

CHAPTER 291

MEAT (POST MORTEM) (BONELESS MEAT)
INSPECTION REGULATIONS

ARRANGEMENT OF REGULATIONS

1. Short title.
2. Definitions.
3. Export Meat.
4. Deboning.
5. Facilities.
6. Deboning area.
7. Inspection area.
8. Inspection of carcasses.
9. Deboning of meat.
10. Boneless Meat Reinspection.
11. Lot inspections and on-line inspections.
12. Records to be kept.
13. Tables.

CHAPTER 291

4 of 1985.
Ch. 219.

MEAT (POST MORTEM) (BONELESS MEAT)
INSPECTION REGULATIONS

(Section 11)

[16th February, 1985]

- Short title. 1. These Regulations may be cited as the
- MEAT (POST MORTEM) (BONELESS MEAT)**
INSPECTION REGULATIONS.
- Definitions. 2. In these Regulations the following expressions have the meanings hereby assigned to them respectively, that is to say-
- “boneless meat” means all deboned skeletal meat from carcasses and heads of cattle, calves, sheep, goats, swine;
- “critical” means those defects which are so extensive or numerous that they affect the wholesomeness and/or acceptability of the product;
- “defect” means blood clots, bruises, bone fragments, bone splinters, detached cartilage and ligaments, hide, hair, wool, parasites, lesions, pathological lesions, stains, and discoloured areas, ingesta, extraneous materials such as wool, metal, glass, paper, plastic, wild oat or grass beards, insects and suchlike, as specified in the Tables to these Regulations;
- “establishment” means any authorised slaughter house;
- “lot” means the meat from a group of one species or type (beef, veal, pork) of animals coming from the same source;
- “major” means those defects which are greater than minor defects but not so

great or extensive as critical defects;

“minor” means those defects which are such as to be insignificant and do not affect the quality or wholesomeness of the product.

3. Meat for export to certain countries as specified in the regulations shall be deboned and reinspected after deboning. Export Meat.
4. Deboning shall be performed by employees of the establishment, licensed under the provisions of the Food and Drugs Act and Regulations made thereunder. Deboning.
CAP. 291.
5. The establishment shall provide an adequate deboning area provided with rustless metal tables and shall at all times be maintained in a clean and sanitary condition and at a temperature of 55 to 60 °F (13 to 16 °C). Facilities.
6. The deboning area shall have facilities for washing hands and sterilising knives and tools prior to and during the deboning operations and shall be provided with adequate light. Deboning area.
7. The establishment shall provide an adequate inspection area with a rust resistant table, illuminated with a light of an intensity of at least 50 foot candles and shall provide adequate help for the Authorised Officer. Inspection area.
8. All carcasses and parts of carcasses shall be inspected by competent establishment employees who shall remove any foreign matter from the said carcasses or parts thereof prior to deboning. Inspection of carcasses.
9. The meat shall be deboned in a manner so as to ensure a clean and wholesome product. Deboning of meat.
10. Boneless meat reinspection shall apply to all deboned skeletal meat from carcasses and heads of cattle, calves, sheep, goat, and swine intended for cooking, canning, packaging, boxing, freezing and other processing at Boneless Meat Reinspection.

establishments preparing meat products.

Lot inspections
and on-line
inspections.

11. The inspection of boneless meat shall follow either one of two plans, lot inspection or on-line inspection.

(1) **Lot Inspection:** The establishment shall be responsible for grouping the product into coded lots which shall be acceptable to the Authorised Officer, and for adequately identifying and re-conditioning rejected lots.

- (a) The authorised Officer shall after each lot is completely assembled, determine the size of the lot in pounds weight and select the indicated sampling plan from Table I. The Authorised Officer may select a larger sample for greater assurance.
- (b) The authorised Officer- shall randomly select the required number of cartons from the lot in proportion to the different code marks and remove 12-pound samples from each of the cartons.
- (c) The Authorised Officer shall examine the samples of the product thoroughly and classify the defects according to Table II for cattle, sheep or goat meat or Table III for meat from swine.
- (d) The Authorised Officer shall accept or reject the lot according to the accept-reject criteria as shown in Table I.
- (e) After the rejected lot has been reconditioned by the establishment, the Authorised Officer shall reinspect the rejected lot at a sampling rate one plan higher than the original plan (Table I).

(2) **On-Line Inspection:** For this inspection, the establishment must have a record of producing a good clean product, and approval of the Authorised Officer shall be required.

- (a) The Authorised Officer shall sample the product by taking a 3-pound sample from each production line, at least each half hour. The sampling point shall be close to where the product enters the containers.
- (b) The Authorised Officer shall examine each sample unit and properly classify its defects according to Table II for cattle, sheep, or goat meat or Table III for meat from swine.
- (c) The Authorised Officer shall evaluate the individual (30 pounds) sample unit limits and the cumulative total limits as per Table I.
- (d) The Authorised Officer shall reject and hold the rejected product when it exceeds the limits. Such product shall be reconditioned and reinspected after reconditioning.
- (e) The Authorised Officer shall follow lot inspection procedures until 60,000 pounds or two days' production is completed, whichever is the less, before on-line inspection shall be resumed.

(3) The Authorised Officer shall-

- (i) Assure that the inspectors properly judge the defects.
- (ii) Inspect a 30 pound sample four times a day or two

30 lbs. samples on each patrol visit or the product available at the time of the visit.

- (iii) Observe the cleanliness of the carcasses before deboning.
- (iv) If a rejection limit is reached, confirm that all the product on hand is cleaned and re-inspected.

(4) If an unacceptable product is passed by the inspector, the Authorised Officer in charge shall enforce product lotting and holding and shall insist on lot-by-lot inspection under his close surveillance until he feels that the establishment may resume online inspection. Lot inspection shall continue until 60,000 lbs. or two days' production has been processed and inspected without rejection.

Records to be kept.

12. The establishment shall keep records of each inspection and inspection results and records of each shipment showing the date, product description, quantity, number of pieces or units, and its origin and destination. Such records shall be available for inspection by Authorised Officers.

Tables.

13. **Tables:** Table I shall be used to select the sampling plan for reinspection of boneless meat and to determine the size of a representative sample to be taken from each designated lot. This table also shows the number of major and critical defects and the total number of minor, major and critical defects to be used as criteria for determining acceptance or rejection of the inspected boneless meat.

Table II shall be used to classify the defects found in boneless meat from cattle, calves, sheep and goats.

Table III shall be used to classify the defects found in boneless meat from swine.

TABLE I

SAMPLING PLANS

Lot Size (Pounds)	Plan No.	Step No.	Sample Units	Major		Critical		Total	
				Ac	Re	Ac	Re	Ac	Re
1,000 or less	5*	-	3	0	1	0	1	1	2
8,000 or less	10	-	6	0	1	0	1	5	6
8,000 to (but not including) 24,000	15	1	9	0	2	0	1	4	8
		2	3	-	-	-	-	-	-
Total			12	1	2	0	1	8	9
24,000 to (but not including) 60,000	20	1	15	0	3	0	1	6	12
		2	15	-	-	-	-	-	-
Total			30	2	3	0	1	18	19
60,000 to (but not including) 240,000	25	1	22	0	4	0	1	9	16
		2	25	-	-	-	-	-	-
Total			47	3	4	0	1	26	27
240,000 to (but not including) 500,000	30	1	27	0	4	0	1	10	19
		2	40	-	-	-	-	-	-
Total			67	4	5	0	1	35	36
500,000 to (but not including) 1,000,000	35	1	33	0	5	0	2	12	21
		2	56	-	-	-	-	-	-
Total			89	5	6	1	2	45	46
500,000 to (but not including) 1,000,000	** 40	1 2	40 71	0 -	6 -	0 -	2 -	15 -	25 -
Total			111	6	7	1	2	56	57
1,000,000 and over	45	1	72	3	7	0	2	32	41
		2	48	-	-	-	-	-	-
Total			120	6	7	1	2	60	61
1,000,000 and over	** 50	1 2	120 100	4 -	9 -	0 -	3 -	51 -	63 -
Total			220	11	12	2	3	105	106

Ac: Accept Re: Reject * To be used only on request of the management of the Establishment.

** Alternate plan for the applicable lot size for reinspection of rejected lots and for lots consisting of numerous marks.

TABLE II

**FOR USE IN CLASSIFICATION OF DEFECTS FOUND IN BONELESS MEAT
FROM CATTLE CALVES SHEEP OR GOATS**

<i>Type</i>	<i>Description</i>	<i>Class</i>
	Less than 1½" in greatest dimension	* Insignificant
Blood Clots	1½" to 6" in greatest dimension	Minor
	More than 6" in greatest dimension or numerous (over 5) minor blood clots (***) in one sample unit not seriously affecting product usability	Major
	One or more of a number or size seriously affecting product usability	Critical
Bruises	Less than 1" in greatest dimension and less than ½" deep	* Insignificant
	1" to 2½" in greatest dimension of ½" to 1" deep	Minor
	More than 2½" in greatest dimension or more than 1" deep or numerous (over 5) minor bruises (***) in one sample unit not seriously affecting product usability	Major
	One or more of a number or size seriously affecting product usability	Critical
Bone Fragments	(1) Thin bone scraping less than 1/32" thick x 1/8" wide x 3" long attached to muscle tissues. (2) Thin flexible bone slivers either attached to or detached from muscle tissue less than 1/4" wide and 3/4" long. (3) Thin bone fragments or chips either attached to or detached from muscle tissue that crumble easily and are less than 3/4" in greatest dimension	* Insignificant
	Less than 1½" in greatest dimension	Minor
	1½" or more in greatest dimension or numerous (over 5) minor fragments (***) in one sample unit not seriously affecting product usability	Major
	One or more of a number or size seriously affecting product usability	Critical
Bone Slivers (from rib)	Less than 3" long and less than 1/4" wide and flexible bone chip from a rib end more than 3/4" in greatest dimension that is thin and crumbles easily and with or without attached muscle tissue	Minor

* No significance in product wholesomeness; do not score.

** Do not score as minor defects also.

<i>Type</i>	<i>Description</i>	<i>Class</i>
	Less than 1" long	* Insignificant
Detached Cartilage Ligaments	1" or more long and free of muscle tissue (see also bone slivers)	Minor
	Numerous (over 5) minor defects (**) in one sample unit not seriously affecting product usability	Major
	Defects of number seriously affecting product usability	Critical
	Minute specks of dust. If affecting product usability score them under "other". Pieces of plastic or paper warps or any soft material less than ½".	* Insignificant
	Paper or plastic wraps ½" to 7 square inches; a single piece covering an area equal to that of a circle 1/8" to ½" diameter; a wild oat or other grass beards over 3/8" long or 3 or more pieces of wild oats or grass beards 1" to 3/8" long on one piece of meat and without inflammation.	Minor
Extraneous Material	Blunt piece of wood 1" or more; paper or plastic over 7 square inches; a single piece of material covering an area greater than that of a circle with a diameter exceeding ½"; small insects without insanitation. Numerous (over 5) minor defects in a sample unit not seriously affecting product usability; any substance causing minor bodily irritation or discomfort (chemicals, hard objects, etc.)	Major
	Any substance causing injury or illness (poisonous or toxic chemicals, sharp pieces of metal, glass, hard plastic, etc.); large insects, associated with insanitation, or any material of number or size seriously affecting product usability.	Critical
Hide, Hair, Wool	Hide (with or without hair) or wool less than ½" in greatest dimension. A total of 5 to 10 single strands of hair or wool. Total number of hairs, divided by 10 and round off to nearest whole number to determine total hair defects. (e.g. 34 hairs=3 defects and 35 hairs=4 defects). When the second step is necessary, total number of hairs in step one and two, divide by 10 and round off as above. Cluster of hair (too numerous to count) in one area.	Minor
	Hide (with or without hair) or wool ½" or more in greatest dimension; numerous (over 25) single strands (**) of hair in one sample unit; numerous (over 5) clusters of hair in one sample unit, (**) provided that none of the above seriously affect product usability.	Major

* No significance in product wholesomeness; do not score.

** Do not score as minor defects also.

<i>Type</i>	<i>Description</i>	<i>Class</i>
	Hair Hide, or wool of amount seriously affecting product usability	Critical
Ingesta	Amount equal to area of circle ½" or less in diameter	Major
	Amount equal to an area of circle more than ½" in diameter	Critical
Off Condition		Critical
Parasitic Lesion	Parasites not transmissible to man. One, two, or three closely associated lesions on one piece of meat-score as one lesion (ovine only). First lesion found in sample.	Minor
	Each succeeding parasitic lesion in the sample.	Major
Pathological Lesions	Any lesion (not evident on post mortem inspection) not seriously affecting product acceptability	Major
	Any lesion unless excepted as noted above	Critical
Stains, discoloured areas	Very light stains of any size or stains covering an area of less than that of a circle of ½" in diameter	* Insignificant
	Equal to area of a circle of ½" to 1½" diameter	Minor
	Equal to area of a circle greater than 1½" diameter; numerous (over 5) minor stains (***) in one sample unit (12 lbs) not seriously affecting product usability	Major
	Minor and Major areas of a number seriously affecting product usability	Critical
Other	Defect that individually or in aggregate affects product appearance, but not its usability	Minor
	Defect that individually or in aggregate materially affects product usability	Major
	Defect that individually or in aggregate seriously affect product usability or appearance	Critical

* No significance in product wholesomeness; do not score.

** Do not score as minor defects also.

TABLE III
FOR USE IN CLASSIFICATION OF DEFECTS
FOUND IN BONELESS MEAT FROM SWINE

<i>Type</i>	<i>Description</i>	<i>Class</i>
Blood Clots	Less than 1½" in greatest dimension	* Insignificant
	1½" to 6" in greatest dimension	Minor
	More than 6" in greatest dimension or numerous (over 5) minor blot clots (***) in one sample unit not seriously affecting product usability	Major
	One or more of a number or size seriously affecting product usability	Critical
Bruises	Less than 1" in greatest dimension and less than ½" deep	* Insignificant
	1" to 2½" in greatest dimension or ½" to 1" deep	Minor
	More than 2½" in greatest dimension or more than 1" deep or numerous (over 5) minor bruises (***) in one sample unit not seriously affecting product usability	Major
	One or more of a number or size seriously affecting product usability	Critical
Bone fragments	(1) Thin bone scrapings less than 1/32" thick x 1/8" wide x 3" long attached to muscle tissue. (2) Thin flexible bone slivers, either attached to or detached from muscle tissue less than 1/4" wide and 3/4" long. (3) Thin bone fragments or chips either attached to or detached from muscle tissue that crumble easily and are less than 3/4" in greatest dimension	* Insignificant
	Less than 1½" in greatest dimension	Minor
	1½" or more in greatest dimension, or numerous (over 5) minor fragments (***) in one sample unit not seriously affecting product usability	Major
	One or more of a number or size seriously affecting product usability	Critical
Bone Slivers (from rib)	Less than 3" long and less than 1/4" wide and flexible bone chip from a rib end more than 3/4" in greatest dimension that is thin and crumbles easily, and with or without attached muscle tissue	Minor

* No significance in product wholesomeness; do not score.

** Do not score as minor defects also.

<i>Type</i>	<i>Description</i>	<i>Class</i>
	Less than 1" long	* Insignificant
Detached Cartilage Ligaments	1" or more long and free of Muscle tissues (see also bone slivers)	Minor
	Numerous (over 5) minor defects (**) in one sample unit not seriously affecting product usability	Major
	Defects of number seriously affecting product usability	Critical
	Minute specks of dust. If affecting product usability score them under "other". Pieces of plastic or paper wraps or any soft material less than ½".	* Insignificant
	Paper or plastic wraps ½" to 7 square inches; a single piece covering an area equal to that of a circle 1/8" to ½" diameter; a wild oat or other grass beard over 3/8" long or 3 or more pieces of wild oat or grass beards 1/8" to 3/8" long on one piece of meat and without inflammation.	Minor
Extraneous Material	Blunt piece of wood 1" or more long; paper or plastic over 7 square inches; a single piece of material covering an area greater than that of a circle with a diameter exceeding ½"; small insects without insanitation. Numerous (over 5) minor defects in a sample unit not seriously affecting product usability; any substance causing minor bodily irritation or discomfort (chemicals, hard objects, etc.)	Major
	Any substance causing injury or illness (Poisonous or toxic chemicals, sharp pieces of metal, glass, hard plastic etc.); large insects; insects associated with insanitation, or any material of number or size seriously affecting product usability.	Critical
Skin, Hair, Hair Roots	Skin (with or without hair or visible hair roots) individually or in aggregate less than 1 square inch.	* Insignificant
	Skin (with or without hair or visible hair roots) individually or in aggregate 1 sq. in. to 3 sq. ins. A total of 2 or 3 single strands of hair or 5 to 10 visible hair roots. Total number of hairs or hair roots in sample:- divide by 3 hairs or 10 for visible hair roots and round off to nearest whole number. For example, 10 hairs - 3 defects; 38 hair roots - 4 defects.	Minor

* No significance in product wholesomeness; do not score.

** Do not score as minor defects also.

<i>Type</i>	<i>Description</i>	<i>Class</i>
	Skin (with or without hair visible hair roots) individually or in aggregate over 3 sq. ins.; Numerous (over 10) single strands (**) of hair in one sample unit provided none of the above seriously affect product usability.	Major
	Hair, skin or visible hair roots seriously affecting product usability.	Critical
Ingesta	Amount equal to an area of circle ½" or less in diameter	Major
	Amount equal to area of a circle more than ½" in diameter.	Critical
Off Condition		Critical
Lips, Ear, canals, teeth, kidney, liver	Any sample unit containing tooth or teeth. Ear canal(s) lip with or without teeth marks, piece(s) of kidney or liver.	Major
Pathological lesions	Any lesion (not evident on post mortem inspection) not seriously affecting product acceptability	Major
	Any lesion unless excepted as noted above	Critical
Stains, discoloured areas	Very light stains of any size or stains covering an area of less than that of a circle of ½" in diameter	* Insignificant
	Equal to area of a circle of ½" to 1½" in diameter	Minor
	Equal to area of a circle greater than 1½" in diameter; numerous (over 5) minor stains (**) in one sample unit (12 lbs) not seriously affecting product usability	Major
	Minor and major areas if a number seriously affecting product usability	Critical
Lung Tissue	Any amount	Critical
Other	Defects that individually or in aggregate affect product appearance, but not its usability	Minor
	Defects that individually or in aggregate materially affect product usability	Major
	Defects that individually or in aggregate seriously affect product usability or appearance	Critical

* No significance in product wholesomeness; do not score.

** Do not score as minor defects also.