body of the backbone. This is done by pointing the saw toward the tail and sawing at an angle to the backbone. Sawing through each individual dorsal vertebra at a 45° angle assures the operator of a 50-50 split of the feather bones, since the spine (if the saw is in the center) steers the saw blade and holds it steady. After the splitting of the forequarters is completed, the vein is removed from the inside of the neck.)

- k. Washing: All blood should be washed off both the inside and the outside of the carcass and the shoulders should be pumped, by working the shanks up and down. Cold or lukewarm water is used to wash the carcass.
- l. Pathogen Reduction: After washing, the carcass will be rinsed with a sanitizing agent as outlined in the plant HACCP Plan.
- m. Care of the Beef Carcass: A thorough chilling during the first 24 hours is essential, otherwise, the carcass may sour. This occurs first at the hip joint - a deep-seated joint from which the heat is slow to escape. A desirable temperature for chilling warm carcasses is 33°F.
- n. After carcasses are chilled to desirable temperature, they are quartered and then blocked into uniform cuts to be boned for further processing. These cuts of beef are then shipped to FDU via "combos" for further fabrication, (ie. ground beef, beef stew, hamburger patties, etc.).
- o. Beef by-products must be boxed, labeled item name, lot number, weight, and date, if shipped with carcass. Tongue, hearts, and head meat may be included in ground beef, but must be labeled accordingly.

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2. Swine:

- a. Swine to be slaughtered should ideally have a live weight of approximately 240 pounds.
- b. Once antemortem inspection has been completed, the swine are driven to the stunning area. One of the approved humane methods of stunning is utilized to render the animal unconscious. One animal will be stunned at the time. Meat Plant Personnel will be responsible for handling the captive bolt stunning device. Use of inmate labor is strictly prohibited in this process. The restraining device or stunning chute and table must be thoroughly cleaned before the start of each day's operation.
- c. The next step in the swine slaughter sequence is bleeding. Sticking must be done properly to insure complete bleedout and to prevent shoulder wounds, which can become heavily contaminated during scalding, dehairing, and polishing. Since all stick wounds must be trimmed as contaminated tissue, the larger the stick wound, the more trimming that will be necessary.
 - 1) A sanitizing agent must be present, because the sticker is required to sanitize the sticking knife.
 - 2) Hog carcasses are shackled and are stuck while hanging from the shackle.
 - 3) Death is to occur by thorough bleeding of the animal. While there is no time requirement, animals usually remain on the bleeding rail no less than 5 minutes to assure complete bleeding and death. It is desirable to have them on the rail no longer than 30 minutes to avoid the possible onset of decomposition and rigidity of the carcass, which may result in its mutilation when it goes through the dehairer and polisher.

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- d. After the stunning, sticking, and bleeding operations have been completed, the next procedure in the sequence is scalding. The purpose of scalding is to loosen hair from the carcass and thereby facilitate further sanitary dressing procedures such as dehairing and dirt removal.

There are several factors that influence satisfactory scalding, dehairing, and cleaning. Some of these factors are as follows:

- 1) Water circulation and the temperature of the scald vat water.
 - 2) The number of carcasses and the time that carcasses remain in the scalding vat.
 - 3) The condition and operation of the dehairing machine.
- e. Several things should be kept in mind about successful scald vat operations. A carcass should not enter the scalding vat prior to death. A hog that is scalded alive dies from asphyxia and will frequently have a scarlet red appearance and have organs that are engorged with blood. The inspector should designate such hogs as U.S. retained for the veterinary inspection.
- f. The points to keep in mind concerning sanitation of the scalding vat are as follows:
- 1) It must be drained and cleaned daily.
 - 2) Fresh, clean, potable water must be used at the start of each day's operation.
 - 3) If chemical additives are used in the scald water, they must be officially approved for that purpose.

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- g. The temperature of the scald water should be adequate (generally 140°F to 145°F) to insure clean carcasses by loosening hair sufficiently. Hogs are placed in the scald vat for approximately two minutes. If the hog stays too long in the vat or at too high a temperature, overscald may result. This is the cooking of the carcass with breaking of the skin and resulting scald water contamination.
- h. If the water is too cold or if the carcass is left for too short a period of time in the vat, the hair and scurf (which is a combination of skin, dirt, and other filth) will not loosen, thus resulting in improper dehairing and the scurf being left on the carcass.
- i. After the scalding operation, the dehairing machine is next in sequence. The dehairing machine must be maintained in good working condition in order to efficiently remove hair and to prevent mutilation by broken parts cutting into the carcass. The water temperature and the number of carcasses going through the machine must be regulated since these factors will greatly influence the dehairing effectiveness.
- j. The next abattoir procedure in the preparation of swine is gambrelling - the hoisting of hogs to the vertical position by tendons of the hind legs. After dehairing, the carcass is placed onto the gambrelling table and aligned. The hind feet are to be cleaned of hair and scurf before the tendon is opened. The gambrel stick must be cleaned prior to usage on a carcass. After the stick is inserted under the tendons, the stick is then hooked onto a trolley and hook that is used to convey the carcass along the dressing chain.
- k. Singeing is the next sanitary dressing procedure. The singer is used for burning the fine hair present on hogs. Singeing is an important dressing procedure in the preparation

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of the carcass for the dropping of the head. The carcass must be properly cleaned before the head is dropped or before any other opening cuts is made in the carcass. Hand scraping or shaving is done after singeing. (The purpose of hand shaving is to remove all the hair before the final wash.) In a scalding vat/dehairing machine operation, "final wash" refers to washing of the carcass prior to head dropping or any incision made in the carcass.

1. The establishment must properly clean hog carcasses before any opening is made for evisceration or for dropping of the head. Once an opening cut is made in the carcass, hair, scurf, etc. shall be removed by trimming. The last procedure prior to head dropping is carcass washing (final wash), the purpose of which is to remove loose dirt, hair, and scurf. The water spray used should be a strong fine spray to accomplish the final wash.

- m. Finally, the head dropping procedure takes place so that head inspection may be done. There are several points to keep in mind about head dropping in a manner that leaves the mandibular lymph nodes attached to the head and available for inspection. It is improper presentation if the nodes are not left attached to the head for inspection. Also, the header's knife must be sanitized after each head is dropped, due to the frequency of abscesses and tuberculosis in the cervical area of swine.

- n. The next dressing procedure after head inspection is bunging. The area immediately surrounding the bung is cut so as to allow the bung to drop between the hams.

- o. The next procedure involves opening the brisket. While opening the brisket, the plant employee should use special precautions to avoid cutting the viscera. The brisket knife or saw is to be sanitized after use on each animal, since the thoracic cavity is entered

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and there is no way of knowing if abscesses or other abnormal conditions are present to contaminate the knife or saw. Eventually, the carcass will be prepared in such a way that the viscera and carcass can be inspected.

- 1) Contaminants on the midline must be trimmed before opening the abdominal cavity. When opening the midline, establishment employees must exercise care to prevent cutting the urinary bladder, intestines, stomach, or gall bladder. a special knife is usually used to prevent cutting the viscera. The cut is made with the knife point out, using the hand to push back the viscera.
- 2) The penis (pizzle), the uterus, the urinary bladder, and lactating mammary glands are removed.
- 3) After these operations, the actual evisceration occurs. The eviscerator must take precautions not to drop the viscera or drag it across the platform or floors.
- 4) Organs and carcasses contaminated by stomach or intestinal contents, urine, bile, etc. should be thoroughly cleaned before being presented for inspection. Such contamination shall be removed in a manner satisfactory to the inspector. Removal of contamination by washing may be acceptable if there is no splashing or spreading of the contamination. Generally, when the surfaces are smooth and unbroken, like the surface of a liver, washing may be satisfactory. When the surfaces are neither smooth nor unbroken or when the contamination is extensive or when washing only serves to spread the contamination, trimming would be necessary. If the contamination is so excessive that all or part of a set of

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viscera must be condemned, the viscera still must be cleaned sufficiently so that inspection can be performed, because lesions may be observed that could affect the disposition of the head, viscera, or carcass.

- 5) Carcass tissue or organs contaminated with milk, pus, exudate, or pathologic tissue must be trimmed under the inspector's direct supervision. Scraping, washing, or wiping is unacceptable. Washing skinned carcasses before inspection to remove contaminants resulting from improper dressing is not permitted. Such contaminants must be removed by trimming.
- p. Contaminated equipment must be washed with water then sanitized. The moving top viscera table must be cleaned and sanitized continuously. It should be given a hot water sanitizing.
- q. The carcass splitting operation takes place after viscera inspection. The splitting saw must be sanitized after each retained carcass. After the splitting operation, trimming procedures such as removal of abscesses from the ham facings and removal of castration scars, pizzles, and related tissue should take place.
- 1) After the splitting and trimming of the carcass, the neck should be cleaned. Pieces of trachea, blood vessels, and blood clots must be trimmed and washed from the neck.
 - 2) External stick wounds contaminated by debris from the skin, scald water, and clotted blood must be trimmed. Other tissues contaminated by scald water must also be trimmed. Internal stick wounds should be opened for removal of blood clots.

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- 3) Kidney popping or removal of the capsule from the kidney for adequate inspection is another necessary requirement, as is the removal of the thyroid gland.
- 4) All remnants of spermatic cords, abscesses, and bruises that are present in the ham facings must be removed. If tapeworm cysts should be found, the carcass should be retained for veterinary disposition.
- r. Quite often, after the hog is dressed completely and all inspection procedures have been accomplished, leaf fat removal will take place. Leaf fat is the heavy layer of fat lining the walls of the abdominal cavity. Sometimes the smaller pieces of the leaf fat (scrap fat) are removed with a hand scraper.
- s. The carcass is now ready to be washed, branded, and sent to the cooler. Necks may be washed (primarily to remove blood clots) after leaf and scrap fat removal. Skimmings from such washings shall not be used for edible purposes. If the carcass was scalded, bone dust may be washed from the carcass. If the carcass was skinned instead of scalded, the carcass must be washed to assure removal of possible loose hair. The inspector then evaluates the carcass and approves/disapproves the carcass for placement in the cooler. The marks of inspection are applied in the cooler. Each carcass must contain at least one mark of inspection of each half before entering the cooler if the carcass is split completely. If the sides of the carcass are held together by natural (skin) attachments, one mark of inspection would be sufficient. The brand utilized in the number 1 (1 3/4" diameter).
- t. Pathogen Reduction: After washing, the carcass will be rinsed with a sanitizing agent as outlined in the plant HACCP Plan.

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- u. After carcasses are chilled to the desired temperature, they are blocked and packaged in "combos". Combos are shipped to the Food Distribution Unit for further processing. Hams, shoulders, and loins are blocked so that they may be utilized by skinning machines prior to boning and fabrication (ie. ground pork, sausage, etc.).
- v. Usable pork by-products are packed in boxes of appropriate size. A label must be affixed to the box, which will include item name, lot number, weight, and date shipped. By-products shipped with lot of carcasses from same animals do not require labels. If shipped separately, are not to be mixed with head meat.
 - 1) Hearts and tongues may be boxed together or separately, but are not to be mixed with head meat.
 - 2) Tongues, hearts, and head meats may be processed into sausage and identified as such on the approved labels by the Department of Agriculture. These items should not be packaged in loin boxes, due to irregular shape and size which causes storage problems in freezers.
 - 3) No pork livers or feet are to be shipped to Food Distribution Unit unless specifically requested.

D. Record Keeping

- 1. A Slaughter Report is prepared each day to provide a record of all slaughter activities. A separate Slaughter Report is prepared for cattle and for swine. Information contained in Slaughter Report include:
 - a. Slaughter date
 - b. Type animal

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- c. Number of head slaughtered this date
 - d. Live weight, taken from scale tickets of all loads of this type animal received on this date, and added together.
 - e. Hanging weight for each carcass, recorded after slaughter. Cattle hanging weights are recorded by stock number. Swine are listed separately, but do not have an identifying number for each carcass.
 - f. Total slaughtered hanging weight
 - g. Cold weight of meat transferred to Food Distribution Unit meat plant and weight of liver and edible by-products is taken.
 - h. Weight of offals
 - i. Date of delivery of animals to abattoir
 - j. Signature of person delivering animals, certifying delivery of animals and certifying delivery as correct
 - k. A space is provided for use by Business Office in calculating percentage yield. Live weight is divided into hanging weight to determine slaughter yield percentage.
2. Beef Slaughter and Processing Performance Report and Pork Slaughter and Processing Performance Report, when fully completed, are monthly records of activity/production of combined abattoir and meat processing units.
- a. Abattoir is responsible for completing sections A, B, C, D, and E on these forms.
 - b. Reports are submitted to the Farm Services Administrator's Office on a monthly, quarterly and yearly basis.

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- c. Tongue, hearts, and head meat may be included in ground beef, but must be labeled accordingly.
- d. All Slaughter Plants will complete their portion of the Meat Processing report as stated in SOP IVL01-00021.

E. HAACP Implementation

- 1. Each Abattoir will develop, implement and follow a HAACP program.
- 2. HAACP programs should follow Georgia Department of Agriculture and United States Department of Agriculture guidelines.
- 3. The Information Resources Manager will review and certify that each unit's plans are kept up-to-date.

F. Safety

- 1. Weekly safety meetings pertaining to work area specific topics will be mandatory. A copy of the meeting minutes including list of attendees should be maintained on site for a period of two (2) years.
- 2. It will be the responsibility of all farm staff to monitor farm operations on a daily basis to insure the safety of both the staff and inmates assigned to this work area.