

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Presence of Non-food Animals	05-A-01
REGULATORY REFERENCE <i>AR 42/2003 Meat Inspection Regulation</i> (Consolidated to 112/2009) Section 25	Initial Release Sept 1, 2009
	Page 1 of 1
RATIONALE <p>The operator of a “Licensed Meat Facility” (facility) has a responsibility to ensure that meat is processed in an environment free from any biological, chemical or physical sources of contamination.</p> <p>All animals are potential carriers of infectious agents that could be serious food safety hazards from the direct, or indirect, contamination of meat, or meat products. A good example is toxoplasmosis (a parasite of dogs and cats which has the potential to cause disease in humans).</p> <p>Note: Direct contamination occurs when an animal comes into direct contact with meat, or meat products. Indirect contamination occurs when clothing, or equipment, contaminated with animal secretions, or excretions (e.g. saliva, feces, urine, etc.), comes into contact with meat, or meat products.</p> <p>Allowing any animals, other than those presented for slaughter, to be present in the facility creates a major food safety hazard.</p> <p>Having animals around the premises, particularly pets could increase the chances that facility personnel could cause indirect contamination of meat and meat products from soiling of their shoes and clothing.</p> <p>Quite simply, prohibiting the presence of all animals, other than those being slaughtered, results in an environment that is more conducive to food safety.</p>	
OBJECTIVE/OUTCOME <p>Only animals that are going to be slaughtered will be allowed to be in a facility.</p> <p>Note: Guard dogs and personal service dogs are exceptions to the above providing their presence is conducted in accordance with TIPM document 05-A-02.</p> <p>This prohibition also applies to the animal holding area of an abattoir.</p> <p>Note: Dogs cannot be used to help move animals into slaughtering facilities.</p>	
RELATED SECTIONS OF TIPM 05-A-02 Guard or Service Dogs	

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Guard or Service Dogs	05-A-02
REGULATORY REFERENCE <i>AR 42/2003 Meat Inspection Regulation</i> (Consolidated to AR 112/2009) Section 25	Initial Release Sept 1, 2009 Page 1 of 1
RATIONALE <p>Normally all animals, other than those being offered for slaughter, are prohibited from being in, or on, the premises of a "Licensed Meat Facility" (facility) because they are potential carriers of infectious agents that could lead to serious food safety risks from the direct, or indirect, contamination of meat, or meat products. A good example is toxoplasmosis (a parasite of dogs and cats which has the potential to cause disease in humans).</p> <p>Note: Direct contamination occurs when an animal comes into direct contact with meat, or meat products. Indirect contamination occurs when clothing, or equipment, contaminated with animal secretions, or excretions (e.g. saliva, feces, urine, etc.), comes into contact with meat, or meat products.</p> <p>Notwithstanding the inherent risks, allowances can be made for the presence of guard dogs and/or personal service dogs providing steps are taken to mitigate the risks.</p> <p>Allowing the use of guard dogs and/or personal service dogs does not absolve the operator of the facility from their responsibility to ensure that meat is processed in an environment free from any biological, chemical or physical sources of contamination.</p>	
OBJECTIVE/OUTCOME <p>A guard dog will be allowed to be in the facility providing:</p> <ol style="list-style-type: none">1. It is not permitted to enter any of the buildings or any other areas that contain food animals, or where carcasses, parts of carcasses, meat products, or ingredients, are processed, packaged, labeled, handled or stored.2. The animal is appropriately restrained so it does not pose a safety risk to MIB Inspectors nor impedes them from performing their duties.3. The animal's health status does not pose a risk to any food animals, or meat products, in the facility. <p>Service dogs that are specially trained to provide assistance to individuals with medical disabilities (e.g. a seeing-eye dog) may be allowed access to all parts of the facility providing they are not allowed to come into direct contact with any meat, or meat products.</p> <p>Note: Facility personnel that need to use a service dog must:</p> <ol style="list-style-type: none">a) avoid contacting meat, or meat products, while they are handling the animal;b) remove their smocks, or coveralls, before handling the animal;c) wash and sanitize their hands before handling any meat, or meat products, after they have handled the animal	
RELATED SECTIONS OF TIPM 05-A-01 Presence of Non-food Animals	

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Records of Shipment	05-A-03
REGULATORY REFERENCES <i>AR 42/2003 Meat Inspection Regulation</i> (Consolidated to 112/2009) Section 30 <i>AR 208/2008 Livestock Identification and Commerce General Regulation</i> Section 25	Initial Release Sept 1, 2009
Page 1 of 2	
RATIONALE Section 30 subsections 1 to 4 of AR 42/2003 cover the records that the operator of a “Licensed Provincial Abattoir” (abattoir) is required to keep. Note: Accurate and complete records are valuable aids for: a) monitoring the control of processing steps; b) providing information in the event of a product recall This document outlines the information, pertaining to the animals that are delivered for slaughter to a provincially licensed abattoir, which must be collected and retained. For inspection purposes and in the event of a recall complete records of animals delivered for slaughter must be kept. Note: Such records should provide: a) name and address of the person(s) from whom the animals were purchased, or acquired; b) date of purchase or acquisition; c) number and kind of animals; d) number of animals that were slaughtered; e) date of slaughter In addition to the above, for poultry (with the exception of ratites and birds for custom slaughter), flock information identifying the health history, growing conditions and transport of the birds is required. Note: This information will assist Meat Inspection Branch (MIB) Inspectors in making accurate post-mortem dispositions. This information is also essential for tracing reportable diseases, which will help maintain the overall safety of the poultry industry.	
OBJECTIVE/OUTCOME The following information will be collected and retained for all live animals, <u>originating in the Province of Alberta</u> , that are submitted to a provincially licensed abattoir: 1. Names and addresses of persons, or corporations, from whom the animals were purchased, or otherwise acquired. 2. Date of delivery to the abattoir. 3. Number and kind (type) of animal(s) delivered. 4. Number and kind (type) of animal(s) slaughtered. 5. Date of slaughter. 6. Enough information on each animal to make it possible for an inspector to trace it to its farm of origin.	

TIPM – 05-A-03 Page 2 of 2 – OBJECTIVE/OUTCOME (continued)

Note: CCIA (Canadian Cattle Identification Agency) tag numbers must be recorded for cattle and bison. These tags will allow the determination of the animal's farm of origin. The abattoir operator also has an obligation, in accordance with section 186(1) (b) of the *Health of Animals Regulation (Canada)* to report the CCIA tag numbers of slaughtered animals to the agency.

Since January 1, 2004 it has been compulsory for a CSIP (Canadian Sheep Identification Program) tag to be placed in all sheep and lambs before they leave their farm of origin. MIB Inspectors report information on untagged animals to the Canadian Food Inspection Agency and the Alberta Sheep and Wool Commission in accordance with Regulatory Services Division (RSD) - Meat Inspection Directive MI - 22.

7. Such other information as the Director of the RSD may require.

Note: The above records must be kept for a minimum of ten (10) years.

For **animals originating from outside of the Province of Alberta** the following **additional information is required.**

1. Gross weight of the livestock.
2. Number of square meters, or square feet, of floor space in the transport vehicle.
3. Time, date and location where the livestock:
 - a) came under the custody of the carrier;
 - b) were fed, watered and rested while in the custody of the carrier;
 - c) were unloaded at their destination
4. Date and location where the transport vehicle was last cleaned and disinfected.

Note: The inter-provincial transportation of livestock is most likely going to occur at abattoirs that are close to a provincial border.

The abattoir operator will comply with all of the requirements for livestock manifests in accordance with AR 208/2008 *Livestock Identification and Commerce General Regulation*.

Note: For details on livestock manifests the reader is referred to TIPM document 04-A-02 *Livestock Documentation (Manifests)*.

Upon the request of a MIB Inspector, or other authorized individual, the abattoir operator will provide the above records for inspection.

Note: The MIB Inspector also has the authority to remove records for photocopying should that be necessary.

REQUIREMENTS FOR AN AUDITABLE SYSTEM (MFS)

Requirements for **Records of Shipment** will be met when:

1. Livestock manifests are retained for a period of 10 years.

Note: Manifests, when properly completed will contain all of the pertinent information that is required.

2. Poultry flock health records are retained for a period of 2 years.

RELATED SECTIONS OF TIPM

03-F-03 Batch & Distribution Records

04-A-02 Livestock Documentation (Manifests)

04-A-03 Poultry Flock Health - Documentation of

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Livestock Yards & Holding Pens	05-A-04
REGULATORY REFERENCES <u>AR 42/2003 Meat Inspection Regulation</u> (Consolidated to 112/2009) Sections 15.1, 18(b)(iii), 21(2), 21(3) & 26 <u>AR 203/2005 Animal Protection Regulation</u> Section 12(1)	Initial Release Sept 1, 2009
	Page 1 of 4
RATIONALE <p>Food animals are sentient beings. This means that they are capable of suffering discomfort, fear and pain.</p> <p>Exposure to strange environments frightens them and makes them more difficult to handle.</p> <p>Like people, animals react positively or negatively to sights and sounds in their environment.</p> <p>Notwithstanding our inherent moral obligation to handle animals in a human manner section 21(1) of AR 42/2003 states, "A person shall minimize pain and distress of any animal that is being prepared for slaughter or slaughtered".</p> <p>Note: Animal handling, or holding facilities, in a "Licensed Meat Facility" (abattoir) should be constructed in a manner that takes into account an animal's likes and dislikes. Having an animal friendly environment makes it much easier to handle them and minimizes their chance of injury and possible damage to the carcass from rough handling.</p> <p>Properly designed and maintained facilities also have the advantage of making the task of moving animals quieter, less stressful, more humane and least laborious.</p> <p>Note: Animals generally fear darkness, dead ends, sharp turns, shadows, flashing bright lights, high frequency noises and even unusual odors. Conversely, they move effortlessly when moved in single file and through chutes with solid sides and open ends so that they can see through them and see and follow the lead animals. Proper construction will alleviate many animal handling problems.</p> <p>Sections 21(2) & 21(3) of AR 42/2003 specify that animals must be provided with immediate shelter and access to feed, water and bedding if held for more than 24 hours.</p> <p>Overcrowding and exposure to other species causes stress thus there is a need to provide separation of the species and adequate space for the number of animals being handled at any one time.</p> <p>In addition to meeting the moral obligations of handling animals in a humane manner, properly designed and maintained facilities reduce the chances of contamination into the slaughter facility, from dirty animals and reduce the chances that rough handling may affect meat quality from bruising and other injuries.</p> <p>Frequent cleanup of the holding area limits the risk of transfer of diseases from animal to animal and adds to the comfort of livestock during a stressful time of being placed in a new environment.</p>	

OBJECTIVE/OUTCOME

Animal handling facilities and/or equipment will:

1. Be constructed in a manner that minimizes the chance of injury while food animals are handled in any manner.

Note: Section 12(1) of AR 203/2005 states, “**No person shall load, or unload, livestock in a manner that is likely to cause injury or undue suffering to it.**”

2. Meet the following requirements.

Unloading docks of different heights will be available, or the ramps will be adjustable.

Note: This is necessary for the safe unloading of animals from vehicles of varying heights.

Unloading docks will be constructed in a manner that eliminates gaps between the vehicle and the dock.

The following are considered to be “Common Industry Practice”:

- a) a level area on the dock before the ramp;
- b) a maximum slope of 20^o to 25^o for pigs;
- c) a maximum of 45^o for other species;
- d) stair step dimensions for cattle of a 3 ½ inch (9-10cm) rise and a 12-inch (30cm) long tread. If space permits, an 18-inch (cm) long tread will create a more gradual ramp;
- e) stair step dimensions for pigs of a 2 ½ inch (6.35cm) rise and a 10-inch (25cm) tread. On adjustable ramps, cleats with 8 inches (20cm) of space between them are recommended. Ramps for small piglets require cleat spacing of 3 inches (8cm);
- f) sides of sufficient strength and height to minimize the chance of injury to animals and there must not be any gaps between the vehicle and the loading dock.

There will be appropriate facilities for the handling of compromised (e.g. crippled) animals.

Floors in holding pens, alleyways and chutes will be:

1. Well sloped for proper drainage;

Note: Drainage can be accomplished through individual water runs out of each pen or via valley-type drains located in the alleyway.

2. Scored, or otherwise treated, if made of concrete, to provide a non-slip surface.

Note: It is “Common Industry Practice” to have concrete floors.

3. Constructed of materials that enable easy cleaning and sanitation.

Note: The use of smooth impervious materials, for construction, will greatly facilitate the ease of cleaning and sanitizing.

The walls and gates of holding pens and alleyways will be constructed of smooth, impervious material.

TIPM – 05-A-04 Page 3 of 4 - OBJECTIVE/OUTCOME (continued)

Note: Rust resistant metal pipe or tubing with a diameter greater than 8 cm (3 inches) is the preferred material.

It is recommended that any wooden walls and gates be painted, or whitewashed, regularly.

Sliding and one-way gates, in alleyways and loading chutes, will be constructed so that animals can see through them.

Note: This makes animals more willing to move forward and reduces their feeling of being trapped.

Hinges and dividers should be constructed and maintained so that they move smoothly without any squeaks or high-pitched noises.

Note: Squeaks and high pitch noises causes stress and fear in animals thus making them more difficult to handle.

All pens and alleyways will be well lit and spacious, with gates and dividers that allow animals to see through.

Note: This type of construction will greatly aid in the movement of livestock as they will have a greater desire to move in and out of the pens voluntarily.

Animal holding facilities will be properly ventilated.

Note: Sufficient ventilation will prevent the development of strong odors and condensation. Poor ventilation is stressful for the animals. Ventilation is particularly important for poultry, rabbits and any other animals that are confined in crates.

A sufficient number of pens should be covered by a roof.

Note: It is not mandatory for all livestock pens to be covered but a sufficient number of covered pens must be provided to afford protection to those animals, or classes of livestock, that normally require shelter.

There will be sufficient pen capacity to comfortably accommodate the peak number of animals that are anticipated on any given day.

Note: Sufficient capacity is defined as having enough space to allow all the livestock to lie down at the same time.

The capacity of each livestock pen should be indicated on the facility's site plan.

It is recommended that pens be kept no more than 75% full.

There must also be a sufficient number of pens to allow the separation of species and the separation, or isolation, of animals that may cause harm to other animals (e. g. bulls, boars, cows with large horns, aggressive animals, etc.).

Animal holding areas will be sufficiently separated from the stunning and bleeding area.

Note: This is a requirement to prevent the entrance of dust, odors, or other forms of contamination, to the kill floor.

All animal handling facilities must be properly maintained.

Note: Well maintained facilities will be free of any protruding nails, bolts, sharp corners or anything else that may contribute to the injury or discomfort of animals.

TIPM – 05-A-04 Page 4 of 4 - OBJECTIVE/OUTCOME (continued)

All animal holding facilities will be cleaned and sanitized regularly and as required.

Note: To ensure frequent and thorough cleaning there should be written sanitation protocols for livestock handling facilities as part of the abattoir's "**Sanitation Schedule**".

Yards, driveways, etc., which have been used to hold or move suspect or condemned animals prior to slaughter will be cleaned in accordance with the written sanitation protocols.

Properly drained and protected concrete, or metal, bins will be available for the storage of manure pending final removal for disposal.

Note: Such facilities must be built & maintained in accordance with local ordinances.

Livestock will have access to clean drinking water within a reasonable length of time.

Note: It is "Common Industry Practice" to make water available in all holding pens. Cold weather conditions may require heaters to prevent freezing.

Animals held longer than 24 hours will have adequate amounts of food, water and bedding.

Note: This is absolutely essential without exception and while 24 hours meets basic legislated requirements animals should have access to water much earlier than this particularly when the weather is hot.

Sufficient bedding, in the form of straw or other litter, must be provided.

Note: Sufficient bedding is defined as enough to prevent the hide of animals from becoming wet, or soiled with manure.

REQUIREMENTS FOR AN AUDITABLE SYSTEM (MFS)

Requirements for "**Livestock Yards & Holding Pens**" will be met when:

1. The "**Sanitation Schedule**" includes livestock pens.
2. The maintenance of the "**Livestock Yards & Pens**" is monitored and recorded.

Note: Information can be recorded in "**Preventative Maintenance Records**" or in the "**External Inspection Records**".

RELATED SECTIONS OF TIPM

03-A-03 External Premises Inspection

03-C-04 Preventative Maintenance Procedures - Records of

03-E-04 Sanitation Schedule

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Stunning & Bleeding Area	05-A-05
REGULATORY REFERENCES <u>AR 42/2003 Meat Inspection Regulation</u> (Consolidated to 112/2009) Sections 8, 18(a)(i), 21(1), 22 & 22.1	Initial Release Sept 1, 2009
	Page 1 of 3
RATIONALE Adequate restraint is essential for the humane stunning of animals in a “Licensed Meat Facility” (abattoir). Note: Poultry and rabbits can be readily restrained by hand thus elaborate restraint equipment is not essential for these species. In addition to a moral obligation of preventing the infliction of unnecessary animal suffering there are also a number of regulations that require humane slaughter. The headings in the Objectives/Outcome section of this document address the following: <ol style="list-style-type: none">1. Permission for alternative methods of slaughter on religious grounds – Section 82. Construction of ramps, alleys, etc. – Section 18(a)(i)3. Prohibition on inflicting unnecessary pain – Section 21(1)4. Ensure rapid & permanent unconsciousness - Sections 21(2)(a) & (b)5. Need to maintain stunning equipment – Section 226. Permissible methods of stunning – Sections 22.1(2)(c)	
OBJECTIVE/OUTCOME All animals will be stunned in a manner that is safe for abattoir personnel and humane for the animal. The conditions listed in the following sections will be met. <u>Knocking (Stunning) Box and Stunning Equipment</u> Chutes and knocking (stunning) boxes will: <ol style="list-style-type: none">1. Have slip proof footing.2. Be narrow enough to prevent an animal from turning around. Note: The knocking box should be designed so that it is appropriate for the species and size of animal being stunned. It must be able to confine an animal without discomfort while preventing excessive movement of the animal forwards, backwards, or sideways.3. Have sufficient slope on the floor to automatically eject the stunned animal onto the landing (shackling) area. Only one animal at a time will be put into the knocking box. Note: This will reduce the stress on the animals and will reduce the chance of carcass damage from bruising.	

TIPM – 05-A-05 Page 2 of 3 – **OBJECTIVE/OUTCOME** (continued)

The following conditions will be met for stunning and stunning equipment:

1. The person doing the stunning must be knowledgeable about proper stunning techniques and physically capable of performing the job without inflicting unnecessary pain on the animal.
2. Only stunning methods that are specifically allowed under section 22.1(2)(c) of AR 42/2003, will be used.

Note: A blow to the head with a mechanical penetrating device (captive bolt), carbon dioxide gas, electrocution or shooting with a rifle are the stunning methods specifically allowed under section 22.1(2)(c) of AR 42/2003.

3. All stunning equipment will be properly maintained so that it is fully functional.

Note: Poor maintenance, of stunning equipment, is a major cause of improper stunning.

It is recommended that the entire knocking box, except for the opening that allows the stunned animal to be expelled, be located outside of the kill floor.

Note: This recommendation is to provide increased safety for abattoir and inspectional personnel. There is a much greater chance of personnel injury from a ricochet when the knocking box is located on the kill floor.

Landing Area

Landing areas will be:

1. Located to the side or front of the knocking box;
2. Dry;
3. Separately drained;
4. A sufficient distance from the bleeding area;

Note: There should be enough separation of the landing and bleeding areas to minimize the chance of getting blood from a bled animal on a recently stunned animal.

5. Secure enough to prevent the escape of improperly stunned animals

Bleeding Area

The bleeding area will be:

1. Curbed;
2. Steeply graded to the blood and wash-up drains;
3. Have drains of sufficient size to prevent blockage due to clotting;

Note: Minimum requirements are a 6" (150 mm) diameter drain and a slope of 17⁰, toward a discharge point in the inedible section of the abattoir.

4. Equipped with hand and equipment washing facilities.

If animals are conveyed, by means of a moving chain, prior to, during and after bleeding, the rail must be long enough to ensure that all animals have bled to death prior to entering the scalding tank.

Ritual or Religious Slaughter

In accordance with section 8 of AR 42/2003 ritual, or religious, slaughter will only be allowed with the written consent of the Director of the RSD.

Note: The Director will only approve alternative methods of slaughter if there are assurances that the physical facilities and skill of the individuals performing the slaughter are such that the animal will be rendered unconscious, in a timely fashion, to the satisfaction of the resident MIB Inspector.

Directives MI – 18 and MI – 33 in the RSD Manual of Directives and Procedures apply to the conduct of alternative slaughter methods. Facilities and equipment used must provide for complete immobilization of the animal prior to bleeding.

REQUIREMENTS FOR AN AUDITABLE SYSTEM (MFS)

Requirements for the “**Stunning & Bleeding Area**” will be met when:

1. The “**Stunning & Bleeding Area**” is included in the “**Preventative Maintenance Procedures**” and/or the “**Internal Inspection Procedures**” of the abattoir.
2. Issues and corrective actions relating to the “**Stunning & Bleeding Area**” are recorded in the “**Preventative Maintenance Records**” or “**Internal Inspection Records**” of the abattoir.
3. On site observations demonstrate that the “**Stunning & Bleeding**” area is properly constructed, maintained, cleaned and sanitized.
4. Ritual, or religious, slaughters, if applicable, are done in a manner that is satisfactory to the MIB Inspector.

RELATED SECTIONS OF TIPM

03-A-02 Internal Premises Inspection

03-C-04 Preventative Maintenance Procedures - Records of

05-B-06 Stunning & Bleeding Practices

07-A-03 Ritual Slaughter

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Segregation of Animals	05-A-06
REGULATORY REFERENCES <i>AR 42/2003 Meat Inspection Regulation</i> (Consolidated to 112/2009) Sections 18(1)(h), 21(1) & 26(a) <i>AR 203/2005 Animal Protection Regulation</i> Sections 10 to 15 inclusive	Initial Release Sept 1, 2009
	Page 1 of 2
RATIONALE Section 18(1)(h) of AR 42/2003 requires an abattoir to have facilities that allow the safe and humane handling of all species of animals that are brought to the abattoir. Section 26(a) requires the abattoir operator to ensure that pens are not overcrowded. Note: The appropriateness of the facilities and having sufficient space are both important for ensuring that undue pain, or discomfort, is not inflicted on animals in accordance with section 21(1) of AR 42/2003. In addition to the legislated requirements of ensuring that animals are not subjected to stress and/or injury, from other animals, the abattoir operator also has an ethical, or moral, responsibility to handle animals in a humane way. Stress from fear, and possible injury are likely to occur unless precautions are taken to protect weak, or vulnerable, animals from other animals in their immediate surroundings. Note: Young animals and those suffering from previous injuries and/or disease conditions are at the highest risk. They should be kept separate from animals that are likely to cause them harm. Animals most likely to cause injury to the young, weak or vulnerable include: <ol style="list-style-type: none">1. Adults;2. Mature and intact (un- castrated) males;3. Aggressive animals Note: Fear from recent transportation, handling, strange surroundings and mixing with unfamiliar animals may lead to aggressive behavior in animals that normally aren't aggressive. Mixing animals of different species will often create hazards for the smaller or less aggressive species.	

OBJECTIVE/OUTCOME

Transportation of Animals to the Abattoir

All animals must be properly segregated in accordance with Section 15 of AR 203/2005.

Note: This section requires segregation of the following types of animals during transportation:

- a) livestock of different species;
- b) groups of mature bulls, de-tusked boars, rams and goat bucks;
- c) cows, and sows with suckling offspring;
- d) livestock of the same species but of substantially different weight, or age

Boars with tusks must be separated from all animals including other boars.

Abattoir operators have a responsibility to advise vehicle operators about any contraventions of AR 203/2005 that are observed. The vehicle should also be advised that such infractions could be reported to the authorities.

Note: Directive MI – 40 Compromised Animals, in the Regulatory Services Division Manual of Directives and Procedures, requires Meat Inspection Branch (MIB) Inspectors to report any contraventions of AR 203/2005 to their Regional Supervisor and/or Area Manager who in turn will decide whether the issue is serious enough to investigate further and possibly report to the S.P.C.A.

Care of Animals at the Abattoir

The abattoir operator will ensure that the same separation required during transportation is maintained in the pens at the abattoir.

Note: If an animal becomes aggressive after it has been delivered to the abattoir there is a responsibility to immediately segregate that animal from all others.

Any animal that appears to be ill, or injured, will be immediately segregated from other healthy animals.

RELATED SECTIONS OF TIPM

05-A-04 Livestock Yards & Holding Pens

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Animal Transport Vehicles - Design & Maintenance	05-B-01
REGULATORY REFERENCES <u>AR 203/2005 Animal Protection Regulation</u> Sections 13 & 14	Initial Release Sept 1, 2009 Page 1 of 2
RATIONALE <p>While not directly responsible for the condition of vehicles used to transport animals to the operator of a “Licensed Meat Facility” (abattoir) often has to deal with animals that have been stressed, injured or otherwise compromised during transportation.</p> <p>The intent of this document is to make abattoir operators aware of the requirements of AR 203/2005 relating to transportation vehicles, or containers.</p> <p>Abattoir operators have a responsibility to advise the operators of transportation vehicles about any contraventions to AR 203/2005 that are observed.</p> <p>Note: MI – 40, the Meat Inspection Branch Directive on Compromised Animals, requires Meat Inspection Branch (MIB) Inspectors to report any contraventions to their Regional Supervisor and/or Area Manager who in turn will decide whether the issue is serious enough to investigate further and possibly report to the S.P.C.A or other authorities.</p>	
OBJECTIVE/OUTCOME <p>All animals will be transported in a vehicle, or container, that is suitably designed and maintained to ensure that the use of that vehicle, or container, does not cause injury, or sickness, in animals being transported.</p> <p>Note: A vehicle is defined as any means of conveyance used for the transportation of animals. A container is defined as a box, or a crate, used for the shipment of animals.</p> <p>Vehicles, or containers, will be constructed to ensure that:</p> <ol style="list-style-type: none">1. Exhaust fumes will not be able to enter the animal compartment.2. The front and sides of the box will be of sufficient height. <p>Note: Sufficient height is defined as being high enough to protect animals from adverse environmental conditions (e.g. wind) and high enough to prevent animals from jumping out, being pushed out, or falling out.</p><p>If the vehicle has a roof it must be high enough for animals to stand, in a natural position, without contacting the roof.</p>3. The flooring is slip-proof. <p>Note: The floor may be constructed with slip-proof material (e.g. checkered steel plating) or evenly covered with straw, dry sand, or other suitable material.</p>4. Animals will be protected, from exposure to severe weather conditions, during transit.	

TIPM – 05-B-01 Page 2 of 2 – OBJECTIVE/OUTCOME (continued)

5. Air flow (ventilation) is sufficient to prevent suffocation and/or the development of heat stroke.

Note: Proper ventilation is of particular importance when the weather is hot.

All vehicles will be maintained in a sanitary condition.

Note: Vehicles should be cleaned and sanitized before loading to:

- a) prevent the spread of disease from prior inhabitants;
- b) reduce the risk of carcass contamination from the entry of dirty animals into the abattoir

Vehicles will be maintained in a manner that minimizes any risk of injury to animals being transported.

Note: **Items** identified, in AR 203/2005, as unacceptable include:

- a) fittings that are not secure or are inadequately padded, fenced off or obstructed;
- b) bolt heads, or other, objects projecting into animal holding areas;
- c) broken, cracked or damaged siding or flooring material;
- d) inadequate ventilation;
- e) unsafe footholds, or footholds that are not secure;
- f) any other equipment in a condition likely to cause injury, or undue suffering, to the animals being transported

The abattoir operator will advise the operators of transport vehicles about any contraventions of AR 203/2005 that are observed.

RELATED SECTIONS OF TIPM

05-A-06 Segregation of Animals

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Delivery & Prompt Unloading	05-B-02
REGULATORY REFERENCES <u>AR 42/2003 Meat Inspection Regulation</u> (Consolidated to 112/2009) Sections 21(1) & (2) <u>AR 203/2005 Animal Protection Regulation</u> Sections 10, 12(1) & 12(3)	Initial Release Sept 1, 2009 Page 1 of 2
RATIONALE <p>In addition to the ethical and moral requirement to handle animals in a manner that will not cause any undue suffering there is also a legislated requirement to do so under section 21(1) of AR 42/2003.</p> <p>Section 21(2) of AR 42/2003 also requires the operator of a “Licensed Meat Facility (abattoir) to ensure that animals arriving at the abattoir to be provided with immediate shelter.</p> <p>Note: This means that animals must be unloaded from their transportation vehicle as soon as possible after arrival at the abattoir.</p> <p>Because abattoirs handle different species of animals, of variable ages and weights and because these animals come in different types of vehicles, facilities need to be suitably designed and maintained in a manner that allows all types of animals to be unloaded in a safe and humane manner. (See TIPM document 05-A-05 Livestock Yards & Holding Pens for details on facility requirements.)</p> <p>Implementation of the measures outlined in this document will minimize the stress on animals during their transfer to a new environment.</p> <p>Abattoir operators have a responsibility to advise the operators of transportation vehicles about any contraventions to AR 203/2005 that are observed.</p> <p>Note: MI – 40, the Meat Inspection Branch Directive on Compromised Animals, requires Meat Inspection Branch (MIB) Inspectors to report any contraventions to their Regional Supervisor and/or Area Manager who in turn will decide whether the issue is serious enough to investigate further and possibly report to the S.P.C.A or other authorities.</p>	
OBJECTIVE/OUTCOME <p>Animals will be unloaded as soon as possible after their arrival at the abattoir.</p> <p>Note: To prevent unnecessary delays livestock producers and/or truckers should consult with the abattoir operator to schedule deliveries.</p>	

TIPM – 05-B-02 Page 2 of 2 – OBJECTIVE/OUTCOME (continued)

Unloading will be done in a humane manner.

Note: Unloading facilities must be designed and maintained in a manner that will minimize the chance of injury during unloading.

Beating animals in any manner, during unloading, in a manner likely to cause injury, **will not be tolerated**.

Animals with injuries (e.g. lameness, etc.) must be handled with extra care, including more time to unload, in order to prevent further injury.

Note: Providing livestock producers and truckers comply with sections 10(1) of AR 203/2005 *Animal Protection Regulation*, which makes it illegal to transport animals which by reason of infirmity, illness, injury, fatigue or any other cause may suffer unduly, abattoirs should not have to deal with compromised animals other than those that may have been injured during transport.

Injured animals must be segregated in pens if necessary to prevent further injury.

RELATED SECTIONS OF TIPM

05-A-04 Livestock Yards & Holding Pens

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Handling of Live Animals in the Abattoir	05-B-03
REGULATORY REFERENCE <u>AR 42/2003 Meat Inspection Regulation</u> (Consolidated to 112/2009) Section 21(1) <u>AR 203/2005 Animal Protection Regulation</u> Sections 12(1) & 12(3)	Initial Release Sept 1, 2009
	Page 1 of 3

RATIONALE

Section 21(1) of AR 42/2003 *Meat Inspection Regulation* requires animals to be handled in a manner that will not cause any undue suffering. In addition to this legal requirement there is also a moral and ethical requirement to handle animals in a humane manner.

Note: In addition to this section abusive handling of animals is also prohibited by sections 12(1) & 12(3) of AR 203/2005.

Mishandling of animals, at a “Licensed Meat Facility” (abattoir) may be intentional or unintentional. **Intentional abuse** simply **must not be tolerated**.

Note: Training of abattoir personnel should eliminate un-intentional abuse providing the training provides sufficient knowledge about animal behaviour patterns so that they can be moved with a minimum of frustration both to the animal and abattoir personnel.

Mishandling of animals can also affect the quality of the product being produced at the abattoir. For example, animals that have been stressed, from improper handling, may not bleed out properly thus leading to the production of an inferior meat product (e.g. “Pale Soft Exudative” [PSE] pork).

The purpose of this document is to provide some basic information on animal behaviour.

Note: More **detailed information** on **animal welfare** and handling procedures **can be found at:**

<http://www.grandin.com/index.html>

OBJECTIVE/OUTCOME

Live animals will be handled in a humane manner.

Note: Meat Inspection Branch (MIB) Inspectors **are authorized to deal with animal welfare issues** related to the infliction of unnecessary pain, or discomfort on animals being moved to slaughter. In the case of excessively rough, or abusive, handling they have the authority to immediately suspend the kill until the contravention has been corrected. They will also record the details of these contraventions and actions taken and report them to appropriate authorities such as the S.P.C.A. as necessary.

Abattoir personnel will take the natural behaviour patterns of animals into consideration while handling them.

TIPM – 05-B-03 Page 2 of 3 – OBJECTIVE/OUTCOME (continued)

Note: Animal behaviour depends on several factors including:

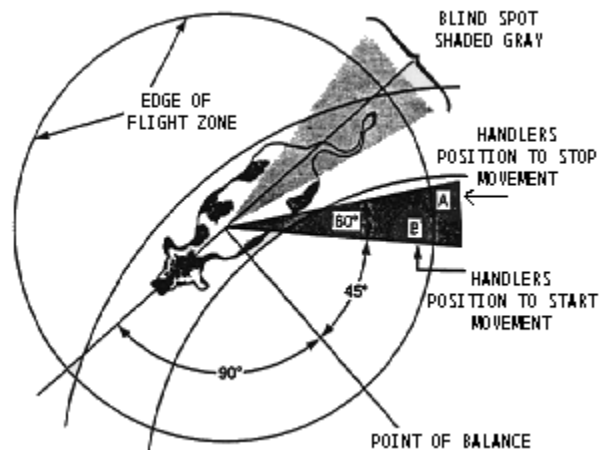
- a) natural instincts (inherited traits and characteristics of the species);
- b) individual differences;
- c) previous experiences

Appropriate lighting (e.g. a spotlight directed onto a ramp or other apparatus) will be used to encourage animal movement in the desired direction.

Note: This takes advantage of the natural tendency for pigs, sheep, and cattle to move from a dimly illuminated area to a more brightly illuminated area, provided they are not subjected to a glare.

Abattoir personnel will be knowledgeable about and take advantage of the animal's natural flight zone when attempting to make them move forward.

Note: The following diagram, of the flight zone for cattle, shows the best location for a handler to approach the animal from.



To make the animal move forward, the handler should stand in the black shaded area either to the right or left side of the animal.

The edge of an animal's flight zone can be determined by slowly walking up to the animal and observing how it responds.

In the above diagram the circle represents the edge of the flight zone.

Abattoir personnel will be calm and patient when moving animals.

Note: More can be accomplished by giving animals time to understand what is expected of them rather than a whole lot of shouting.

Impatience is one of the main causes of inhumane treatment of food animals. Impatience arises when animals fail to move freely from one point to another. This gives rise to frustration, which is often taken out on the animals.

TIPM – 05-B-03 Page 3 of 3 – OBJECTIVE/OUTCOME (continued)

Other factors which tend to lead to the inhumane treatment of animals include being taken away from other tasks to unload animals and needing to move animals into the knocking box fast enough to keep pace with the speed of the slaughter line.

Striking, beating, kicking, lifting by the wool or any other action that causes injury, or pain, **will not be tolerated.**

Electrical prods will be used sparingly. Prods and other instruments are not to be a handler's primary driving tool.

When electric prods are used they will be used at the lowest effective power setting and will never be used in a manner that causes excessive pain or distress.

Note: Electric prods must not be used on sick, or injured, animals and they must never be applied to the face, udder, genitals, anus or any other area that will cause undue pain or distress.

To facilitate the smooth movement of animals, from one point to another, items that might frighten them should not be located where one wants them to go.

Note: Animals have a natural instinct to be shy about what they perceive to be obstacles. For example, flapping objects, ventilation drafts, floor drains, loud noises or other movements ahead of them may cause them to balk. Whenever possible, things of this nature should be located outside of the area where the animals are expected to go, or reduced to an absolute minimum.

RELATED SECTIONS OF TIPM

05-B-02 Delivery & Prompt Unloading

06-A-10 AM Care of Animals - General

12-B-05 Safe Handling of Livestock

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Timely Slaughter	05-B-04
REGULATORY REFERENCE <i>AR 42/2003 Meat Inspection Regulation</i> (Consolidated to 112/2009) Section 26(b)	Initial Release Sept 1, 2009 Page 1 of 1
RATIONALE Animals submitted to a “Licensed Meat Facility” (abattoir) should be slaughtered as soon as possible for the following reasons: <ol style="list-style-type: none">1. Animal holding facilities, at most abattoirs, are not designed for the long term care and comfort of animals.2. Mixing animals, from multiple sources, increases the risk that some of the animals may get sick over time. <p style="margin-left: 40px;">Note: An animal’s health can change dramatically within a 24-hour period therefore, another ante-mortem inspection must be conducted if an animal hasn’t been slaughtered within 24 hours of the original inspection to determine whether it is still fit for slaughter.</p>3. In the case of animals brought to the abattoir in crates it is impractical to provide them with food and water. Holding animals for the purpose of fattening them is specifically prohibited in section 26(b) of AR 42/2003.	
OBJECTIVE/OUTCOME All animals will be slaughtered as soon as possible after their arrival. <p style="margin-left: 40px;">Note: It is recommended that animals not be held for more than 24 hours before slaughter.</p> <p style="margin-left: 40px;">Immediate slaughter is particularly desirable for animals delivered in crates (i.e. rabbits and poultry).</p> <p style="margin-left: 40px;">To improve meat quality, it is “Common Industry Practice” to give pigs at least 2 hours of rest before slaughter.</p> Livestock will have access to clean drinking water within a reasonable length of time. <p style="margin-left: 40px;">Note: It is “Common Industry Practice” to have water available in all holding pens. Heaters may be needed, to prevent freezing, during cold weather.</p> Animals held for <u>more than 24 hours</u> will receive adequate amounts of <u>food, water and bedding</u>. <p style="margin-left: 40px;">Note: This is absolutely essential, without exception and while 24 hours meets basic legislated requirements for water animals should have access to water much sooner when the weather is hot.</p> Animals will not be held longer than a week without permission of a Meat Inspection Branch (MIB) Inspector. Abattoir pens will not to be used to fatten animals.	
RELATED SECTIONS OF TIPM 05-A-04 Livestock Yards & Holding Pens 06-A-11 Time Requirements for AM Inspection	

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Sick or Non-ambulatory Animals	05-B-05
REGULATORY REFERENCES: <i>AR 42/2003 Meat Inspection Regulation</i> (Consolidated to 112/2009) Section 21 <i>AR 203/2005 Animal Protection Regulation</i> Sections 10, 12(1) & 12(3)	Initial Release Sept 1, 2009 Revised on Sept 1, 2010
	Page 1 of 2

RATIONALE

Ethical and moral responsibilities to provide humane care to animals, along with the legislated requirements, under section 21 of AR 42/2003 and sections 10 & 12 of AR 203/2005, of not causing undue suffering to animals require that injured or sick animals receive special attention.

Sick or injured animals, upon arrival, may be:

1. Mobile and capable of exiting the transportation vehicle on their own.
2. Immobile but able to exit the vehicle with assistance, or through the use of special devices.
3. Immobile and impossible to move without causing undue pain or suffering.

Regardless of their condition it is imperative that sick, or injured, animals be handled in a humane manner and that they be slaughtered as soon as possible in a manner that doesn't compromise food safety.

In addition to the need to treat animals humanely sick animals may pose a risk to the health of other animals if their condition is contagious.

Note: It may be necessary to prioritize the disposal of these animals to minimize the chance of spreading disease.

OBJECTIVE/OUTCOME:

In accordance with AR 203/2005, no person shall load, or transport, animals that, by reason of infirmity, illness, injury, fatigue or any other cause, would suffer unduly during transport.

Note: Circumstances relating to situations where it is suspected that a sick, injured or non-ambulatory (downer) animal has undergone undue and/or additional suffering during transport, will be referred to and handled by the Meat Inspection Branch (MIB) Inspector in a prompt and humane manner.

In the absence of a MIB Inspector, the abattoir operator will record details of non-compliance with AR 203/2005 and provide this information to the MIB Inspector or to other appropriate provincial and/or federal authorities.

When a sick, injured or otherwise compromised animal arrives at an abattoir the operator will ensure that the animal(s) is handled, slaughtered, or euthanized in a manner that does not subject the animal to any further avoidable distress, or pain.

TIPM – 05-B-05 Page 2 of 2 – OBJECTIVE/OUTCOME (continued)

Seriously injured animals will be slaughtered as soon as possible after arrival.

Note: In situations where these animals arrive when a MIB Inspector is NOT on duty, an attempt could be made to contact the Area Manager or the regularly appointed MIB Inspector to see if arrangements can be made for an emergency slaughter. If this is not possible, an appointed veterinarian could be contacted to provide inspection for an emergency slaughter.

Sick, or compromised animals capable of walking, with or without assistance, will be moved to a holding pen where they will be segregated from healthy animals and tagged appropriately.

Non-ambulatory (downers), that are too heavy to be moved, in a conscious state without causing additional suffering, can be:

1. Stunned on the vehicle and immediately removed to the kill floor to be bled.
2. Stunned and bled, in a sanitary manner in, or immediately outside of, the vehicle.
3. Euthanized on the vehicle.

Note: A non-ambulatory animal must **NEVER** be dragged.

A MIB Inspector must conduct an ante-mortem inspection before any animals can be stunned and bled (when present).

All stunning must be irreversible.

Animals that are euthanized must be condemned and cannot enter the kill floor, or any other part of the abattoir where edible meat products are processed or handled. Animals that are euthanized when an inspector is not on duty must be reported to the inspector the next time he/she is on duty at the abattoir. It is highly recommended that the abattoir develop a euthanasia consent form for the animal owner or trucker to sign.

Truckers will **NOT** be **permitted to leave** the abattoir **with** any sick or **compromised animals in the vehicle**.

Note: An exception to this prohibition would be granting of permission by the Division Veterinarian of the Regulatory Services Division, or a private veterinary practitioner, to transport the sick animal to a veterinary clinic for appropriate treatment.

RELATED SECTIONS OF TIPM

05-B-07 Procedures for Condemned, Dead & Suspect Animals Prior to Slaughter

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Stunning & Bleeding Practices	05-B-06
REGULATORY REFERENCES <i>AR 42/2003 Meat Inspection Regulation</i> (Consolidated to 112/2009) Sections 8, 21(1), 22 & 22.1	Initial Release Sept 1, 2009
	Page 1 of 3
RATIONALE Humane slaughter procedures accomplish two primary goals: <ol style="list-style-type: none">1. The prevention of needless suffering by animals.2. Improving the quality of meat products. <p style="padding-left: 40px;">Note: Excessive stress, in the pre-slaughter period, can have a significant effect on the quality of meat. A prime example of this is Pale Soft Exudative (PSE) Pork.</p> Humane slaughter requires the use of procedures that cause an immediate state of unconsciousness that is maintained until death occurs from blood loss. <p style="padding-left: 40px;">Note: Section 21(1) of AR 42/2003 makes it illegal for the operator, of a “Licensed Meat Facility” (abattoir), to inflict unnecessary pain on an animal. The skills (knowledge and physical condition) of individuals doing the stunning and the condition of the stunning equipment are important factors. Section 22 makes it mandatory to keep the stunning equipment in good repair.</p> <p style="padding-left: 40px;">Section 21.1(1) of AR 42/2003 requires animals to be properly restrained and rendered unconscious prior to slaughter.</p> Efficient and humane stunning requires: <ol style="list-style-type: none">1. Suitable restraint2. Trained and knowledgeable abattoir personnel3. Suitable equipment that is in good repair Common causes of a return to sensibility after electric stunning are: <ol style="list-style-type: none">1. Improper positioning of electrode(s)2. Insufficient amperage (current)3. Poor bleed out4. Poor electrical contact from electrode to animal <p style="padding-left: 40px;">Note: Poor contact is often due to excessively dirty, or long, hair, or wool.</p> <ol style="list-style-type: none">5. Insufficient wetness of hair or wool6. Insufficient electrode contact area More Detailed information concerning the animal welfare aspects of stunning and bleeding can be found at: http://www.grandin.com/index.html	
OBJECTIVE/OUTCOME All animals slaughtered in the abattoir will be stunned in a manner which causes an immediate state of unconsciousness that is maintained until death occurs from the loss of blood.	

TIPM – 05-B-06 Page 2 of 3 – OBJECTIVE/OUTCOME (continued)

Note: This is essential to meet the humane slaughter requirements of AR 42/2003 to ensure that there is no undue suffering inflicted on animals.

Section 8 of AR 42/2003 allows an application, to the Director of the Regulatory Services Division (RSD), for an exemption on religious grounds, from the need to render an animal unconscious. An exemption does not absolve the individual from performing the slaughter as humanely as possible.

All animals will be properly restrained prior to stunning.

Note: To ensure proper restraint, without causing undue pain and distress, all restraint devices must be properly designed and maintained in good working condition.

Only approved methods of stunning will be **allowed**.

Note: In accordance with section 21(2)(c) of AR 42/2003 the following methods of stunning have been approved:

- a) a blow to the head by a mechanical stunning device (e.g. captive bolt);
- b) use of concentrated carbon dioxide gas;
- c) application of an electric current to the head in a manner that produces rapid unconsciousness;
- d) shooting with a rifle

Alternative methods may be approved, by the Director of the RSD, for the purpose of developing, or testing, new procedures, or equipment, that are intended to improve humane methods of slaughter.

When electrocution is used as a method of stunning sufficient current will be applied to the animal for adequate results.

Note: 1.25 Amperes (Amps) of current is considered to be sufficient for market pigs, 2 or more Amperes (Amps) is required for mature sows and boars, and a minimum of 1 Amp is sufficient for sheep and poultry.

All stunning equipment will be properly maintained.

No food animals will be hoisted, or shackled, before they are rendered unconscious with the exception of poultry and rabbits.

All stunned animals will be closely observed for signs of consciousness, or improper stunning.

Note: Signs of proper stunning, that can be observed from a distance include:

- a) a loose and floppy head and neck (the legs may kick);
- b) a limp tongue which hangs straight down;
- c) a straight back;
- d) lack of vocalization (the making of sounds, typical of the type of animal being slaughtered, such as mooing, or squealing);
Vocalization is an indication of inadequate, or improper, stunning;
- e) a wide open eye and a blank stare with no eye movements (captive bolt) or a clamping of eyes shut followed by a blank stare (electrical stunning);
- f) no blinking or eye reflexes in response to touch;
- g) absence of rhythmic breathing (intermittent gasping is acceptable);
- h) a relaxed tail that hangs straight down;
- i) no "nose pinch" reflex

TIPM – 05-B-06 Page 3 of 3 – OBJECTIVE/OUTCOME (continued)

Animals showing signs of incomplete, or improper, stunning will be stunned again immediately.

All animals must be bled out as quickly as possible.

Note: Rapid bleeding is essential regardless of the method of stunning because it ensures maximum loss of blood and helps ensure that the state of unconsciousness will be maintained until the animal dies.

Rapid bleeding is particularly important when the animal is stunned by electrocution. This method of stunning doesn't cause any significant physical damage to the brain thus the animal is more likely to regain consciousness than when methods that damage the brain, such as gunshot, are used to stun the animal.

It is "Common Industry Practice" to strive for a "Stun to Stick" interval of less than 30 seconds in the case of electrical stunning. For head only stunning of hogs, the stun to stick interval should be within 15 seconds. When head only stunning is used for cattle or sheep the animal should be bled within 10 seconds.

When stunned animals recover they regain their sense of feeling before they are able to struggle, or vocalize. For this reason the absence of reflexes cannot be relied upon as an absolute indication that the animal isn't feeling pain.

Abattoir personnel that are responsible for sticking (cutting the throat) will be knowledgeable about the best location for sticking the animal.

Note: This knowledge is essential to ensure that animals bleed out quickly and to ensure that there is no accumulation of blood in the tissues of the neck.

The optimum location for sticking varies with each species.

REQUIREMENTS FOR AN AUDITABLE SYSTEM (MFS)

Requirements for "Stunning & Bleeding Practices" will be met when:

1. Written "**Dressing Procedures**", for the abattoir, include provisions for humane and safe stunning, sticking and bleeding.
2. Written "**Preventative Maintenance Procedures and/or Records**" include stunning equipment.

Note: Maintenance records should demonstrate that appropriate actions have been taken to address any deficiencies that were detected.
3. Abattoir personnel responsible for stunning and bleeding have received proper training.
4. On site observations demonstrate that stunning and bleeding is being conducted in a satisfactory manner.

RELATED SECTIONS OF TIPM

03-C-04 Preventative Maintenance Procedures - Records of

03-G-01 Dressing Procedures - Red Meat Animals

03-G-02 Dressing Procedures - Poultry

05-A-05 Stunning & Bleeding Area

07-A-03 Ritual Slaughter

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Procedures for Condemned, Dead & Suspect Animals Prior to Slaughter	05-B-07
REGULATORY REFERENCES <u>AR 42/2003 Meat Inspection Regulation</u> (Consolidated to 112/2009) Sections 27(1), 27(2) 45, 46 (1), 46(2), 50 & 51 <u>Meat Facility Standards</u> (MFS) Section A.2.5.3	Initial Release Sept 1, 2009 Page 1 of 3
RATIONALE <p>Sick and/or injured animals, particularly those that are affected with contagious diseases pose a serious threat to food safety. For this reason AR 42/2003 requires that all animals be subjected to an ante-mortem (before death) inspection.</p> <p>Upon completion of the ante-mortem (AM) inspection a Meat Inspection Branch (MIB) Inspector will determine that an animal or group of animals:</p> <ol style="list-style-type: none">1. Is fit for slaughter;2. Requires immediate slaughter for humane reasons;3. Is fit for slaughter but needs to be held until the end of the kill;4. Needs to be held for further examination;5. Must be condemned because it is unfit for slaughter <p>This document outlines the responsibilities of the “Licensed Meat Facility (abattoir) operator relating to animals that are “held” or condemned following the AM inspection.</p> <p>Animals condemned on the AM inspection and any that are found dead must be disposed of in a manner that does not compromise food safety.</p> <p>Note: It is for this reason that section 27(1) of AR 42/2003 prohibits the taking of a dead animal into the abattoir and section 27(2) requires the operator to remove and dispose of, in a timely manner, any animal(s) that dies in the abattoir.</p> <p>“Held” animals must be handled in a humane manner and in accordance with the instructions of a MIB Inspector.</p> <p>Note: Depending on their condition an animal(s) may need to be slaughtered immediately, for humane reasons, or held until the end of the kill because of concern that their condition may lead to contamination of other carcasses.</p> <p>Section 46 of AR 42/2003 gives the MIB Inspector the authority to determine how “held” animals will be handled including separation and segregation before slaughter.</p>	
OBJECTIVE/OUTCOME <p>The operator of the abattoir will develop and implement procedures for the handling of animals that are held, or condemned, on the AM inspection.</p> <p>Note: In accordance with AR 42/2003, a MIB Inspector must clearly identify any animals that are held, or condemned, on the AM inspection.</p> <p>For condemned animals a MIF – 8 Condemned Tag, or other device that shows the word ALBERTA CONDEMNED on it will be used. For held animals a</p>	

TIPM – 05-B-07 Page 2 of 3 – OBJECTIVE/OUTCOME (continued)

MIF – 7 Held Tag will be used.

Held tags may be applied directly to the animal, or to the container, or pen, in which the animal is located.

For condemned animals, in addition to using appropriate tags, the MIB Inspector will record full details including animal identification, owner's name and address, reason for condemnation, etc. on the MIF – 13 “Ante-mortem Inspection Report” and the MIF – 4 “Certificate of Condemnation”.

The MIB Inspector’s record of condemned animals serves to provide:

- (a) a written record of all condemnations and reason(s) for the condemnation;
- (b) a document that the abattoir operator can give to the producer, to verify that a carcass or portion thereof has been condemned;
- (c) record of condemnations for statistical purposes

Held and Condemned animals will be handled as described in the following text.

Held Animals

All held animals will be handled in accordance with the instructions of the MIB Inspector.

Note: The MIB Inspector has the authority to order held animals to be:

- a) slaughtered after all other animals have been slaughtered on that day;
- b) slaughtered immediately for humane reasons;
- c) held indefinitely for further examination

Held animals will be moved to appropriate holding pens in accordance with the instructions of the MIB Inspector.

Note: If a MIB Inspector deems that an animal cannot be moved, without causing undue suffering, that animal may be irreversibly stunned in the pen then dragged into the kill floor for bleeding. In these situations, providing it can be done in a sanitary manner, the animal may be bled in the pen, or live animal receiving area.

Held animals will only be removed from the holding area with permission from a MIB Inspector.

Note: Section 51 or AR 42/2003 prohibits the removal of a “Held Tag” without the permission of the MIB Inspector.

Condemned Animals

Condemned animals or animals found dead, during the AM inspection, **can't be taken** into any part of the abattoir **where edible product is handled** or processed.

Note: Salvage of hides, etc., from these animals must take place in the yards, or inedible area, of the abattoir.

Live condemned animals will be killed in the yards.

Note: Section 45(a) requires that condemned live animals be slaughtered (killed) apart from all other animals. This means that kill floor facilities can't be used to kill

TIPM – 05-B-07 Page 3 of 3 – OBJECTIVE/OUTCOME (continued)

these animals.

Abattoir operators will ensure that condemned and/or dead animals are properly disposed of, as soon as possible, and denatured (treated in a manner that makes a substance unfit for human consumption) in a manner approved by a MIB Inspector.

Note: This must be done to comply with sections 45(c) and (d) of AR 42/2003.

If, for any reason, the MIB Inspector requires a dead animal to be held the operator shall be notified and the MIB Inspector should identify the animal(s) with a MIF – 7 Held Tag.

Dead cattle determined to be **over 30 months of age will be handled as SRM.**

REQUIREMENTS FOR AN AUDITABLE SYSTEM (MFS)

Requirements for “**Condemned, Dead or Suspect Animals**” will be met when;

1. The operator of the abattoir is given a:

a) **Certificate of Condemnation** (MIF - 4);

Note: This certificate must be filled out, in its entirety and signed by the MIB Inspector. It should describe how many carcasses, or portions of carcasses, were condemned, and the reasons for the condemnation.

b) Copy of the **Inspector’s Daily Report** (MIF - 5);

Note: This report must be signed by the MIB Inspector. When properly completed it will summarize how many carcasses, or portions, were condemned and the reasons why.

c) Copy of the **Control Sheet for MIF - 2 and MIF - 7 Held Tags** (MIF - 3)

Note: This form should indicate corrective action, if any, is required to deal with held carcasses, or equipment.

The **MIB Inspector** is **responsible** for **filling out the** above **forms** completely and in a legible manner.

2. On site observations demonstrate that held and condemned animals are handled in an appropriate manner.

RELATED SECTIONS OF TIPM

05-B-05 Sick or Non-ambulatory Animals

06-A-09 AM Condemnations

06-A-10 AM Care of Animals - General

06-A-12 Maintenance of Identity during the AM Inspection

06-A-13 Dispositions following the AM Inspection

10-A-04 SRM Removal & Control Program

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Feed & Water Withdrawal	05-B-08
REGULATORY REFERENCE <i>AR 42/2003 Meat Inspection Regulation</i> (Consolidated to 112/2009) Section 21 (3)	Initial Release Sept 1, 2009 Page 1 of 1
RATIONALE <p>In addition to the moral and ethical responsibility of treating animals in a humane manner section 23(3) of AR 42/2003 requires that animals not be held, in a “Licensed Meat Facility” (abattoir) for longer than 24 hours without adequate feed, water and bedding.</p> <p>Note: When assessing the length of time, without feed or water, the operator of the abattoir should take into consideration the amount of time an animal may have been without feed, or water, during transportation.</p> <p>It should also be recognized that 24 hours is too long for an animal to be deprived of water during hot weather.</p> <p>Prolonged periods without food, or particularly water, may have a negative impact on the quality of the meat products from these animals.</p> <p>Conflicting with the need to handle animals in a humane manner is the matter of withholding feed, to empty the gut, in order to prevent contamination of the carcass. There will be less contamination, of the carcass, if feed is withheld, particularly for pigs and poultry.</p> <p>Note: It is generally accepted that a fasting period of 6 to 12 hours is optimal. For poultry the proper time for feed withdrawal by the producer, on farm, is affected by the:</p> <ul style="list-style-type: none">a) feeding program (type of feed);b) size of the bird;c) scheduled time for catching the birds;d) length of time the birds will be in transport;e) length of time the birds will have to wait at the abattoir before slaughter	
OBJECTIVE/OUTCOME <p>Animals that will be held, at the abattoir, for more than 24 hours will receive adequate feed, water and bedding.</p> <p>Note: This is necessary to comply with the requirements of AR 42/2003. The length of time an animal has been in transport, or waiting to be unloaded should be included in the 24 hour limitation.</p> <p>In warm environmental conditions animals will require water more frequently than every 24 hours.</p> <p>Animals that are known to have been off feed or water for more than 24 hours will be slaughtered immediately upon their arrival.</p> <p>To minimize the chance of contamination of the carcass abattoir operators can withhold feed and water for a period of time before slaughter.</p> <p>Note: Current information indicates that the optimum period of feed withdrawal, in poultry and hogs is 6 to 12 hours before evisceration.</p>	
RELATED SECTIONS OF TIPM 05-A-04 Livestock Yards & Holding Pens 06-A-10 AM Care of Animals - General 06-A-11 Time Requirements for AM Inspection	

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Poultry - Catching, Loading & Transport	05-C-01
REGULATORY REFERENCES <u>AR 203/2005 Animal Protection Regulation</u> Sections 11, 12(1), 12(3), 12,(4), 12(5) & 14(2)	Initial Release Sept 1, 2009
	Page 1 of 3
RATIONALE <p>While a “Licensed Meat Facility” (abattoir) may, or may not, be directly responsible for catching, loading, or transportation, of poultry, to the abattoir, operators often have to deal with birds that have been stressed, injured, or otherwise compromised, during transportation.</p> <p>Note: MI – 40, the Meat Inspection Branch Directive on Compromised Animals, requires Meat Inspection Branch (MIB) Inspectors to report any contraventions to their Regional Supervisor and/or Area Manager who in turn will decide whether the issue is serious enough to investigate further and possibly report to the S.P.C.A.</p> <p>The abattoir operator has a responsibility to notify transporters about any contraventions of AR 203/2005 that may be observed when transport vehicles arrive at the abattoir.</p> <p>Careless, or rough, catching and loading of birds is a common cause of injury.</p> <p>Note: Not only are injured birds more susceptible to suffering adverse effects during transportation many injuries also result in the loss of marketable product.</p> <p>Careless and rough handling is also inhumane.</p> <p>To minimize stress, birds must be protected from adverse temperature variations during transportation.</p> <p>Note: Extremely hot, or cold, conditions can have equally devastating effects.</p> <p>The intent of this document is to provide an outline of what are considered to be acceptable methods of catching, loading and transporting poultry.</p> <p>Note: The methods outlined in the Objective/ Outcome section of this document also apply to the unloading of birds at the facility.</p>	
OBJECTIVE/OUTCOME <p>Birds will be received in good condition with minimal injury, or stress.</p> <p>The following methods and procedures are considered to be “Common Industry Practice”.</p> <u>Catching and Loading</u> <ol style="list-style-type: none">1. The catching and loading crew will be knowledgeable and skilled in the proper methods of catching and loading poultry. <p>Note: Proper training and experience are critical factors in the development of knowledgeable and skilled personnel. Training is the responsibility of the employer.</p>	

TIPM – 05-C-01 Page 2 of 3 – OBJECTIVE/OUTCOME (continued)

2. Piling up in corners will be avoided.

Note: Methods of reducing piling up include:

- a) reducing the lighting intensity in the barn;
- b) using blue lights;
- c) corralling birds with a net, or a screen, at the loading door

3. Birds will be caught in a proper manner.

Note: The proper way to catch a bird is by the legs. Catching them by the wings or the neck is not acceptable.

4. An appropriate number of birds will be caught at the same time.

Note: The number of birds that can be caught safely, at the same time, varies with the size of the birds. A maximum of 5 birds per hand is recommended for birds weighing up to 4 pounds each.

5. Only properly designed crates that are in a good state of repair and cleanliness will be used.

6. An appropriate number of birds will be placed in each crate.

Note: The number of birds that can be put in a crate, or bin, depends on the size of the birds and weather conditions at the time of transport.

There should be enough space to allow all birds to rest on the floor at the same time.

The following maximum total weights are recommended for winter transportation:

- a) chickens: 63 kg/m² (139 lb/10 ft²);
- b) broiler turkeys: 98 kg/m² (216 lb/10 ft²);
- c) heavy hens: 98 kg/m² (216 lb/10 ft²);
- d) heavy toms: 98 kg/m² (216 lb/10 ft²)

These weights should be reduced during the summer months.

When temperatures exceed 32⁰ C (90⁰ F), birds should not be loaded unless they are scheduled for same-day delivery.

On hot summer days, turkeys should not be loaded at midday.

7. Loaded crates will be moved onto the transport vehicle in a manner that doesn't cause injury, or undue stress, on the birds.

Note: Loaded crates should be moved smoothly, and in a horizontal position. They should not be thrown or dropped.

If a conveyor is used the conveyor angle should prevent tilting of crates at an angle that causes the birds to pile up.

Transportation

1. Transport drivers will be aware of their responsibility to provide proper care of poultry during transportation.

TIPM – 05-C-01 Page 3 of 3 – OBJECTIVE/OUTCOME (continued)

2. Protection, from adverse weather conditions, will be provided.

Note: Covers should be used to protect birds from wind, rain and adverse weather conditions. The covers should be adjusted to allow the birds to warm up, or cool off, as required.

3. Poultry will be transported to the abattoir immediately after loading.

4. Birds will not be required to sit in a parked vehicle for more than two hours unless there is protection from adverse weather conditions.

Note: Acceptable transportation temperatures are between 5⁰ C (42⁰ F) and 30⁰ C (86⁰ F). In cases of extreme temperatures transportation may not be advisable.

5. The transportation vehicle and/or containers will be designed to minimize injury or sickness during transportation.

Note: The design of the vehicle and containers (crates) should ensure that birds:

- a) are not exposed to exhaust fumes;
- b) are completely contained within the crates;
- c) have adequate space to lie down comfortably;
- d) are not exposed to any sharp protruding objects

6. Transportation vehicles and containers will be kept clean.

Note: The vehicle and containers should be clean at the time of loading and they should be cleaned and sanitized as soon as possible after they have been unloaded.

RELATED SECTIONS OF TIPM

05-C-02 Poultry Receiving & Handling

05-B-01 Animal Transport Vehicles - Design & Maintenance

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Poultry Receiving & Handling	05-C-02
REGULATORY REFERENCES <i>AR 42/2003 Meat Inspection Regulation</i> (Consolidated to 112/2009) Section 21	Initial Release Sept 1, 2009 Page 1 of 2
RATIONALE In addition to the ethical and moral requirement of handling animals in a manner that will not cause any undue suffering there is also a legislated requirement to do so under section 21 of AR 42/2003. Note: Section 21(2) of AR 42/2003 also requires the operator of a “Licensed Meat Facility” (abattoir) to ensure that animals arriving at an abattoir be provided with immediate shelter. This implies that they must be unloaded from the transport vehicle as soon as possible after arrival. Implementation of the measures outlined in this document will minimize the stress and intentional, or unintentional, abuse of poultry during unloading, holding and eventual movement to slaughter.	
OBJECTIVE/OUTCOME Birds will be handled in a humane manner from the time of arrival until slaughter. Arrangements will be made for holding and monitoring birds upon their arrival. Live birds will be protected from adverse weather conditions while waiting to be unloaded. Note: Forced-air circulation, or other means of ventilation, must be provided, as required, to prevent live poultry from overheating. Crates of live birds will be moved smoothly and kept in a horizontal position while being unloaded, or moved. Note: If a conveyor is used to unload crates, of live birds, the angle should kept at a level that prevents the birds from piling up. Crates containing live birds <u>must not be thrown or dropped.</u> Care will be taken, to avoid injury, to birds, as they are removed from transport crates, or liner trucks. Note: Birds must <u>never be lifted by the head, neck, or wings.</u> Birds that escape during unloading should be caught as soon as possible. Reduced lighting levels, in the receiving area, will help keep birds calm. Care will be taken to properly hang birds on shackling devices.	
REQUIREMENTS FOR AN AUDITABLE SYSTEM (MFS) Requirements for the “Poultry Receiving & Handling” will be met when: 1. Up-to-date written “Poultry Receiving and Handling Procedures” are on file. Note: These procedures should be specific to the abattoir. 2. On site observations demonstrate that the “Receiving and Handling of Poultry Procedures” are being implemented. Note: Implementation of these procedures will ensure that birds are handled in a humane manner.	
RELATED SECTIONS OF TIPM 05-B-01 Animal Transport Vehicles - Design & Maintenance 05-B-02 Delivery & Prompt Unloading 05-B-04 Timely Slaughter 05-C-01 Poultry Catching, Loading & Transport	

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Poultry Bleeding & Stunning Practices	05-C-03
REGULATORY REFERENCES: <i>AR 42/2003 Meat Inspection Regulation</i> (Consolidated to 112/2009) Sections 21, 22 & 22.1	Initial Release Sept 1, 2009 Revised on Sept 1, 2011
	Page 1 of 2

RATIONALE

Every “Licensed Meat Facility” (abattoir) has an ethical, moral and legal requirement to conduct slaughter in a humane manner.

Note: The legal requirements, for humane slaughter, are found in Sections 21 22 and 22.1 of AR 42/2003.

Section 21(1) requires abattoir operators to minimize pain and distress on animals (including birds) during slaughter.

Section 22 mandates the need to keep stunning equipment in good repair.

Section 22.1 outlines all of the other conditions of humane slaughter.

Humane slaughter procedures:

1. Prevent needless animal suffering.
2. Improve the quality of meat products.

Note: To be considered humane, slaughter methods must cause an immediate state of unconsciousness that is maintained until death occurs from blood loss.

Efficient and humane stunning requires:

1. Suitable restraint.
2. Trained and knowledgeable staff.
3. Suitable equipment that is in a good state of repair.

OBJECTIVE/OUTCOME

All poultry will be stunned and bled in a humane manner.

Note: To meet the humane slaughter requirements of AR 42/2003 and prevent undue suffering, all poultry will be stunned in a manner which causes immediate unconsciousness and ensures that this state of unconsciousness is maintained until death occurs from the loss of blood.

It is “Common Industry Practice” to use electrocution as the method of choice for stunning poultry.

All personnel involved with stunning and bleeding will be properly trained in the required procedures.

Sufficient current will be applied to ensure adequate results.

Note: An amperage of anywhere between 0.1 to 1.0 maximum is generally sufficient

TIPM – 05-C-03 Page 2 of 2 – OBJECTIVE/OUTCOME (continued)

for poultry.

Lower cost stunners (e.g. knives) are generally effective with amperages of between 0.25 to 0.5 amperes with a voltage adequate to ensure the amperage requirements are met (usually between 100-400 volts.)

Newer technology stunners (e.g. water baths/plate) are generally effective with amperages of between 0.13 to 0.19 amperes with a voltage of between 17-30 volts. Salt is recommended to be added to improve consistency.

Birds will be observed following application of the electric current to ensure adequate results.

Note: It is expected that birds should be rendered insensible 99% of the time after the first electrical stun.

A rigid body with an arched neck and tucked in wings, with the head held vertically, is expected in a proper stun. Poultry will be rigid during the stun, and may show detectable constant, rapid body tremors, but the bird's body is expected to be loose and there is to be no rhythmic breathing.

As poultry bleed out, the head will start to drop, the eyelids may close, and the wings will slowly come away from the body. A proper bleed out must show a constant stream of blood, and the bird is generally bled out within 45-90 seconds.

The operator ("kill" boss) will cease stun and bleed operations and take immediate corrective action when poultry is not being effectively stunned and/or bled.

Note: An additional abattoir employee should be assigned to the killing station and given the responsibility of killing, by hand, any bird that has not been properly stunned or that has regained consciousness.

A **live**, or conscious, bird **must not** be allowed to **enter the scalding vat**.

Bleeding and stunning equipment will be properly maintained.

REQUIREMENTS FOR AN AUDITABLE SYSTEM (MFS)

Requirements for "**Stunning & Bleeding Practices**" will be met when:

1. Up-to-date written "**Poultry Dressing Procedures**" are on file.

Note: These procedures must:

- a) be specific for the abattoir;
- b) include safe and humane stunning and bleeding practices

2. The written "**Preventative Maintenance Procedures**", for the abattoir include stunning and bleeding equipment.

3. "**Preventative Maintenance Records**" are on file.

Note: These records should show:

- a) that stunning and bleeding equipment is monitored regularly;
- b) details on any corrective actions that were required and instituted

4. On site observations demonstrate that poultry are being stunned and bled in an

acceptable and humane manner.

RELATED SECTIONS OF TIPM

03-C-04 Preventative Maintenance Procedures - Records of

05-B-06 Stunning & Bleeding Practices

07-B-06 Dressing Procedures - Poultry

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Animal Welfare Audits - Red Meat Abattoirs	05-D-01
REGULATORY REFERENCES <u>AR 42/2003 Meat Inspection Regulation</u> (Consolidated to 112/2009) Sections 21, 22 & 22.1	Initial Release Sept 1, 2009
	Page 1 of 9
<p>RATIONALE</p> <p>Section 21(1) of AR 42/2003 imposes a legal requirement, upon the operator of a “Licensed Meat Facility (abattoir) and abattoir personnel, to minimize pain and distress in any animal being prepared for, or being slaughtered.</p> <p>Note: In addition to this legal requirement there is also a moral and ethical requirement to handle animals in a humane manner.</p> <p>Mishandling of animals may be intentional, or unintentional. <u>Intentional abuse will not be tolerated.</u></p> <p>Note: Un-intentional abuse can be prevented through the training of abattoir personnel to ensure they have sufficient knowledge about animal behaviour patterns so that they can be moved with a minimum of frustration, both for the animals and the animal handlers.</p> <p>The Meat Inspection Branch (MIB) of Alberta Agriculture and Rural Development (ARD) is fully committed to animal welfare and will conduct regular “Animal Welfare Audits”.</p> <p>The intent of these audits is to promote continuous improvement of animal welfare through the observation of and measuring various objective indicators in order to correct any problems that may exist.</p> <p>Note: “Animal Welfare Audits” have three components:</p> <ul style="list-style-type: none">a) Animal Handling & Care (Core Criteria)b) Condition of the Handling Facilities in the Abattoirc) A General Questionnaire <p>Objective criteria, relating to animal handling and the condition of facilities will be assessed during an on site visit. The intent of the general questionnaire is to gather supplementary information about the abattoir.</p> <p>The purpose of this document is to provide information on the conduct of “Animal Welfare Audits”.</p>	
<p>OBJECTIVE/OUTCOME</p> <p>Regular “Animal Welfare Audits” will be conducted at the abattoir.</p> <p>Note: The MIB will determine the frequency of the audits. Normally there will be partial audits conducted each year. At least one of these will deal with animal welfare.</p> <p>There may be a greater frequency of “Animal Welfare Audits” in abattoirs with animal welfare issues in the past.</p> <p>Under ideal conditions the following “Core Criteria” for the handling of animals will be met:</p> <ol style="list-style-type: none">1. All animals will be rendered insensible with the first shot, or application of an electric stunner.	

Note: All abattoirs should strive to meet this ideal but it is recognized that 100% success is not possible. There is a small allowance, in the audit criteria, for not always meeting this ultimate ideal.

It is critical that all animals be observed for signs of effective stunning and if there is **any indication of sensitivity** the **animal** should be **re-stunned immediately**.

Signs of a properly stunned animal include the following:

- a) a loose floppy neck and a head that hangs right down;

Kicking of the legs is not a sign of an improperly stunned animal. This is a sign that the lower nerve centers, in the spinal cord, responsible for automatic reflex actions, are no longer being controlled by the brain.

It is normal for muscle spasms to cause some animals to flex their neck immediately after stunning but the neck should be loose and floppy within 20 seconds. If flexing continues the eye reflexes should be checked for signs of sensitivity.

Continuous kicking movement in an electrically stunned animal is a sign of insufficient amperage, or poor contact.

- b) a straight and limp tongue;

Stiff curling of the tongue, or moving of the tongue in and out, is indications of at least partial sensibility. In a properly stunned animal the tongue will hang out of the mouth and it will be straight and limp.

- c) hanging head and straight back and a limp tail when hung on the rail;

When a properly stunned animal is hung on the rail its back will be straight and the head will hang straight down.

There must not be any arching of the back or attempts to lift the head. These are both signs of what is called a righting reflex (attempt to get up). **Momentary flopping** of the head is **not** a **righting reflex**.

- d) open eyes with a blank stare;

This effect should be immediate when a bullet, or captive bolt, is used.

With electrical stunning the animals will clamp its eyes shut briefly then they should relax into a blank stare.

- e) loss of blink and eye preservation reflexes;

Animals that are **shot correctly**, with either a bullet, or captive bolt, **will not blink**. Rolling back of the eyes and nystagmus may be a sign of partial sensitivity. Nystagmus is an eye movement where the eye gradually moves in one direction then suddenly snaps back in the opposite direction.

It is advisable to observe electrically stunned animals, particularly pigs, rather than indiscriminately poking at the eyes. If a pig has a natural blink (where the eye closes and then re-opens) it has not been stunned properly. Nystagmus is not a sign of regained sensitivity in electrically stunned animals particularly those stunned with frequencies higher than 50 or 60 cycles.

Vibration of the eyelids is an indication of a poor stun with a captive bolt pistol but is not a sign of sensitivity in animals stunned electrically.

- f) loss of rhythmic breathing;

Gasping is a sign of a dying brain and is acceptable. Twitching of the nose (like a rabbit) might be a sign of partial sensibility.

- g) lack of vocalization;

Vocalization is defined as the making of sounds that are normal for the species, e.g. a squealing pig, a bleating lamb, etc. Any vocalization is a sign of sensitivity.

- h) lack of response to external stimuli;

In a properly stunned animal there will be no reflex response to actions such as pinching the nose, touching the eyeball, making contact with hot water, etc.

Auditors will use the following criteria to evaluate stunning:

Captive Bolt or Rifle

- a) Was the animal rendered insensible with a single shot?

Miss-firing, or shots in the air, with pneumatic units, are not counted but if the operator double stuns the animal the effectiveness of the first shot is the one that will be assessed.

- b) Is the captive bolt or caliber of the bullet, appropriate for the size of animal being stunned?
- c) Are the eyes completely relaxed and wide open within 15 seconds of stunning?

Electrical Stunning

- a) Are the voltage and/or amperage settings adequate to cause immediate unconsciousness as soon as the electrodes are energized?

A minimum of 1.25 Amps is generally required for market hogs and 1.00 for sheep.

Broken backs and blotchy hemorrhages (bleeding) in the muscle tissues may result if the voltage and/or amperage are too high.

Electrical Stunning will render the animal unconscious either by causing a loss of consciousness, from current passing through the brain, or from a lack of oxygen from stopping the heart.

To stop the heart the current must pass through the body. This is accomplished by placing one electrode on the body and the other on the forehead, or side of the head, or top of the head, or in the hollow directly behind the ears.

To make the current pass through the brain, causing a grand mal seizure (convulsion), there must be sufficient amperage and the electrodes must be placed in one of the following ways:

- i. one on each side of the head;
- ii. one on the top of the head and the other on the bottom of the head;
- iii. one on the top of the head and the other on the neck in the hollow behind the ears;
- iv. one under the jaw and the other on the back of the neck

The electrodes must not be placed on the same side of the head and neck, or jaw, because the current will bypass the brain.

- b) Were the tongs, or wand, properly applied to the animal?

Electrodes must be placed firmly on the animal before they are energized. They must not be applied to sensitive areas of the body such as the eyes, inside the ears, in the rectum, etc.

“Hot Wanding”, which is the application of energized electrodes, should be discouraged because poor contact is often made and the animal suffers a shock that causes pain and distress and in most cases vocalization.

- c) Does the stunning effect last until the animal has been bled out?

Electrical stunning does not damage the brain physically so the animal could regain consciousness if bleeding is delayed.

2. Animals on the rail will not show any signs of sensibility (consciousness).

Note: All animals should be observed, from a distance, for signs of sensibility.

As stated in the previous section the most important signs indicating proper stunning are a floppy head, tongue hanging straight down, back and head hanging straight down, and no arching of the back.

Animals showing any **signs of sensibility** must be **re-stunned immediately**. It is absolutely essential that procedures such as shackling, hoisting, skinning, head removal, etc. be delayed until the animal is completely insensitive.

As an animal regains sensitivity the following signs will appear in order:

- a) return of eye reflexes;

Touching the cornea (surface of the eyeball) will cause a sensitive animal to blink. This is called the corneal reflex.

Touching the edge of the eyelids will also cause a sensitive animal to blink. This is called the palpebral reflex.

- b) return of rhythmic breathing;

On occasion rhythmic breathing may come back before any of the eye reflexes come back. This is a primary indication of poor stunning.

- c) spontaneous blinking;

Here we are talking about an animal that makes normal blinking movements without stimulation of the palpebral, or corneal, reflexes.

d) response to a painful stimulus;

The presence of a pain response during any dressing procedure is a clear indication that the animal is sensitive.

If there is any doubt, about the sensitivity of an animal, following the observation of other signs, a painful stimulus, such as a pin prick to the nose, should be administered to determine the state of sensitivity.

e) righting reflex;

Any attempt to get up is a clear indication that the animal is conscious.

On the rail the righting reflex is shown by arching of the back and bending of the neck in a manner that brings the head up and back.

f) vocalization

Vocalization is another clear cut sign of a sensitive animal.

3. There will be a short interval between stunning and bleeding.

Note: From a humane perspective the time between stunning and bleeding is not as critical in animals that have been stunned with a captive bolt, or a bullet. The severe and permanent physical damage to the brain will cause these animals to die without regaining consciousness. For this reason the stunning to bleeding time is not measured in an “Animal Welfare Audit” when this method of stunning is used.

There is no physical damage to the brain with electrical stunning thus the animal will return to consciousness unless it dies from being bled out.

For animals that are stunned with the electrodes only applied to the head bleeding should start within 20 seconds. Animals that have been put into cardiac arrest should be bled within 60 seconds.

In addition to humane considerations there are other reasons for prompt bleeding. Excessive stun to bleed intervals may cause dark cutters and other quality issues with the carcass.

4. Fewer than 3% of cattle, pigs, sheep, or alternative livestock will slip and less than 1% will suffer a fall.

Note: For audit purposes a slip is defined as a situation where the animal’s foot loses contact with the ground in a non-walking manner.

A fall is defined as a situation where the animal suddenly loses its upright position resulting in a part of the body, other than a limb, making contact with the ground.

Slipping and falling is usually caused by a combination of poor footing and too much excitement as animals are being moved.

During an audit animals will be observed during all phases of the operation including unloading, penning, movement through the chute system and while standing in the stunning box or pens. Observed slips and falls will be recorded.

5. There will be a minimal amount of vocalization.

Note: In general less than 5% of pigs and 3% of ruminants should vocalize.

Vocalization, by undisturbed animals, in their pens, or in the chute system is not counted.

Vocalization is considered to be a sign of distress when it is associated with handling or in response to an injury.

Multiple vocalizations, by the same animal, in a defined area, are only counted as one instance of vocalization.

6. There will be limited and judicious use of electric prods.

Note: Electric prods should not be the primary tools used to move animals. Using a prod on **more than 25%** of animals is clearly **unacceptable**.

Electric prods should only be used on stubborn animals. They should not be applied continuously, or repetitively, on animals that are not responding as expected. Only one jolt should be given at a time and then the animal should be given a chance to respond. Most animals will move ahead after being given a moment to respond. Excessive and/or continuous use only serves to cause panic and gets the animal so riled up that it doesn't know how it is supposed to respond.

The **repeated use of paddles**, sticks, or other non-electrical instruments, in a forceful, driving manner, applied directly on the animal, is also considered **unacceptable**.

7. There will be no willful acts of abuse.

Note: Willful acts of abuse are totally unacceptable and will be addressed with immediate corrective action.

Examples of willful acts of abuse include, but are not limited to:

- a) dragging a conscious animal;
- b) applying prods to sensitive parts of the animal;
- c) excessive use of prods;
- d) hitting animals with various instruments;
- e) slamming gates on livestock;
- f) purposefully driving livestock on top of one another;
- g) hoisting sensible animals;
- h) lifting sheep by the wool or hide

8. Animals being held for more than 24 hours must have access to feed and water.

Note: It is desirable for animals to have access to clean drinking water at all times while in the holding pens.

The **Facility Criteria** will meet the following requirements:

1. The unloading facilities will be of suitable design and maintained in a manner that allows for the safe handling of animals with minimal opportunities for injury to the animals.

Note: There should not be any gaps between the deck of the transport vehicle and the unloading dock.

The first part of the unloading dock should be level. In other words animals should not have to move onto an inclined plane immediately upon leaving the transport vehicle.

The incline will not be greater than 20 to 25⁰. The less slope the better.

Inclines should have cleats, or there should be steps, to prevent slipping and falling. For adjustable ramps a spacing of 20 cm (8") is recommended between the cleats.

Concrete stepped inclines provide the best traction for livestock. For cattle the steps should have a 30 to 45 cm (12 to 18") tread and an 8 to 9 cm (8") rise. For hogs the tread may be reduced to 25 cm (10") and the riser to 6cm (2½").

2. There will be sufficient space in the holding pens for the number of animals.

Note: Animals should not have to remain on the transport vehicles for lack of space in the holding pens.

Animals should only take up 75% of available space in each pen. The following are offered as guidelines:

- a) 1.87 sq meters (20 sq ft) for each 550 kg (1,200 lb) ruminant;
- b) 0.55 sq meters (6 sq ft) for each market hog;
- c) 1.03-1.12 square meters (11-12 sq ft) for sows;
- d) 3.74 sq meters (40 sq ft) for boars

There should be enough pens to allow separation of incompatible animals, e.g. separation of young from old, aggressive animals from docile animals, etc.

3. There will be non-slip flooring throughout the animal handling area.

Note: This is required to prevent falls and possible crippling injuries.

4. There will be smooth edges and surfaces on all gates and walls throughout the animal handling area.

Note: Sharp edges (e.g. angle iron) and small diameter piping will cause bruises. Round pipes with a diameter of more than 8 cm (3") are less likely to bruise.

Protruding bolts and sharp metal must be eliminated.

Gate tracks should be recessed into the wall of the chute.

There should be padding on the bottom edge of vertical sliding gates. They should also be counter weighted. Cut tires or belting provide sufficient padding.

TIPM – 05-D-01 Page 8 of 9 – OBJECTIVE/OUTCOME (continued)

5. Chutes will be properly illuminated.

Note: Proper lighting will actually attract animals into a chute.

The front area of the chute or the entire chute should be lit.

Light should not glare directly into the eyes of an approaching animal.

6. Visual distractions, for the animals, will be minimized.

Note: Examples of distractions that will cause animals to balk if they are in the way of the animals include:

- a) puddles of water;
- b) cups;
- c) pieces of paper;
- d) shadows;
- e) drains;
- f) a pipe running across the floor of a chute or alley;
- g) hanging and flapping objects, e.g. chains

7. Crowding pens and chutes will have solid sides and rounded corners.

8. Noise will be kept to a minimum in animal handling areas.

Note: Noises that are particularly irritating to animals include:

- a) high-pitched motor and hydraulic system noise;
- b) banging;
- c) reverberation;
- d) hissing air;
- e) yelling and shouting

Abattoir personnel will be trained in and employ the principles of good animal handling methods.

Note: Training in the proper handling of compromised animals (e.g. downers) should be provided.

There will be written protocols for the handling of animals.

Note: Abattoir personnel must be aware of and follow these policies, or protocols, particularly those dealing with the handling of compromised animals.

Personnel doing the stunning will be proficient.

Note: A proficient stunner will

- a) be successful on the vast majority of stunning attempts;
- b) constantly monitor stunned animals for incomplete stunning, or return to sensitivity;
- c) promptly re-stun any animal requiring it

Stunning equipment will be properly maintained.

Regular inspections of animal holding areas will be conducted.

Note: It is recommended that the animal holding area be checked at least once a week and that prompt action be taken to deal with anything that might cause an animal to be injured or uncomfortable.

REQUIREMENTS FOR AN AUDITABLE SYSTEM (MFS)

Requirements for “**Animal Welfare Audits - Red Meat Abattoirs**” will be met when:

1. Written “**Animal Welfare Procedures**” have been developed and implemented.
2. Responsible abattoir personnel have been properly trained in the humane handling of the types of animals handled at the facility.
3. The abattoir has successfully passed an “**Animal Welfare Audit**”.

Note: Any noted deficiencies will be corrected in time for the next audit or as directed.

4. On site observations demonstrate that:
 - a) animals are handled and slaughtered in an acceptable humane fashion;
 - b) animal handling facilities are kept in a good state of repair

RELATED SECTIONS OF TIPM

03-H-01 Audits - General

03-H-02 Annual Audits

03-H-03 Partial Audits

05-A-04 Livestock Yards & Holding Pens

05-A-05 Stunning & Bleeding Area

05-A-06 Segregation of Animals

05-B-01 Animal Transport Vehicles - Design & Maintenance

05-B-02 Delivery & Prompt Unloading

05-B-03 Handling of Live Animals in the Abattoir

05-B-04 Timely Slaughter

05-B-05 Sick or Non-ambulatory Animals

05-B-06 Stunning & Bleeding Practices



Meat Inspection Branch
Regulatory Services Division

**Animal Welfare Audit Report
for Red Meat Abattoirs**

Name of Facility	Region
Facility Number	Date
Plant Representative	Phone
Slaughtered Species	Fax

Audit History

DATE		AUDITOR	
Current			

To ensure animal welfare in abattoirs, a number of objective criteria can be utilized. By regularly measuring welfare indicators, problems can be detected and continuous improvements can be achieved.

Alberta Agriculture and Rural Development (ARD) is committed to animal welfare. When any criteria is not acceptable, the plant operator must take steps to correct the problems in a timely manner. A follow-up audit may be performed to evaluate corrective actions.

Please review Welfare Audit Checklist for More Detail

Ref No	Observations	Expected Correction Date	Status or Date Completed

Comments

Plant Representative _____	Branch Auditor _____
Date _____	Resident Inspector _____
Reviewed by _____	Date _____

Welfare Audit Checklist

Part 1 - Core Criteria

Item	The following critical control points are assessed while observing handling and slaughter.	
C 1	<p>Effective Stunning</p> <p>Animals are stunned correctly on the first attempt. Cattle and alternative livestock should be rendered insensible with one shot or first electrical stun at least 95% of the time.</p> <p>Pigs and sheep should be rendered insensible 99% of the time after the first try.</p>	<p>Acceptable or Unacceptable</p>
Comments		
C 2	<p>Bleed Rail Insensibility</p> <p>Any sensible animal on the bleed rail is unacceptable. It is critical that animals showing signs of a return to sensibility are re-stunned immediately.</p> <p>Stun to bleed time should be as short as possible.</p> <p>All animals must be completely insensible before procedures such as scalding, skinning, head removal or dehorning.</p>	
Comments		
C 3	<p>Slipping and Falling</p> <p>No animals observed should slip or fall anywhere in the facility during all phases of handling.</p> <p>A slip is when a knee touches the ground or a foot loses contact with the ground.</p>	
Comments		
C 4	<p>Vocalization</p> <p>Animals which moo, squeal, or bellow during handling will be scored. Vocalization should be minimal while individual animals are in the chute or entering the restrainer.</p> <p>Vocalization in sheep is not scored.</p>	
Comments		
C 5	<p>Electric Prod/ Instrument Use</p> <p>Electric prods should be used as a last resort. Up to 25% is acceptable for cattle, pigs, sheep and alternative livestock.</p>	
Comments		
C 6	<p>Willful Acts of Abuse</p> <p>Any willful act of abuse, like dragging a conscious animal, applying prods to sensitive parts of the animal, slamming gates on livestock, picking up sheep by the pelt/wool, purposefully driving livestock on top of one another, or hitting or beating an animal is not acceptable.</p>	
Comments		
C 7	<p>Access to Water and Feed After 24 hours</p> <p>Do animals in all holding pens have access to clean drinking water and feed after being held for 24 hours?</p>	
Comments		

Section 2 - Facility Criteria

Item	The following infrastructure features will be observed at each provincial plant.	
F 1	Unloading Area Is the unloading area adequate for the operations of the facility?	
Comments		
F 2	Stocking Density and Condition of Holding Pens Pens should be only 75% full. Are there adequate pens to allow separation for animals for humane considerations? (Examples, boars, cripples, immature animals) Are pens kept clean and dry? Is bedding provided if animals are held? Are animals sheltered from the elements?	
Comments		
F 3	Non Slip Flooring Does the plant have non-slip flooring? Non slip flooring is essential to prevent falls and crippling injuries.	
Comments		
F 4	Smooth Edges and Surfaces Gates, fences and chutes should have smooth surfaces to prevent bruises.	
Comments		
F 5	Slide gates in Chutes The use of vertical slide gates should not cause harm or injury of animals. The gate tracks should be recessed into the chute wall. The gates should be counter-weighted.	
Comments		
F 6	Lighting Is lighting being used to attract animals into chutes? Light should illuminate the chute up ahead or illuminate the entire chute area. It should never glare directly into the eyes of approaching animals.	
Comments		
F 7	Visual Distractions Are visual distractions at animal level present?	
Comments		
F 8	Sides of Chutes and Crowd Pens Crowd pens (and gate), and drive chutes should have solid sides.	
Comments		
F 9	Noise Reduction Animals are very sensitive to noise. Is the noise level reduced as much as possible?	
Comments		

Section 3 - General Questions

Item	The following questions will be helpful in gathering information about the facility. Simple yes or no answers are required.	
Q 1	Does the facility have a training program for its employees in the principles of good animal handling?	
	Comments	
Q 2	Does the facility have a written protocol or widely understood policy for handling non-ambulatory animals?	
	Comments	
Q 3	Are facility personnel trained in handling non-ambulatory animals?	
	Comments	
Q 4	Does the facility provide training to stunner operators to ensure proper equipment use and stunning efficacy? Are the stunning procedures monitored?	
	Comments	
Q 5	Does the facility have a written procedure or widely understood protocol to handle a sensible animal on the bleed rail? Are the workers trained in the protocol?	
	Comments	
Q 6	If mounting behaviors were observed, are animals that are chronically mounted removed from the pen?	
	Comments	
Q 7	Are non-electrical devices the primary tool used to move livestock?	
	Comments	
Q 8	Does the facility have a protocol for maintenance of stunning equipment?	
	Comments	
Q 9	Does the company perform weekly inspections of the livestock handling areas and equipment for damage or sharp protrusions that may injure animals?	
	Comments	
Q 10	Does the company have an emergency management plan for livestock?	
	Comments	

TECHNICAL INTERPRETATION POLICY MANUAL (TIPM)

SUBJECT: Animal Welfare Audits - Poultry Abattoirs	05-D-02
REGULATORY REFERENCES <i>AR 42/2003 Meat Inspection Regulation</i> (Consolidated to 112/2009) Sections 21, 22 & 22.1	Initial Release Sept 1, 2009
	Page 1 of 6
RATIONALE Section 21(1) of AR 42/2003 imposes a legal requirement, upon abattoir operators and personnel, to minimize pain and distress on animals, including poultry, while they are being slaughtered or prepared for slaughter. Note: In addition to this legal requirement there is also a moral and ethical requirement to handle birds in a humane manner. Mishandling of birds may be intentional, or unintentional. <u>Intentional abuse will not be tolerated.</u> Note: Un-intentional abuse can be prevented with training of abattoir personnel to ensure they have sufficient knowledge about humane handling of birds The Meat Inspection Branch (MIB) of the Regulatory Services Division (RSD) of Alberta Agriculture and Rural Development (ARD) is fully committed to animal welfare and will conduct regular “ Animal Welfare Audits ”. The intent of these audits is to promote continuous improvement of animal welfare through the observation of and measuring various objective indicators in order to correct any problems that may exist. Note: “ Animal Welfare Audits ” have three components: a) Animal Handling & Care (Core Criteria) b) Condition of the Animal Handling Facilities in the Abattoir c) A General Questionnaire Objective criteria, relating to the handling of birds and the condition of facilities will be assessed during an on site visit. The intent of the general questionnaire is to gather supplementary information about the abattoir. The purpose of this document is to provide information on the conduct of “ Animal Welfare Audits ” in poultry abattoirs.	
OBJECTIVE/OUTCOME Regular “ Animal Welfare Audits ” will be conducted at the abattoir. Note: The MIB will determine the frequency of the audits. Normally there will be partial audits conducted each year. At least one of these will deal with animal welfare. There may be a greater frequency of “Animal Welfare Audits” in abattoirs with animal welfare issues in the past. Part one (1) of the audit process consists of an evaluation of the following “ Core Criteria ”: 1. Stunning Stunning will meet the requirement of rendering 99% of birds insensible with the first application of an electric stunner.	

Note: It is critical that birds be observed for signs of effective stunning and if there is **any indication of sensitivity** they should be **re-stunned immediately**.

Visual evidence of a proper, or effective, stun is an arched neck and wings tucked in followed by complete relaxation, open eyes with a blank stare and loss of blink reflexes.

Birds showing any **signs of sensibility** must be **re-stunned immediately**.

It is absolutely essential for birds to be completely insensitive before entry into the scalding vat.

The stunning of at least **50 broilers**, or **fowl** and at least **25 turkeys, ducks or geese** will be observed at **low volume abattoirs** (generally those located on a Hutterite Colony). At **high volume** abattoirs a minimum of **100 broilers**, or **fowl** and **50 other types** of birds will be observed.

The same numbers will be observed in the evaluation of the next 4 criteria.

2. **Bleeding**

Following stunning the throats will be cut quickly and efficiently in a manner that induces a complete bleed out of the bird.

Note: For manual operations the bleeding knives must be sharp at all times.

To ensure efficient and effective operation of an automated throat slitting device the assembly must be adjusted frequently.

It is expected that a maximum of 2 out of 50 birds might miss the slitting machine thus back-up personnel must be situated immediately after the slitting machine to cut the throat of birds that are missed.

During the audit process the same number of birds will be observed as stated for high and low volume abattoirs as were observed for stunning.

3. **Scalding**

100% of birds will be bled out before entering the scalding vat.

Note: The entry of a single sensitive bird, into the scalding vat is totally unacceptable and will lead to failure of the audit.

4. **Crate Pick-up/Dumping, Bird Hanging**

The process of picking up loaded crates, removing, or dumping, of birds from them and hanging the birds on shackles will meet acceptable standards of humane care leading to minimal injuries and crate damage.

Note: Acceptable standards consist of:

- a) keeping crates in a horizontal position when they are moved;
- b) **not** throwing, or dropping the crates;
- c) lifting birds out of the crate by grasping their legs rather than by their wings, or neck;
- d) being gentle while hanging birds in shackles

5. **Carcass Inspection**

Carcasses will be evaluated for any evidence of dislocated, or broken legs, and wings.

Note: This evaluation provides a critical evaluation of the gentleness with which the birds were handled.

No more than 3% of birds (regardless of weight) should show these types of injuries.

Breaks and dislocations deemed to have occurred after the bird was dead will not be counted. When breaks, or dislocations, occur after the bird is dead there won't be any bleeding.

6. **Willful Acts of Abuse**

Willful acts of abuse will not be tolerated. If any are observed there will be automatic failure of the audit and corrective measures will be implemented immediately.

Note: Examples of willful acts of abuse include, but are not restricted to:

- a) throwing birds;
- b) kicking birds;
- c) stomping on birds;
- d) hitting, or beating, etc

Part two (2) of the audit process will consist of observing various aspects of catching, loading and transportation.

Note: Only some of the following categories will apply to every audit. For example it will be impossible to observe catching methods in an abattoir where the birds are trucked in from another location. Transportation is not a factor at Hutterite Colonies where the birds are stunned and bled in the barn then moved into the abattoir.

1. **Catching**

All birds must be caught in a manner that minimizes any chance of injury.

Note: Unacceptable practices include but are not restricted to:

- a) Picking up too many birds. Only 2 to 5 birds (depending on size) should be picked up, in each hand, at a time.
- b) Picking birds up by their wings, or necks.
- c) Rough handling while placing birds in cages, or crates.

The use of nets, or a screen, to corral birds at the loading door is an effective method of minimizing injuries.

2. **Barn Lighting**

Barn lighting should be low, or blue bulbs should be used to prevent injuries from piling up.

Note: The ideal is to provide adequate illumination for humans but not for the birds.

3. **Cage Cleanliness**

All cages must be clean before they are used.

4. **Ventilation**

Cages must be positioned in the transportation vehicle, or trailer, in a manner that allows the movement of air into the cages located in the center of the load.

5. **Cage Protection**

Birds must be protected from extremes of weather during transportation.

Note: Covers should be used to protect birds from wind, rain and cold temperatures.

Air temperatures should be maintained between 5^o C (42^o F) and 30^o C (86^o F).

Protective covering must be used to prevent the temperature from dropping below 5^o C.

When temperatures exceed 30^o C the truck has to be periodically moved a short distance, at a minimum speed of 30 km/hr. Alternatively the truck should be kept in the shade or in an area where the air is being circulated mechanically.

6. **Cage Maintenance**

All cages must be designed, constructed and maintained in a manner that allows birds to be loaded, conveyed and removed without injury.

Note: To be acceptable 95% of cages, or crates, must be in a good state of repair with no loose ends of wire, or broken plastic.

Cages, or crates, must be constructed in a manner that provides adequate, uniform ventilation but prevents protrusion of heads, wings, or legs.

7. **Cage Stocking Levels**

The number of birds in a cage, or crate, must be controlled so that there is room for all birds to lie down, at the same time, without piling up.

Note: The number of birds that can be put in a crate will vary with the size of the crate and the size of the birds. Prevailing environmental conditions, at the time of transportation, are also factors.

Loading of turkeys, at mid-day, on a hot day should be avoided and when temperatures exceed 32^o C birds should not be loaded unless they are scheduled for same day delivery.

Part three (3) of the audit process will consist of observing the following aspects of live receiving and slaughter.

1. **Ventilation in the Holding Shed**

There should be sufficient fans to ensure appropriate air movement during warm weather and there should be sufficient protection, from temperature extremes, during cold weather.

2. **Loose Bird Control**

Loose birds must be put back into cages, or onto the kill line, in an expedient and gentle manner.

TIPM – 05-D-02 Page 5 of 6 – OBJECTIVE/OUTCOME (continued)

Note: This is required to ensure that birds are not injured by moving trucks, or other moving hazards.

3. Birds Dead on Arrival (DOA)

The number of birds that are DOA must be within acceptable limits.

Note: A maximum acceptable level is 0.5%.

4. Lighting

There should be subdued lighting in the receiving area.

Note: Birds will settle down better with subdued lighting.

5. Bleed Time

A period of 90 to 120 seconds of bleeding time must elapse before birds enter the scalding vat.

Note: The lower time is for smaller birds. This time lapse is essential to ensure that birds are completely bled out before entering the scalding vat. An incompletely bled bird could regain consciousness.

6. Stunner/Electric Knife Function

All instruments used to stun and bleed poultry must be of an approved type and must be maintained in a manner that ensures they function properly.

Note: Proper maintenance of approved equipment provides greater assurance that birds will be killed in a humane manner.

The amount of current required will vary with the type of stunner, electric knife, or stunning cabinet in use. Generally a minimum of 120 miliamps of current is required for online stunners.

Salinity concentrations, if applicable, must be maintained.

Part four (4) of the audit process consists of the following general questions:

Does the abattoir:

1. Have a training program, in the principles of good handling of live birds?

Note: The purpose of this training is to ensure that responsible abattoir personnel understand how to properly handle live birds.

2. Provide training for stunner operators?

3. Have a written protocol for handling sensible birds on the bleeding rail?

Note: It is important to know whether responsible personnel know what to do in this situation.

4. Have a protocol for monitoring and maintaining stunning equipment?

5. Have an emergency plan in place?

Note: The purpose of this plan is to address the welfare of birds in the event of a mechanical or electrical failure leading to a shutdown, or extended stoppage of the line.

REQUIREMENTS FOR AN AUDITABLE SYSTEM (MFS)

Requirements for “**Animal Welfare Audits - Poultry Abattoirs**” will be met when:

1. Written “**Poultry Handling Procedures**” are on file.
2. Responsible personnel have been properly trained in the humane handling of poultry.
3. The abattoir has successfully passed an “**Animal Welfare Audit**”.


Note: Any noted deficiencies will be corrected in time for the next audit, or as directed.

4. On site observations demonstrate that:
 - a) birds are handled and slaughtered in an acceptable humane fashion;
 - b) crates are kept in a good state of repair

RELATED SECTIONS OF TIPM

- 03-H-01 Audits - General
- 03-H-02 Annual Audits
- 03-H-03 Partial Audits
- 05-A-04 Livestock Yards & Holding Pens
- 05-A-05 Stunning & Bleeding Area
- 05-A-06 Segregation of Animals
- 05-B-01 Animal Transportation Vehicles - Design & Maintenance
- 05-B-02 Delivery & Prompt Unloading
- 05-B-03 Handling of Live Animals in the Abattoir
- 05-B-04 Timely Slaughter
- 05-B-05 Sick or Non-ambulatory Animals
- 05-B-06 Stunning & Bleeding Practices

Attachment #1 - TIPM 05-D-02

	Meat Inspection Branch Regulatory Services Division	Animal Welfare Audit Report for Poultry Abattoirs	
Name of Facility		Region	
Facility Number		Date	
Plant Representative		Phone	
Slaughtered Species		Fax	
Audit History			
	DATE	AUDITOR	
Current			
Last:			
To ensure animal welfare in abattoirs, a number of objective criteria can be utilized. By regularly measuring welfare indicators, problems can be detected and continuous improvements can be achieved.			
Alberta Agriculture and Rural Development (ARD) is committed to animal welfare. When any criteria is not acceptable, the plant operator must take steps to correct the problems in a timely manner. A follow-up audit may be performed to evaluate corrective actions.			
Please review Welfare Audit Checklist for More Detail			
Ref No	Observations	Expected Correction Date	Status or Date Completed
Comments			
Plant Representative		Branch Auditor	
Date		Resident Inspector	
Reviewed by		Date	

Part 1 Core Criteria

Item	The following critical control points are assessed while observing handling and slaughter.	
C 1	Effective Stunning Birds are stunned correctly on the first attempt. Birds should be rendered insensible 99% of the time after the first electrical stun.	
Comments		
C 2	Bleeding Bleed cut must be effective.	
Comments		
C 3	Scalding Under no circumstances shall a live bird enter the scalding. There must be no uncut red birds. All birds that miss the bleed machine must be cut by the backup bleeder person.	
Comments		
C 4	Crate Pickup/Dumping, Bird Hanging Crates must be lifted and moved from the trailers in a careful manner as not to injure the birds or cause damage to crates. When birds are removed from the crates, they must not be handled by the wings or neck. Birds should be hung in a gentle manner to prevent leg breakage.	
Comments		
C 5	Carcass Inspection Monitor broken wings, broken or bruised legs, dislocated joints.	
Comments		
C 6	Willful Acts of Abuse Any willful act of abuse, like throwing birds, stomping on birds, broken plant equipment that causes visible bird injury, or crushes them, or hitting or beating a bird, or putting live birds in the trash is not acceptable.	
Comments		

Part 2 - Catching/Loading/Transportation

Item	The following features will be observed at catching and loading (if applicable).	
F 1	Catching Is catching causing injury to birds? It is recommended that catchers should handle no more than 2-5 birds depending on their size. Birds should never be caught or carried by their wings or neck.	
Comments		
F 2	Barn Light Levels Are lighting levels in the barn reduced to aid in bird catching?	
Comments		
F 3	Cage Cleanliness Are cages clean prior to being loaded?	
Comments		
F 4	Ventilation Are cages placed on the trailer in a way to move air through the centre?	
Comments		
F 5	Cage Protection Are cages adequately covered in the event of inclement weather, either hot or cold?	
Comments		
F 6	Cage Maintenance Must have 95% of the chicken compartments in good repair. No loose wire ends or broken plastic parts.	
Comments		
F 7	Cage Stocking Levels Birds have enough room to all lie down at the same time without being on top of each other.	
Comments		

Part 3 - Plant Live Receiving/Slaughter

Item	The following infrastructure features will be observed at each provincial plant.	
P 1	Holding shed/Live Receiving Ventilation	
	The holding shed/live receiving should have sufficient fans to ensure all birds are exposed to proper air movement in hot conditions and protected from the cold in adverse weather conditions.	
	Comments	
P 2	Loose Bird Control	
	Loose birds are to be placed back into cages/kill line in a expedient and gentle manner.	
	Comments	
P 3	DOA's	
	The number of Dead On Arrival birds at the plant should be minimized. A maximum of 0.5% is acceptable.	
	Comments	
P 4	Lighting	
	The lighting in the live-receiving area must be subdued to allow the birds to settle during hanging.	
	Comments	
P 5	Bleed Time	
	Bleed time should be adjusted to ensure proper bleeding prior to scalding. Time should be adjusted according to bird size. Typically this is 90-120 seconds.	
	Comments	

Section 4 - General Questions

Item	The following questions will be helpful in gathering information about the facility. Simple yes or no answers are required.	
Q 1	Does the facility have a training program for its employees in the principles of good animal handling?	
	Comments	
Q 2	Does the facility provide training to stunner operators to ensure proper equipment use and stunning efficacy? Are the stunning procedures monitored?	
	Comments	
Q 3	Does the facility have a written procedure or protocol to handle a sensible bird on the bleed rail? Are the workers trained in the protocol?	
	Comments	
Q 4	Does the facility have a protocol for the monitoring and maintenance of stunning equipment?	
	Comments	
Q 5	Does the facility have an emergency plan in place to address bird welfare in the event of a mechanical or electrical failure leading to a shutdown or extended line stoppage?	
	Comments	