



New South Wales

Poultry Processing Regulation 1996

under the
Poultry Processing Act 1969

His Excellency the Governor, with the advice of the Executive Council, has made the following Regulation under the *Poultry Processing Act 1969*.

RICHARD AMERY, M.P.,
Minister for Agriculture

Explanatory note

The object of this Regulation is to repeal and remake, with one major change in substance, the *Poultry Processing Regulation 1982*. The major change is the requirement that the operator of a poultry processing plant have in place, and adhere to, an approved Hazard Analysis—Critical Control Point plan or Quality Assurance Program.

The Regulation deals with the following:

- the registration of poultry processing plants (clauses 5–13 and Schedule 2),
- the processing of poultry (clauses 14 and 15 and Schedule 3),
- matters of a technical nature and miscellaneous matters (clauses 1–4 and 16–21 and Schedule 1).

This Regulation is made under the *Poultry Processing Act 1969*, including section 16 (the general regulation-making power).

This Regulation is made in connection with the staged repeal of subordinate legislation under the *Subordinate Legislation Act 1989*.

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Poultry Processing Regulation 1996

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Clause 1 Poultry Processing Regulation 1996

Part 1 Preliminary

Poultry Processing Regulation 1996

Part 1 Preliminary

1 Name of Regulation

This Regulation is the *Poultry Processing Regulation 1996*.

2 Commencement

This Regulation commences on 1 September 1996.

3 Definitions

(1) In this Regulation:

amenity room includes a washroom, toilet, locker room, changing room, dining room, cafeteria and any similar room.

animal food means food that is not intended for human consumption but is fit for use as pet food (whether fresh or manufactured).

approved means approved in writing for the time being by the Chief, Division of Animal Industries.

by-product area means any part of a plant in which poultry waste is treated.

drinking water means of a quality consistent with standards for drinking water acceptable to the Water Supply Authority for the relevant local government area.

giblets means the heart, the liver and the gizzard of poultry.

immersion tank means a tank used for the purpose of scalding, washing, chilling or thawing poultry meat in water.

poultry waste means the cadavers of condemned poultry, the inedible products derived from poultry and poultry meat that is contaminated or otherwise unfit for human consumption.

preparation area means any part of a plant to which live poultry is delivered or in which poultry is held, killed or defeathered.

processing area means any part of a plant in which poultry meat is eviscerated, cleaned, cut up, boned, packaged, refrigerated or stored, or from which poultry meat is dispatched.

Quality Assurance Program has the meaning given it in clause 14 (3).

the Act means the *Poultry Processing Act 1969*.

- (2) In this Regulation, a reference to poultry killed at a plant is a reference to poultry killed at a plant for the purpose of preparing poultry meat for sale.
- (3) In this Regulation, a reference to a Form is a reference to a Form set out in Schedule 1.
- (4) For the purposes of this Regulation, one part of a plant is isolated from another part of the plant if
 - (a) those parts are contained in separate buildings, or
 - (b) those parts are contained in a single building and:
 - (i) those parts are separated from each other by means of walls rising to the ceiling of either of those parts, and
 - (ii) the only means of access between those parts is by means of self-closing doors or by means of apertures of an approved design through which poultry meat passes in the course of its being processed.
- (5) For the purposes of the Act and this Regulation, the draining of a carcass is taken to be completed at the commencement of the stage of the process immediately following the evisceration and cleaning of the cadaver.

4 Notes

The explanatory note, table of contents and notes in the text of this Regulation do not form part of this Regulation.

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Clause 5 Poultry Processing Regulation 1996

Part 2 Registration of poultry processing plants

Part 2 Registration of poultry processing plants

5 Definition

In this Part, *relevant period* has the same meaning as in section 9A (1) of the Act.

6 Particulars to accompany applications for registration or renewal of registration

For the purposes of section 9 (2) (a) of the Act, the prescribed particulars in relation to an application for registration of a plant, or for renewal of registration of a plant, are:

- (a) the name and address of the operator of the plant, and
- (b) the address of the plant, and
- (c) the number of poultry, if any, killed at the plant during the relevant period.

7 Form of application for registration or renewal of registration

For the purposes of section 9 (2) (b) of the Act:

- (a) the prescribed form of application for registration of a plant is Form 1, and
- (b) the prescribed form of application for renewal of registration of a plant is Form 2.

8 Documents and information to accompany applications for registration

- (1) For the purposes of section 9 (2) (c) of the Act, the following maps, plans, documents and information are prescribed in relation to an application for registration of a plant:
 - (a) any development consent required under the *Environmental Planning and Assessment Act 1979* in relation to the erection or use of the plant,
 - (b) a site plan showing:
 - (i) the location and dimensions of the site,
 - (ii) the fall, if any, of the land comprising the site,

- (iii) the location of any watercourse adjacent to or passing through the site,
- (iv) the names and widths of any roads adjacent to the site,
- (v) the location of all existing and proposed buildings and structures on the site, and
- (vi) the direction of true north,
- (c) a floor plan showing the dimensions of all floor areas and the location of all internal walls, all doors and windows and all appliances to be used in connection with the process,
- (d) a drainage plan showing the proposals for floor drainage and effluent disposal and the location of all hot and cold water outlets, hand-washing facilities, boot-washing facilities and facilities for washing poultry and poultry meat,
- (e) longitudinal and cross-sectional drawings of all existing and proposed buildings, indicating the finish to be provided for walls, floors and partitions, the heights above floor level of all chains and other mechanisms to be used for the carriage of poultry or poultry meat and the location of all appliances to be used in connection with the process,
- (f) elevation drawings of each side of all existing and proposed buildings, showing the sizes and positions of all doorways, windows and other openings,
- (g) written specifications of materials used or to be used in the construction of all buildings and structures and of all appliances to be used in connection with the process,
- (h) particulars of the source of the water supply to the plant and the manner in which the water is to be supplied.

(2) The drainage plan referred to in subclause (1) (d) may be incorporated in the site plan referred to in subclause (1) (b) or the floor plan referred to in subclause (1) (c).

(3) Anything required to be shown on a plan or drawing referred to in subclause (1) may be shown on a separate plan or drawing.

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Clause 8 Poultry Processing Regulation 1996

Part 2 Registration of poultry processing plants

- (4) Plans and drawings referred to in subclauses (1) and (3) must be prepared in a professional manner.
- (5) This clause does not apply in relation to an application for renewal of registration of a plant.

9 Registration fees

- (1) For the purposes of section 9A (3) (a) of the Act, the registration fee payable in respect of the registration of a plant of a class specified in Column 1 of the Table to this clause is the fee specified opposite that class in Column 2 of that Table.

Table

	Column 1 <i>Class of Plant</i>	Column 2 <i>Registration Fee</i>
1	Plant at which the number of poultry killed during the relevant period did not exceed 10,000	\$500
2	Plant at which the number of poultry killed during the relevant period exceeded 10,000 but did not exceed 25,000	\$800
3	Plant at which the number of poultry killed during the relevant period exceeded 25,000 but did not exceed 100,000	\$1,000
4	Plant at which the number of poultry killed during the relevant period exceeded 100,000	\$1,000 for the first 100,000 plus \$200 for each additional 100,000 or part of that number.
(2)	For the purposes of section 9A (3) (b) of the Act, the registration fee payable in respect of the registration of a plant at which no poultry was killed during the relevant period	\$500.

10 Applications for renewal of registration

An application for renewal of registration of a plant is not to be made until after the end of the relevant period in relation to the application.

11 Prescribed minimum standards for plants

For the purposes of sections 9 (2A) and 9D (1) of the Act, the prescribed minimum standards for a plant are the standards specified in Schedule 2.

12 Certificates of registration

For the purposes of section 9 (4) of the Act, the prescribed form of certificate of registration is Form 3.

13 Prescribed structural alterations and additions

- (1) For the purposes of section 9C of the Act, structural alterations and additions to a plant of the following classes or descriptions are prescribed:
 - (a) structural alterations or additions to the roof of the plant,
 - (b) structural alterations or additions to the ceilings in the plant,
 - (c) structural alterations or additions to the interior or exterior walls of the plant,
 - (d) structural alterations or additions to the floors of the plant.
- (2) An application for an approval under section 9C of the Act is to be accompanied by such maps, plans, documents and information as the Chief, Division of Animal Industries, may require.

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Clause 14 Poultry Processing Regulation 1996

Part 3 Processing of poultry

Part 3 Processing of poultry

14 Processing requirements

- (1) The operator of a plant must have in place, and adhere to:
 - (a) an approved HACCP plan, or
 - (b) an approved Quality Assurance Program.

Maximum penalty: 4 penalty units.
- (2) The operator of a plant must ensure that the requirements of Schedule 3 are complied with in processing poultry at the plant.

Maximum penalty: 4 penalty units.

Note. The requirements of Schedule 3 are additional to the requirements of the *Food (General) Regulation 1992* made under the *Food Act 1989* in relation to food for sale.

- (3) In this clause:

HACCP plan means a Hazard Analysis—Critical Control Point plan based on the 7 principles identified in the Codex Guidelines for the Application of the Hazard System adopted by the 20th Session of the joint Food and Agriculture Organisation and World Health Organisation Codex Alimentarius Commission, 1993, a copy of which Guidelines may be inspected at the offices of the Department of Agriculture.

Quality Assurance Program means a program designed to ensure, as far as is practically possible, that poultry meat and poultry meat products:

- (a) will not cause food-borne illness when properly handled and prepared for their intended use, and
- (b) do not contain chemical residues in excess of established limits, and
- (c) are free of obvious physical contamination, and
- (d) are free of defects recognised as objectionable to consumers, and
- (e) are produced under adequate hygiene control.

15 Procedure for testing weight gain

- (1) For the purposes of section 10 (1) (a) of the Act, the prescribed number of carcasses is 20.

(2) For the purposes of section 10 (1) (a) of the Act, the prescribed manner of testing carcasses for weight gain is as follows:

(a) at the stage of the process occurring immediately after the evisceration of cadavers and immediately before the cleaning of the carcasses, the inspector must:

- (i) select at least 20 carcasses,
- (ii) attach an identifying tag of an approved type to each of those carcasses,
- (iii) determine the base weight of each of those carcasses to the closest whole number of grams, and
- (iv) record each of the base weights so determined,

(b) at the stage of the process occurring immediately after the draining of carcasses has been completed, the inspector must:

- (i) select 20 of the carcasses to which an identifying tag has been attached under paragraph (a) (ii),
- (ii) determine the end weight of each of those carcasses to the closest whole number of grams, and
- (iii) record each of the end weights so determined,

(c) the inspector must then determine the weight gain of the 20 carcasses selected under paragraph (b) (i) by reference to the weights recorded by the inspector in respect of those carcasses under paragraphs (a) (iv) and (b) (iii).

(3) For the purposes of sections 6A (1) (b) and 10 (1) (b) of the Act, the prescribed percentage is 8 per cent.

(4) The operator of a plant must not remove any poultry meat, or cause any poultry meat to be removed, from any carcass which is the subject of a test for weight gain being carried out in accordance with subclause (2).

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Clause 16 Poultry Processing Regulation 1996

Part 4 Miscellaneous

Part 4 Miscellaneous

16 Identification certificates for inspectors

For the purposes of section 5 (2) of the Act, the prescribed form is Form 4.

17 Labelling of poultry meat for sale as animal food

- (1) The operator of a plant must cause all packages of poultry meat that are dispatched from the plant and that contain poultry meat intended for sale as animal food:
 - (a) to display the words "NOT FIT FOR HUMAN CONSUMPTION", and
 - (b) to be accompanied by a continuous band, affixed in a durable manner, that encircles the package by crossing the top of the package, continuing down opposite sides of the package and crossing the base of the package.
- (2) In the case of a package of poultry meat that is dispatched from the plant and that contains poultry meat intended for sale as animal food (other than a package of poultry meat referred to in subclause (3)):
 - (a) the words "ANIMAL FOOD", "ANIMAL FOOD MEAT", "INEDIBLE MEAT" or "PET FOOD," must also be displayed on the package, and
 - (b) the band that is to encircle the package in accordance with subclause (1) (b) must be coloured yellow.
- (3) In the case of a package of frozen poultry meat that is dispatched from the plant and that contains poultry meat intended for sale for further processing into animal food:
 - (a) the words "ANIMAL FOOD—FOR HEAT STERILISATION", "COOKED ANIMAL FOOD", "COOKED INEDIBLE MEAT", "ANIMAL FOOD—FIT ONLY FOR PROCESSING BY HEAT STERILISATION", "INEDIBLE MEAT—FIT ONLY FOR PROCESSING BY HEAT STERILISATION" or "PET FOOD—FIT ONLY FOR PROCESSING BY HEAT STERILISATION" must also be displayed on the package, and

(b) the band that is to encircle the package in accordance with subclause (1) (b) must be coloured red.

(4) Words required by this clause to be displayed on a package must be printed or otherwise marked on the package in letters at least 10 millimetres high on a contrasting background.

Maximum penalty: 4 penalty units.

Note. By virtue of the *Food Standards Code (Incorporation) Regulation 1995*, the *Food Standards Code* of the National Health and Medical Research Council, as amended, applies as a law of New South Wales. Standard C1 of that Code sets out (among other things) the labelling requirements for poultry that is sold for human consumption.

18 Records of poultry deliveries

The operator of a plant must cause to be kept and retained for at least 5 years a record of the number of live poultry contained in each consignment of live poultry delivered to the plant, together with particulars of the name and address of the supplier by whom each such consignment was so delivered.

Maximum penalty: 4 penalty units.

19 Written directions to be kept

The operator of a plant must retain at the plant for at least 5 years any written direction (other than a direction to which section 6A (2) or (3) of the Act relates) given to the operator under section 6A (1) of the Act by an inspector.

Maximum penalty: 4 penalty units.

20 Refunds

(1) If the period during which the registration of a plant is to be in force is less than 6 months, the applicant for registration is, on the applicant's written request to the Chief, Division of Animal Industries, entitled to a refund of one-half of the fee paid by the applicant under section 9A (3) of the Act in relation to the application.

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Clause 20 Poultry Processing Regulation 1996

Part 4 Miscellaneous

- (2) The Minister may refund such proportion as the Minister thinks fit of the registration fee paid in relation to a plant at which an approved Quality Assurance Program is in operation or has commenced.

21 Repeal

- (1) The *Poultry Processing Regulation 1982* is repealed.
- (2) Any act, matter or thing that, immediately before the repeal of the *Poultry Processing Regulation 1982*, was done for the purposes of, or had effect under, that Regulation is taken to have been done for the purposes of, or to have effect under, this Regulation.

Schedule 1 Forms

Form 1

(Clause 7 (a))

Poultry Processing Act 1969

(Section 9 (2) (b))

Application for Registration of a Plant

Plant name

(registered business name, name of company, surname of owner or other distinguishing name)

I,

(full name)

of

(address)

being the proposed operator of a plant to be located at

.....
(address of plant)

apply for registration of the plant in accordance with section 9 of the *Poultry Processing Act 1969*.

There were no poultry killed at the plant during the period of 12 months that ended on 30 April last preceding the date on and from which the registration is to be in force.

I enclose the fee of \$500.00.

Date:

Signature of proposed operator:

Capacity of proposed operator:

(owner; manager, director of company)

Form 2

(Clause 7 (b))

Poultry Processing Act 1969

(Section 9 (2) (b))

Application for Renewal of Registration of a Plant

Plant name

*(registered business name, name of company, surname of owner
or other distinguishing name)*

I,

(full name)

of

(address)

being the operator of a plant located at

.....
(address of plant)

apply for renewal of registration of the plant in accordance with section 9 of
the *Poultry Processing Act 1969*.

The number of poultry killed at the plant during the period of 12 months that
ended on 30 April last preceding the date on and from which the renewed
registration is to be in force was

I enclose the fee of \$

The registration number of the plant is

Date:

Signature of proposed operator:

Capacity of proposed operator:

(owner, manager, director of company)

Form 3

(Clause 12)

Poultry Processing Act 1969

(Section 9 (4))

Certificate of Registration of Poultry Processing Plant

No

Plant name

Address of plant

.....
Name of operator

Address of operator

.....
This is to certify that the plant described above is registered under the
Poultry Processing Act 1969 until 30 June

This certificate is issued subject to the following conditions and restrictions:

.....
.....
Date:

.....
Signature of Chief, Division of Animal Industries:

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Schedule 1 Forms

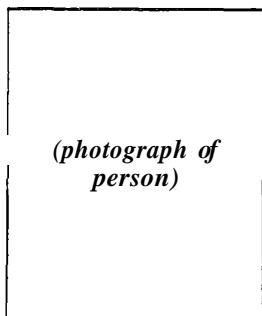
Form 4

(Clause 16)

Poultry Processing Act 1969

(Section 5 (2))

Certificate of Identification as an Inspector



This is to certify that:

.....
(insert name of person being appointed)

a specimen of whose signature appears below

.....
(specimen of signature)

is appointed as an inspector for the purpose of the *Poultry Processing Act 1969*.

Dated this day of 19

.....
Minister for Agriculture

Schedule 2 Prescribed minimum standards for plants

(Clause 11)

Part A Location, facilities and layout of plant

1 Location of plant

- (1) The plant must be situated on land that is well-drained and not subject to flooding.
- (2) Unless otherwise approved, the plant must be situated at least 150 metres from any building used for human habitation, any factory, any public road and any place on which is carried on an activity that is likely to cause poultry or poultry meat in the plant to become contaminated.

2 Design of plant

The plant must be designed so as to facilitate the sanitary conduct of processing operations and the efficient conduct of inspections and tests.

3 Services to plant

The plant:

- (a) must be supplied with drinking water of a quantity and under a pressure sufficient for all operating needs, and
- (b) must have an approved waste water disposal system, and
- (c) must have a permanent supply of electricity.

4 Condition of plant

- (1) The plant must be in good condition and the surrounding areas must be in a clean and sanitary condition.
- (2) Areas surrounding the plant must be treated to a distance of at least 30 metres from the plant so as to prevent dust arising from those areas.

5 Separate specialist areas of plant

- (1) Specified sections are to be provided in the plant for stunning, bleeding, scalding, defeathering, eviscerating, washing, chilling and storing poultry and poultry meat.

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Schedule 2 Prescribed minimum standards for plants

- (2) Preparation areas and by-product areas must be isolated from each other, unless the Chief, Division of Animal Industries, approves in writing of their not being so isolated.
- (3) Any processing area must be isolated from all other parts of the plant. In particular, it must be at least 75 metres from any area in which live poultry is held.
- (4) Any wet rendering area must be located at least 30 metres from any other building in the plant.

6 Live poultry and poultry meat

- (1) Any part of a plant to which poultry or poultry meat is delivered, or from which poultry meat is dispatched, must be sheltered, paved and drained.
- (2) Adequate ventilation must be provided, and an appropriate temperature must be maintained, in any area in which live poultry is held.

7 Poultry waste

- (1) Any area in a plant used for the dispatch of poultry waste or of products arising from the treatment of poultry waste must, unless otherwise approved, be sheltered, paved and drained.
- (2) Earth pits for the disposal of poultry waste, if approved, must be situated at least 75 metres from any preparation or processing area and must be securely covered with a metal or concrete lid to minimise their attraction to insects and pests.

8 Store rooms

- (1) Any store room in which packing materials, or spices or other substances used in the preparation of poultry meat, are stored must:
 - (a) be provided with racks for the storage of those materials and substances, and
 - (b) be isolated from all other parts of the plant, and
 - (c) be constructed so as to prevent the entry of insects, birds, rodents and pests.

(2) Any store room in which cleaning agents, poisons or pesticides are stored must:

- (a) be isolated from all other parts of the plant, and
- (b) be capable of being effectively secured.

9 Amenity rooms

- (1) Amenity rooms must be provided for the use of employees if the Chief, Division of Animal Industries, so requires.
- (2) Amenity rooms must also be provided for the exclusive use of inspectors carrying out their functions at the plant, if the Chief, Division of Animal Industries, so requires.
- (3) All amenity rooms must:
 - (a) be isolated from all other parts of the plant, but located so as to be readily accessible to the various sections of the plant, and
 - (b) be constructed in accordance with good trade practice, and
 - (c) be fly-proof, well ventilated and provided with artificial lighting, and
 - (d) be provided with an electric or other approved power supply.
- (4) Paved walkways must be provided from the various sections of the plant to the amenity rooms in such a way as:
 - (a) to allow a person moving from a preparation area or a by-product area to an amenity room to do so without passing through a processing area, and
 - (b) to allow a person moving from a processing area to an amenity room to do so without passing through a preparation area or a by-product area.

10 Toilets

Any toilet must be separated from all other parts of the plant by means of an air-lock.

Part B Construction standards

11 Materials

Materials used in the construction and equipment of a plant must be:

- (a) durable, and
- (b) non-toxic, and
- (c) smooth-surfaced, and.
- (d) resistant to corrosion, and
- (e) impervious to moisture, and
- (f) resistant to impact, and
- (g) capable of being easily cleaned, and
- (h) resistant to chipping and flaking, and
- (i) of a finish that makes foreign matter clearly visible, and
- (j) so far as is practicable, maintenance-free.

12 Floors

The floors of a plant must:

- (a) be constructed of concrete or other approved material, and
- (b) be impervious to moisture, and
- (c) have approved anti-slip surfaces, and
- (d) be coved to a radius of at least 25 millimetres at their junctions with walls in such a manner that there are no cracks between the floors and the coving or between the walls and the coving.

13 Walls

The walls of a plant must:

- (a) be constructed of concrete or other approved material, and
- (b) if prefabricated, be on plinths of concrete or other approved material at least 150 millimetres high, and

- (c) have internal surfaces that are smooth and impervious to moisture:
 - (i) to a height of at least 1.8 metres above the level of the floor, and
 - (ii) in all places where poultry or poultry meat passes within 1 metre of those surfaces, and
- (d) if lined internally with sheets of material—be lined with the sheets running perpendicularly to the floor and joined together with smooth corrosion-resistant metal or other approved mouldings or cover strips, and
- (e) be vertical and, if they do not reach the ceiling, be fitted with caps sloped at an angle of at least 45 degrees to the horizontal, and
- (f) except for the walls in a storage room, not have any shelves attached, and
- (g) be coved to a radius of at least 25 millimetres at their junctions with other walls in such a manner that there are no cracks between the walls and the coving.

14 Ceilings and roof

- (1) The ceilings in a plant must be:
 - (a) constructed of approved material, and
 - (b) smooth and impervious to moisture.
- (2) The roof must be waterproof.

15 Openings and joints

- (1) Openings to the exterior of buildings must be effectively screened so as to prevent the entry of insects, rodents, birds and pests of any kind.
- (2) The joints between the component parts of the structure of a plant must be sealed with a non-toxic, pliable sealing compound that is impervious to moisture.

16 Doors

- (1) All doors in a plant must be self-closing.
- (2) Doors and door jambs must be constructed of, or be lined with, corrosion-resistant metal or other approved material.

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Schedule 2 Prescribed minimum standards for plants

17 Window sills and fittings

- (1) Window sills must, unless otherwise approved, be located at least 1.2 metres above the level of any floor above which they are situated.
- (2) The upper surfaces of all window sills, lockers, cupboards and other fittings in a processing area must be sloped at an angle of at least 45 degrees to the horizontal.

18 Stairs

Stairs and work platforms must be constructed of materials that are impervious to water and resistant to corrosion and must, unless otherwise approved, have solid treads or floors, closed risers and be edged with kerbs at least 150 millimetres high.

19 Exposed woodwork

Interior exposed woodwork must consist of dressed timber that has been treated so as to be impervious to moisture.

20 Lights and light fittings

- (1) The lighting in a plant must have a degree of illumination:
 - (a) at any inspection point—of at least 600 lux, and
 - (b) at any point where poultry meat is eviscerated, cleaned, cut up, boned or packaged—of at least 400 lux, and
 - (c) at any other work surface—of at least 220 lux.
- (2) Eight fittings must be fitted with shatter-proof covers and, in the case of fittings that are suspended from a roof or ceiling, must be fitted with caps sloped at an angle of at least 45 degrees to the horizontal.

21 Ventilation

- (1) A ventilation system must be provided for all processing areas and must be capable of effecting at least 4 air changes per hour in those areas.
- (2) The system must prevent excessive heat and condensation in the plant and the entry of odours, dust, vapour and smoke.

- (3) Air vents must be located in such positions as to avoid the intake of contaminated air.
- (4) Roof-mounted cooling systems must not discharge over poultry meat.

Part C Drainage

22 Number of outlets

At least one drainage outlet must be provided for each 40 square metres (or part of 40 square metres) of floor space in all preparation and processing areas.

23 Gradation and direction

- (1) Floors must be graded at least 1 in 50 to drainage outlets.
- (2) The drainage system must be constructed so that effluents are drained in the opposite direction to that in which poultry meat passes.

24 Disconnecting traps required

Floor drains must be provided with disconnecting traps.

25 Drainage valleys

- (1) Drainage valleys must be provided with approved covers at all points above which any person, any poultry or any poultry meat passes.
- (2) The bases of all floor drainage valleys must be coved to a radius of at least 25 millimetres at their junctions with the sides of the valleys.

26 Drainage pipes

- (1) Drainage pipes must have an internal diameter of at least 100 millimetres and must be constructed of an approved material that is impervious to water and resistant to corrosion.
- (2) Drainage pipes must not be vented inside any preparation or processing area.

27 Save-all pits

- (1) Save-all pits must not be located inside any preparation or processing area.
- (2) Save-all pits must be separated from drainage outlets by means of deep seal traps.
- (3) Save-all pits must be constructed of concrete or other approved material and must be provided with a surround that is similarly constructed and that slopes downwards towards the pit.

Part D Equipment

28 Equipment generally

- (1) Equipment used in connection with the process must:
 - (a) be constructed of materials that are non-toxic, impervious to moisture, resistant to corrosion, shattering, chipping, flaking and abrading, unaffected by repeated treatment in hot water or with cleaning agents and incapable of affecting the flavour of poultry meat, and
 - (b) be constructed with external surfaces that are smooth and free from crevices and recesses that are likely to harbour contaminants, and
 - (c) be positioned in such a way as to prevent splashing of surrounding areas, and
 - (d) be capable of being easily and thoroughly cleaned, and
 - (e) not contain inaccessible seams, gaps, crevices or recesses, and
 - (f) be in good order and condition.
- (2) Materials used for gasketing in equipment used in connection with the process must be non-toxic, impervious to moisture and unaffected by contact with poultry meat, lubricants and cleaning agents.
- (3) All equipment must be constructed so that any overflow or effluent from the equipment is discharged directly into a drainage outlet or drainage valley.

29 Equipment for holding live poultry

Coops, crates and cages intended for holding live poultry must be constructed of materials that are impervious to moisture and resistant to corrosion and must be designed for easy cleaning.

30 Equipment that comes into contact with poultry meat

- (1) The following materials must not be used in the construction of those parts of equipment that come into contact with poultry meat in the course of the process:
 - (a) cadmium,
 - (b) copper, or any alloy containing copper,
 - (c) lead,
 - (d) paint,
 - (e) enamel,
 - (f) wood,
 - (g) porcelain,
 - (h) aluminium.
- (2) Any table on which poultry meat is handled or otherwise treated must, if positioned against a wall, be provided with a suitable splashback.
- (3) Any container in which poultry meat is stored must be constructed so as to permit the efficient drainage of any fluids from the container.

31 Equipment required in all processing areas

The following facilities and appliances must be provided in all processing areas:

- (a) approved facilities for washing poultry meat,
- (b) approved facilities for the conduct of inspections and tests,
- (c) hand-wash basins that are operated by means of a foot pedal or other approved means and are:

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- (i) provided with an adequate supply of drinking water at a temperature of at least 40 degrees Celsius mixed from a hot and cold supply and delivered through a single outlet approximately 300 millimetres above the rim of the basin, and
- (ii) provided with approved soap dispensers, and
- (iii) provided with splash guards, and
- (iv) drained directly to the drainage system or into the floor valleys, and
- (v) located so as to be readily accessible to employees at the plant, and
- (vi) sufficient in number, having regard to the number of employees,
- (d) approved hand-drying facilities,
- (e) wash-down hoses situated so as to enable all parts of the processing areas to be readily cleaned,
- (f) hot water at a temperature of at least 82 degrees Celsius,
- (g) approved facilities for the cleaning and storage of all equipment.

32 Equipment required in specific areas or locations

- (1) All processing areas, other than chilling rooms, must be provided with hot and cold water connections.
- (2) Hose connections and racks for the storage of hoses must be provided in each preparation and processing area.
- (3) Approved boot-washing facilities must be provided at each entrance to the processing area.
- (4) Approved hand rinsing facilities must be provided in any part of the plant in which live poultry is attached to chains, conveyors, shackles or other equipment used for its conveyance.

33 Refrigeration

- (1) Refrigeration facilities of an approved type and capacity must be provided.
- (2) Refrigeration facilities must be equipped in such a way that poultry meat is stored in them:
 - (a) on approved pallets, or
 - (b) on racks or shelves with at least 300 millimetres clearance from the floor.
- (3) Drainage water from refrigeration facilities must be discharged into the drainage system so as to prevent its coming into contact with any poultry meat.
- (4) Any floor waste in a freezer is to be sealed by an approved device.
- (5) The temperature of a chiller or freezer unit must be displayed on the outside of the unit.

34 Immersion tanks

- (1) Immersion tanks must be provided with overflow pipes.
- (2) Any water outlet which supplies water to an immersion tank must, unless otherwise approved, be located at least 50 millimetres above the level of the overflow pipe of the tank.
- (3) If a water supply line leads to an approved submerged water outlet in an immersion tank, the water supply line must be provided with an effective non-return valve.

35 Drip trays and drainage trays

- (1) Any equipment located above any point through which any person, any poultry or any poultry meat passes must be provided with drip trays.
- (2) Drip trays and drainage trays must be demountable for ease of cleaning.

36 Cleaning of equipment

- (1) All equipment installed in a plant must be located so that all parts of the equipment are readily accessible for cleaning and inspection.
- (2) Approved sterilisers must be provided for the sterilising of implements used in connection with the eviscerating, cleaning, cutting up and boning of poultry meat.
- (3) An equipment washing area, separately drained and adequately ventilated, must be available in a part of the plant that is separate from the processing area. It must be accessible to persons working in the processing area.

37 Miscellaneous

- (1) Any spin washer or chiller must be of a counterflow design with a water supply that is adequate to maintain sanitary conditions.
- (2) Pipelines in plants constructed after 1 September 1996 must be identified in accordance with Australian Standard AS 1345-1995 (Identification of the contents of pipes, conduits and ducts).
- (3) All water lines and electrical cables must, if not plumbed into the structure of a building, stand at least 25 millimetres away from any part of the building or structure to which they are attached.

Schedule 3 Processing of poultry

(Clause 14)

Part A General

1 Killing of poultry

- (1) Poultry to be killed must be rendered unconscious by an electric current, carbon dioxide gas or dislocation of the neck and must not be allowed to regain consciousness.
- (2) Poultry must be killed by removal of the head.
- (3) Despite subclauses (1) and (2), poultry to be killed may be rendered unconscious, or killed, by a different method if that method is approved.

2 Poultry meat for human consumption to be wholesome

- (1) Poultry must not be used in the preparation of poultry meat for human consumption if the poultry:
 - (a) died otherwise than by being killed in the course of the process, or
 - (b) is unwholesome.
- (2) Without affecting the generality of subclause (1), poultry is unwholesome if it shows signs of
 - (a) toxæmia,
 - (b) septicaemia,
 - (c) emaciation,
 - (d) extensive abscesses, tumours, wounds or other lesions,
 - (e) extensive discolouration,
 - (f) extensive purulent peritonitis,
 - (g) ascites,
 - (h) decomposition, or
 - (i) chemical contamination.
- (3) Unwholesome poultry must be killed and their cadavers placed in poultry waste bins.

3 Poultry meat for sale to be fit for human consumption

- (1) Poultry meat must not be used in the preparation of poultry meat for sale unless the poultry meat concerned is fit for human consumption.
- (2) Without affecting the generality of subclause (1):
 - (a) a trunk of a carcass is not fit for human consumption if it shows signs of
 - (i) major internal faecal spillage, or
 - (ii) tumours,
 - (b) the giblets from a carcass are not fit for human consumption if the viscera from the carcass shows signs of:
 - (i) tumours,
 - (ii) abscesses,
 - (iii) haemorrhages,
 - (iv) faecal spillage,
 - (v) fibrinous deposits,
 - (vi) cirrhosis of the liver, or
 - (vii) parasites, and
 - (c) a limb from a carcass is not fit for human consumption if the limb shows signs of:
 - (i) staining,
 - (ii) bruising,
 - (iii) tumours,
 - (iv) abscesses,
 - (v) wounds, or
 - (vi) infected hocks.

4 Contaminated poultry meat

- (1) Poultry meat that touches the floor, or any other part of the plant, any equipment in the plant or any matter or thing in the plant other than the equipment by which it is being processed or the material in which it is packaged must be considered to be contaminated.

- (2) Poultry meat that is touched by any person, other than the person by whom it is being processed or an inspector acting in the lawful exercise of the inspector's duties under the Act, must be considered to be contaminated.
- (3) Poultry meat that is touched by water that has been used in the cleaning of carcasses or that has been used for the purpose of cleaning any part of the plant or any equipment must be considered to be contaminated.
- (4) Poultry meat that is contaminated must not be used in the preparation of poultry meat for human consumption unless it is washed or trimmed, as appropriate, to remove the contamination.

Part B Stages of the process

5 Delivery of live poultry

Live poultry must not be delivered to a plant unless the coops, crates or cages in which it is delivered are in good repair and free from rust.

6 Use of wax in removal of feathers

- (1) If wax is used in the removal of feathers, the cadavers of the poultry concerned must be handled in such a way that all used wax and removed feathers fall directly into containers.
- (2) Wax must not be used in the removal of feathers unless the wax is clean, is of an edible grade and has been stored in hygienic conditions.
- (3) Used wax that is to be used again must be held at a temperature of at least 80 degrees Celsius for at least 20 minutes and:
 - (a) skimmed, washed and filtered, or
 - (b) passed through a centrifugal cleaning machine.
- (4) Feather separation sieves in wax dipping machines must be removed and cleaned at least once a day.

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7 Collection of feathers

Feathers must be continuously collected and removed from the defeathering and scalding sections in a way that does not contaminate either the poultry or the processing area.

8 Heads and feet

- (1) Poultry heads and feet must be removed in the defeathering section unless the poultry is to be prepared for sale with its head and feet on.
- (2) Despite subclause (1), poultry feet may be removed in the evisceration section if the processing of the poultry involves total immersion scalding.
- (3) A container, drain or mechanical removal system must be located in such a position that heads and feet, when removed, fall directly into them.
- (4) Poultry that is to be sold with its head and feet on must be processed at the end of the day's operations and prepared so that:
 - (a) the head (including the beak, oral cavity and nasal passages) are clean and free of extraneous matters, and
 - (b) the feet are clean and free of nails and epidermal scales.

9 Feet for further processing

- (1) If feet are required for further processing, they must be removed from the container, drain or mechanical system and:
 - (a) scalded, descaled, washed and chilled to less than 5 degrees Celsius in a section of the plant used only for that purpose within one hour after removal, or
 - (b) bulked and chilled to less than 5 degrees Celsius before being transported under refrigeration to another place for approved further treatment.
- (2) The feet are to be stored at the plant, and transported to the other place, separately from other poultry meat.

10 Bleeding of poultry

- (1) If poultry is bled, it must be bled in such a way that the blood does not enter the drainage system.

11 Evisceration

- (1) Poultry must be washed before it is eviscerated. It may be washed either by a water spray or in running water.
- (2) Poultry must be eviscerated within one hour after being killed and in such a manner that the intestinal tract is not severed.
- (3) Any vent gun used in connection with the evisceration of poultry must be flushed with running water after each use.
- (4) Evisceration troughs must be provided with running water at all times while poultry is being eviscerated.
- (5) Immediately after a cadaver is eviscerated, the inner and outer surfaces of the carcass must be cleaned by means of a water spray or running water and in such a manner as to prevent other poultry or poultry meat from becoming contaminated by that water.

12 GIBLETS

- (1) GIBLETS intended for human consumption must be separated from viscera immediately after the viscera is removed from its cadaver.
- (2) GIBLETS intended for sale with poultry meat must be washed by means of a water spray or running water and must be chilled to a temperature of not more than 4 degrees Celsius within 1 hour after their removal from the viscera.
- (3) GIBLETS must not be packaged for sale until after they have been drained to remove any ice or excess water.
- (4) GIBLETS must not be packaged together with poultry meat unless the gIBLETS are enclosed in sealed packets made of an approved material.

13 Temperature requirements

- (1) Whole poultry carcasses must be chilled to a surface temperature of not more than 7 degrees Celsius within 6 hours after slaughter.

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- (2) Carcasses (or parts of carcasses) and deboned poultry meat must be:
 - (a) further chilled to a core temperature of not more than 5 degrees Celsius within 12 hours after slaughter, and
 - (b) stored and transported in conditions that ensure that the temperature does not exceed 5 degrees Celsius.
- (3) The temperature of any air or water in which poultry meat is thawed must not exceed 10 degrees Celsius.

14 Poultry meat for human consumption

Poultry meat that is intended for human consumption must not be taken into any preparation or by-product area.

15 Poultry meat for animal food

- (1) Poultry meat that is intended for sale as animal food must be stained, before being placed into a chiller or freezer, with an aqueous solution of Brilliant Blue FCF (number 42090 in the Society of Dyers and Colourists Colour Index, Third Edition, 1971) diluted to at least one part in 500, or with an approved dye solution, so that the dye is visibly dispersed throughout the meat.
- (2) Subclause (1) does not apply to poultry meat intended for processing by heat sterilisation at a pet food processing plant.

16 Miscellaneous

- (1) A wetting agent must not be added to water in a scald tank unless:
 - (a) the agent is of an approved type, and
 - (b) the concentration of the agent in the water does not exceed the percentage approved for that type of agent.
- (2) Thawed poultry meat must not be refrozen.

Part C Further processing

17 Where further processing may be carried out

- (1) Rooms or sections designated for further processing must comply with the Australian Standard for Construction of Premises Processing Meat for Human Consumption (CSIRO publishing, 1995).

- (2) If fresh poultry meat is to undergo any process that will result in its being other than simple fresh or frozen meat (such as marinading, smoking, cooking, being blended with other edible matter, being included with other edible matter or any similar process), that process is to be carried out in a room that is isolated from any area in which poultry is defeathered or eviscerated.
- (3) If the process involves smoking or cooking, the room in which it is carried out must also be isolated from any area in which raw poultry meat is otherwise handled.
- (4) If poultry meat is removed from a chiller for processing:
 - (a) the process must be carried out in a place so constructed as to maintain an air temperature of not more than 10 degrees Celsius, or
 - (b) the temperature of the poultry meat must be reduced to no more than 5 degrees Celsius within 3 hours after the process has been carried out.

Part D Poultry waste

18 Waste to be placed in bins

Poultry waste must be placed in poultry waste bins as soon as it arises in the course of the process.

19 Special bins to be used for waste

- (1) Poultry waste bins must be provided with close-fitting covers and must either be coloured red or labelled as containing inedible material.
- (2) All other bins used in connection with the process must be so coloured as to be readily distinguishable from poultry waste bins.
- (3) Poultry waste bins must not be used for the handling of poultry meat for human consumption or animal food.

20 Disposal of waste

- (1) Poultry waste must be removed from the plant, or disposed of at the plant in an approved manner, every day.

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- (2) Poultry waste that is emptied from poultry waste bins and is not immediately disposed of must be stored, pending its disposal, in leak-proof containers with close-fitting covers located outside the preparation and processing areas, under cover and on a concrete slab that is drained and kerbed.
- (3) If poultry waste is intended to be sold for further processing by heat sterilisation into animal food, it may be stored at the plant under the following conditions:
 - (a) it must be stored in leak-proof containers identified for that purpose, and
 - (b) it must be kept under refrigeration in a room used solely for that purpose.
- (4) Poultry waste that is removed from the plant must be removed in leak-proof containers that are securely covered so as to prevent spillage.

Part E Hygiene

21 Water

- (1) Water that is not drinking water must not be used in a plant except for such purposes as may be approved.
- (2) Ice must not be used in connection with the process unless it has been made from drinking water and is clean and free from contamination.
- (3) If chlorinated water is used in connection with any part of the process, the concentration of residual chlorine in the water, as measured by an approved method, must not be less than 0.25 parts of residual chlorine per million parts of water.

22 Immersion tanks

- (1) Any immersion tank that is used in connection with any part of the process must be supplied with running water and with an efficient overflow.

- (2) The temperature of the water used in an immersion tank must not exceed 20 degrees Celsius at any time while the tank is being used.
- (3) Subclause (2) does not apply to the temperature of the water used in a scald tank.
- (4) Carcasses must not remain in an immersion tank for longer than 15 minutes unless the temperature of the water in the tank is less than 4 degrees Celsius.

23 Implements

- (1) If any implement used in the evisceration of poultry, or the cutting up or boning of poultry meat, becomes contaminated, it must not be allowed to come into contact with poultry or poultry meat until after it has been sterilised in an approved manner.
- (2) All implements used in the process must be sterilised at the end of each day's operations and, when not being used, must be stored in racks.

24 Clothing

- (1) A person must not enter a processing area unless the person is wearing approved protective clothing that includes:
 - (a) a head covering,
 - (b) two-piece protective clothing or a coat, and
 - (c) waterproof footwear.
- (2) Protective clothing and equipment that is worn in a plant is not to be worn outside the plant.
- (3) A person must not enter a processing area unless the person's clothing is clean and free from contamination.
- (4) All clothing worn by persons in a processing area must be clean at the commencement of each day's work.
- (5) Any protective clothing worn by persons employed in a preparation area must be readily distinguishable from that worn by persons in a processing area and must not be stored together with clothing worn in a processing area.

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- (6) A person must remove all gloves, aprons and processing implements before entering any amenity room.

25 Prevention of contamination

- (1) A person must wash his or her hands immediately on entering a processing area.
- (2) A person employed in a processing area must keep his or her hands and implements clean by means of frequent washing.
- (3) If a person who is carrying on any part of the process has any infected lesion on any exposed skin of the person's body, the person must keep the lesion covered with a clearly visible impervious dressing.
- (4) If the body or clothing of a person employed in a processing area becomes contaminated with blood, faeces, visceral matter or chemicals, that person must not continue carrying out any part of the process until after he or she has removed the contamination, whether by means of washing, changing clothing or otherwise.

26 Storage

- (1) Receptacles containing poultry meat, packaged poultry meat and packaging materials must not be stored otherwise than on pallets, racks or shelves that are situated at least 300 millimetres above the floor.
- (2) Pallets must not be used in connection with the conveyance or storage of poultry meat unless they are made of an approved material.

27 Miscellaneous

- (1) A person must not consume food or drink in a preparation or processing area.
- (2) No animal (other than poultry that is to be dealt with in the course of the process) is to be allowed to enter or remain in a plant.

Part F Cleaning routines

28 Containers

All containers brought into a plant must be sanitised in an approved manner before being used for the storage or packaging of poultry meat.

29 Vehicles

Vehicles must not be cleaned in a plant otherwise than in an area that is paved and drained and that is isolated from any processing area in the plant,

30 Plant generally

- (1) Every part of, and everything in, a plant must be kept clean, tidy, free of vermin and in good repair.
- (2) Without affecting the generality of subclause (1):
 - (a) all floors, steps, stairways, doors, windows, window-sills and drains, and all equipment used in the process, must be cleaned at the end of each day's operations,
 - (b) all vehicles, coops, crates and cages used for the delivery of live poultry to a plant must be cleaned after each delivery,
 - (c) all chains, shackles, droppers and other equipment used for the conveyance of poultry, the supports of that equipment, all overhead lights and their supports, all overhead joists, beams, pipes and all other overhead things must be kept clean and free of rust, scale, flaking paint and dripping lubricant,
 - (d) all refrigeration facilities must be dry-cleaned daily,
 - (e) all toilets and the floors of the rooms in which they are situated must be washed daily with hot water to which a detergent has been added,
 - (f) all buildings, loading bays and areas to which live poultry is delivered or in which it is held, and the environs of all such places, must be cleaned so as to prevent the accumulation of dust, debris and manure, and
 - (g) all amenity rooms must be cleaned daily.

(3) In carrying out any cleaning required under subclause (2), a hose must not be used in the vicinity of poultry that is being killed or of poultry meat that is being processed.

31 Cleaning during processing

(1) While processing is being carried out:

- (a) the floors and drains in the vicinity of any plucking machine must be regularly cleaned so as to prevent the accumulation of feathers,
- (b) poultry waste bins and other receptacles containing rubbish or waste must be regularly emptied so as to prevent the bins from being overfilled and must be cleaned before being re-used, and
- (c) blood containers, channels, troughs and drains, bleeding floors and bleeding cones must be regularly emptied and cleaned.

(2) Any chains, conveyors, shackles or other equipment used for the conveyance of poultry during the stunning, killing, scalding, defeathering or decapitation of the poultry must be cleaned before they enter any processing area or before they are returned to the point at which poultry are attached to them.

32 Air-drying required at end of day's operations

All equipment, and all aprons, gloves and footwear, must, after being washed at the end of each day's operations, be allowed to air-dry.