Guideline
Slaughtering/Deboning
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1 Fundamentals

You can find basic information on the QS scheme such as organisation, participation conditions, use of the QS certification mark and sanction procedures in the Guideline “General Regulations”.

1.1 Scope

Slaughtering/Deboning of red and white meat (meat, innards and by-products suitable for foodstuff)

Slaughtering/deboning companies are entitled to trade and store QS meat and QS meat products. A separate certification for the production scope meat wholesale is not required. With the approval on this stage in the QS scheme they are entitled to produce minced meat and seasoned/marinated meat products, cuts of meat or portion and pack meat.

The following requirements apply to slaughtering/deboning businesses and relate to all processes that take place on the production site.

1.2 Responsibilities

The scheme participant is responsible for ensuring:

- The compliance with the requirements,
- The complete and correct documentation,
- The self-assessment,
- The adequate and timely implementation of corrective actions,
- The correct use of the QS certification mark and product labelling.

The scheme participant must always comply with the requirements of the QS scheme and be able to demonstrate compliance with said QS requirements. They must ensure compliance not only with the requirements of this guideline and all related documents (Guideline "General Requirements", Guideline "Salmonella monitoring pig", Guideline "Salmonella monitoring and reduction programme for poultry meat production", Guideline “Diagnostic Data in Poultry Slaughtering”, Guideline "Livestock Transport", Guideline "Certification" and “Paper of incident”) but also with the applicable legal provisions both within the country in which the QS products are produced as well as the country in which they will be marketed by the scheme participant.

2 General requirements

2.1 General scheme requirements

2.1.1 General Business data

The following master data must be entered in the database by the scheme participants and always be kept up to date:

- Address of main company and all production sites with EU approval numbers
- Company name
- Phone number, e-mail address, legal representative, contact
- Crisis manager
- Details of the type of company and on the production (e. g. slaughtering of red meat, deboning of white meat, etc.)
- Number of slaughtered animals
- Details on the working hours
In addition, a business overview must be drawn up (existing documentation may be used, e.g. QM or HACCP), which as well as the information listed above also includes the following data:

- All production and storage sites with EU approval numbers (this includes external companies, e.g. frozen storage; where rooms are shared by several companies, all rooms belonging to the company must be identified in a business plan.)
- Details of existing quality management and audit systems (e.g. ISO 9001, IFS, BRC)
- Commissioned laboratories (current address, phone number, e-mail address) and their fields of analysis

Company overview/QS database

2.1.2 Incident and crisis management

QS has developed a comprehensive crisis management system that ensures the provision of active support to scheme participants in the event of an incident or crisis. The scheme participants must inform QS immediately and - where a legal obligation exists - also the competent authorities about critical incidents and public product recalls where these are of relevance for the QS scheme.

Critical incidents are occurrences that pose or could pose a risk to humans, animals, assets or the QS scheme as a whole.

In particular, the scheme participants must inform QS in cases in which:

- Nonconformities occur in the procurement of goods, or in production or marketing that might pose a risk to food safety,
- Preliminary proceedings are initiated due to violation of regulations to secure food safety or regarding animal welfare
- Investigations are carried out by the media, there are critical reports in the media, or public protests are held on issues of food safety.

All scheme participants must have access to a paper of incident so that they can pass on all necessary information in a targeted manner in the event of an incident. Moreover, all scheme participants must name a crisis officer, and this officer must always be reachable. The name of the crisis officer must be entered in the QS database.

A procedure of conduct in the event of incidents or crises must be defined and implemented, as well as verified at regular intervals, but at least once a year (approx. every 12 months).

It must include the following points:

- Creation of a crisis team
- Emergency call list
- Procedure for product recall and return
- Communication plan
- Customer information

Paper of incident, procedure for conduct in the event of incidents or crises

2.1.3 Food safety culture

The food company has introduced an appropriate food safety culture in accordance with Reg. (EC) No. 2021/382. Roles and responsibilities for all processes related to food safety are clearly regulated. The staff are adequately trained and supervised. The food company must ensure that the food safety culture is implemented and up to date.
2.1.4 Commissioning of service providers

Storage
The scheme participant may only commission companies with the storage of QS meat and QS meat products that have a QS approval which includes the requirements for the storage of meat and meat products.

Transport
Initially, transport companies that carry meat and meat products on behalf of QS scheme participants can become voluntarily certified in accordance with the new guideline. From 1st January 2024, after a two-year transition period, certification shall become mandatory for all transport service providers engaged by QS scheme participants.

Note: If logistics companies are hired to transport QS produce in the short term or as a one-off (due to high seasonal demand, e.g. as part of day contracts), nonconformity with the obligation to only use QS-approved transport companies is permitted.

Scheme participants at the processing stage with their own transportation vehicles are not required to hold a separate certification.

2.2 Company management

The production process must be organised in line with REG (EC) No 852/2004 that contamination of food stuff is prevented.

2.2.1 Handling of documents

A procedure for archiving the documentation must be in place and applied in the company. All relevant records must be kept in a detailed and seamless manner. The documents and records of internal inspections must be retained for a period of at least two years – provided that no longer retention periods are stipulated by law.

2.2.2 Company Premises and Access Regulations

All buildings and operating facilities must be protected from unauthorized access and be kept closed. For this reason, an access regulation must be defined. Operating sites in which food is produced or stored may not be accessible to unauthorized persons. Outside persons may only have access to the operating areas accompanied by authorization or by permission. All external personnel with the exception of drivers loading their transport vehicles, must receive instructions prior to entering production areas. If external vehicles, e.g. livestock transports or disposal vehicles, enter the business premises, the potential risks involved must be considered.

Access regulations

2.3 Self-assessment and HACCP

2.3.1 [K.O.] Conducting self-assessment

Testing methods – limit and reference values

The specifications of the currently valid version of REG (EC) No 2073/2005 (or equivalent inspection methods) are used for testing. The adequate analytical reference methods are:

- Testing for Salmonella: ISO 6579 or PCR
- Aerobic colony count: ISO 4833 prior to cooling
- Enterobacteriaceae: ISO 21528-2 prior to cooling
- Campylobacter: ISO 10272-2 after cooling
- Escherichia coli: ISO 16649-1 or 2
The company is required to adhere to sampling plans (see tab. 1 and tab. 2). The analysis must be done accordingly to the standard procedure. A trend analysis must be carried out and measures must be taken in the event of unsatisfying or negative results.

**Examination of carcasses**

**Sampling frequency**

Five samples per week must be taken on one slaughtering day each – with typical distribution over the slaughtering process – on varying days of the week (rotation principle).

**Sampling method**

**Cattle, calves and pigs**

When sampling for Salmonella testing, samples must be taken using an abrasive sponge. Locations should be chosen where the probability of contamination is greatest (ham, belly, back and jowl at the pig and rump, flank, brisket and neck at the cattle). The total sampling surface must cover an area of at least 400 cm².

When sampling to test for *Enterobacteriaceae* and the aerobic colony count, a choice can be made between destructive and non-destructive methods in line with REG (EC) No 2073/2005.

The "punching sample" method can be used; it is tried and tested and shows a high rate of bacteria recovery:

- Punching samples: area of 4 x 5 cm² (to test for *Enterobacteriaceae* and the aerobic colony count)

If tests are also to be conducted for Salmonella by means of a "punch sample", the following conditions must be satisfied:

- The responsible food company must prove to the responsible authority that the sensitivity of the punch sample does not deviate considerably or systematically from that of the prescribed scratching sponge method and
- that the punch sample is a "method with at least equivalent guarantees".

Sampling is to be executed when entering cold storage or, where electrocution was used, in the post-cold storage room, provided that no alternative official approval is available.

**Poultry**

When testing for Campylobacter and Salmonella, sampling must be differentiated according REG (EC) No 2073/2005 Annex I, Chapter 3.2 whether the tests for Salmonella and Campylobacter are carried out in one laboratory or in different laboratories.

**Note:** If limit values are exceeded, in Germany the document "Fleischhygiene zur Prävention lebensmittelhygienischer Risiken bei der Geflügelschlachtung" (issued by the working group on meat and poultry meat hygiene and issues relating to foodstuffs of animal origin, available only in German) provides information for the introduction of improvement measures.
Tab. 1: Process hygiene criteria\(^{(1)}\) for carcasses after trimming and prior to cooling and meat and meat products upon the manufacturing process (from REG (EC) No 2073/2005)

<table>
<thead>
<tr>
<th>Food category</th>
<th>Microorganisms</th>
<th>Sampling plan(^{(2)})/Limit values</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cattle carcasses</td>
<td>Aerobic colony count(^{(3)})</td>
<td>m=3.5 and M=5.0 log CFU/cm(^2) daily mean log</td>
</tr>
<tr>
<td></td>
<td>Enterobacteriaceae (^{(3)})</td>
<td>m=1.5 and M=2.5 log CFU/cm(^2) daily mean log</td>
</tr>
<tr>
<td></td>
<td>Salmonella</td>
<td>n=50(^{(4)}) and c=2(^{(5)}) not detected in the area tested per carcass(^{(6)})</td>
</tr>
<tr>
<td>Pig carcasses</td>
<td>Aerobic colony count(^{(3)})</td>
<td>4.0 and 5.0 log CFU/cm(^2) daily average log value</td>
</tr>
<tr>
<td></td>
<td>Enterobacteriaceae (^{(3)})</td>
<td>2.0 and 3.0 log CFU/cm(^2) daily average log value</td>
</tr>
<tr>
<td></td>
<td>Salmonella</td>
<td>n=50(^{(4)}) and c=3(^{(5)}) not detected in the area tested per carcass(^{(6)})</td>
</tr>
<tr>
<td>Poultry carcasses of broilers and turkeys</td>
<td>Salmonella spp.(^{(7)})</td>
<td>n=50(^{(4)}) and c=7(^{(5)}) not detected in 25 grams of a pooled sample of neck skin(^{(3)})</td>
</tr>
<tr>
<td>Carcasses of broilers</td>
<td>Campylobacter spp.</td>
<td>n=50(^{(4)}) and c = 15(^{(8)}) from 1.1.2025: c = 10 1.000 CFU/g(^{(6)})</td>
</tr>
<tr>
<td>Minced meat</td>
<td>Aerobic colony count(^{(9)})</td>
<td>n=5 and c=2</td>
</tr>
<tr>
<td></td>
<td></td>
<td>m=5x10(^5) and M=5x10(^6) CFU/g</td>
</tr>
<tr>
<td></td>
<td>Escherichia coli(^{(10)})</td>
<td>n=5 and c=2</td>
</tr>
<tr>
<td></td>
<td></td>
<td>m=50 and M=500 CFU/g</td>
</tr>
<tr>
<td>Meat preparations</td>
<td>Escherichia coli(^{(10)})</td>
<td>n=5 and c=2</td>
</tr>
<tr>
<td></td>
<td></td>
<td>m=500 and M=5.000 CFU/g or cm(^2)</td>
</tr>
</tbody>
</table>

\(^{(1)}\) "Process hygiene criterion": a criterion that specifies the acceptable functionality of the manufacturing process. Such a criterion does not apply to goods already in the trading process. It is used to define a reference value for the level of contamination that calls for corrective actions to be implemented when this value has been exceeded in order to maintain process hygiene in compliance with food law.

\(^{(2)}\) \(n = \text{number of units comprising the sample; } c = \text{number of sample units giving values between } m \text{ and } M\)

\(^{(3)}\) The limits \((m \text{ and } M)\) shall apply only to samples taken by the destructive method. The daily mean log shall be calculated by first taking a log value of each individual test result and then calculating the mean of these log values.

\(^{(4)}\) The 50 samples shall be derived from 10 consecutive sampling sessions in accordance with the sampling rules and frequencies laid down in REG (EC) No 2073/2005.

\(^{(5)}\) The number of samples where the presence of Salmonella is detected. The \(c\) value is subject to review in order to consider the progress made in reducing the Salmonella prevalence. Member States or regions having low Salmonella prevalence may use lower \(c\) values even before the review.

\(^{(6)}\) \(m=M\)

\(^{(7)}\) Where \(\text{Salmonella spp.}\) is found, the isolates shall be further serotyped for \(\text{Salmonella typhimurium}\) and \(\text{Salmonella enteritidis}\) in order to verify compliance with the microbiological criterion set out in REG (EC) No 2073/2005.

\(^{(8)}\) Satisfactory, if a maximum of \(c/n\) values are > \(m\), unsatisfactory, if more than \(c/n\) values are > \(m\).

\(^{(9)}\) This criterion shall not apply to minced meat produced at retail level, provided that the shelf life of the product is less than 24 hours.

\(^{(10)}\) \(E.\text{coli}\) is used here as an indicator for faecal contamination.
Tab. 2: Food safety criteria\(^{(1)}\) regarding meat and meat product put into circulation during the shelf-life (excerpt from REG (EC) No 2073/2005)

<table>
<thead>
<tr>
<th>Food category</th>
<th>Microorganisms</th>
<th>Sampling plan(^{(2)}/Limit values)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minced meat and meat preparations intended to be eaten raw(^{(3)})</td>
<td>Salmonella</td>
<td>(n=5) and (c=0) not detected in 25 g</td>
</tr>
<tr>
<td>Minced meat and meat preparations made from poultry meat intended to be eaten cooked(^{(3)})</td>
<td>Salmonella</td>
<td>(n=5) and (c=0) not detected in 25 g</td>
</tr>
<tr>
<td>Minced meat and meat preparations made from other species than poultry intended to be eaten cooked(^{(3)})</td>
<td>Salmonella</td>
<td>(n=5) and (c=0) not detected in 10 g</td>
</tr>
<tr>
<td>Meat products intended to be eaten raw, excluding products where the manufacturing process or the composition of the product will eliminate the Salmonella risk(^{(3)})</td>
<td>Salmonella</td>
<td>(n=5) and (c=0) not detected in 25 g</td>
</tr>
<tr>
<td>Meat products made from poultry meat intended to be eaten cooked(^{(3)})</td>
<td>Salmonella typhimurium(^{(5)})</td>
<td>(n=5) and (c=0) not detected in 25 g</td>
</tr>
<tr>
<td>Fresh poultry meat(^{(3)})(^{(4)})</td>
<td>Salmonella enteritidis(^{(5)})</td>
<td>(n=5) and (c=0) not detected in 25 g</td>
</tr>
</tbody>
</table>

\(^{(1)}\) “Food safety criteria”: a criterion which determines the acceptability of a product or a lot of food and which applies on products in the market.

\(^{(2)}\) \(n = \) number of units comprising the sample; \(c = \) number of sample units giving values between \(m\) and \(M\)

\(^{(3)}\) \(m=M\)

\(^{(4)}\) This criterion shall apply to fresh meat from breeding flocks of Gallus gallus flocks, laying hens, broilers and breeding and fattening flocks of turkeys.

\(^{(5)}\) As regards monophasic Salmonella typhimurium only 1,4[5],12:i:- is included.

In case that other products are made than the ones in the food categories mentioned above the product hygiene can also be determined with the following guidance and warning values.

Tab. 3: Reference and critical values of raw beef, raw pork and raw poultry\(^{(a)}\) for orientation

<table>
<thead>
<tr>
<th>Microorganisms</th>
<th>guidance value (CFU/g)</th>
<th>critical value (CFU/g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Enterobacteriaceae</td>
<td>1x10(^{4})</td>
<td>1x10(^{5})</td>
</tr>
<tr>
<td>Escherichia coli (beef and pork)</td>
<td>1x10(^{2})</td>
<td>1x10(^{3})</td>
</tr>
<tr>
<td>Escherichia coli (poultry)</td>
<td>5x10(^{2})</td>
<td>5x10(^{3})</td>
</tr>
<tr>
<td>Coagulase-positive Staphylococcus</td>
<td>5x10(^{2})</td>
<td>5x10(^{3})</td>
</tr>
<tr>
<td>Listeria monocytogenes(^{(b)})</td>
<td>---</td>
<td>1x10(^{2})</td>
</tr>
<tr>
<td>Pseudomonas</td>
<td>1x10(^{6})</td>
<td>---</td>
</tr>
<tr>
<td>Salmonella</td>
<td></td>
<td>not detected in 25 g</td>
</tr>
<tr>
<td>Aerobic colony count (pork and poultry)</td>
<td>5x10(^{6})</td>
<td>---</td>
</tr>
</tbody>
</table>

\(^{(a)}\) not seasoned or pre-packaged

\(^{(b)}\) For detection and assessment of L. monocytogenes the requirements of REG (EC) No 2073/2005 must be observed.

**2.3.2 Listeria monitoring**

A listeria monitoring procedure in line with legal requirements is implemented within the company and includes (if required in accordance with Art. 5 Reg. (EC) No. 2073/2005) examinations of processing areas and equipment for Listeria monocytogenes. Sampling takes place during processing and after
cleaning and disinfection. The requirements of the German ordinance on monitoring zoonoses and zoonotic agents in the food industry (ZoonoseV) or the equivalent national legislation must be observed.

2.3.3 [K.O.] HACCP concept

The company must develop, apply and maintain a system for hazard control in line with HACCP principles (REG (EC) No 852/2004) in order to ensure food safety that is comprehensible for third parties.

The foundation and prerequisite for implementing a HACCP system is to have basic hygiene measures in place that include codes of practice for good hygiene practice (GHP) and good manufacturing practice (GMP).

The process from the incoming goods stage to the outgoing goods stage must be such that contamination of raw materials, partially processed products, finished products, packaging materials, machines and all other substances coming into contact with the foods is avoided. It must be ensured that effective measures are taken to minimise physical and/or microbiological and/or chemical contamination.

If changes that are HACCP-related are made to a product, a manufacturing process or a production, processing, storage or sales stage, the company must review and if applicable modify the HACCP concept. The thawing and tempering of goods must be considered process-specifically in the HACCP concept.

- Self-assessment records, checklists

2.3.4 HACCP-Team

To develop an efficient HACCP concept, the requisite knowledge must be available. The HACCP-Team must be documented in a written form. If required, the HACCP-Team must be trained. In this case, record of the training must be kept.

2.3.5 Product description

A complete description of the product / the article group must be compiled, and the intended purpose must be defined. This must include:

- Composition of the product/the article group
- Physical and chemical structure
- Antimicrobial/Static treatment
- Packaging
- Shelf life
- Storage conditions
- Distribution channels (e. g. foreign countries/inland, status, loose goods/prepacked, etc.).

2.3.6 Flow chart

A schematic flow chart must be prepared. The flow chart must include all operating processes and product groups.

2.3.7 Hazard analysis

The HACCP concept is based on the determination of hazards that must be avoided, eliminated or reduced to an acceptable level.

2.3.8 Critical control points (CCP)

Critical control points must be defined if control is required, in order to avoid, eliminate or reduce any hazards to an acceptable level.
2.3.9 Limit values for CCP
Limit values for the critical control points must be defined with regard to the avoidance, elimination or reduction of identified hazards.

2.3.10 Monitoring and verification of limit values for CCP
Procedures for monitoring and verifying critical control points must be defined and implemented. These procedures must be applied regularly.

2.3.11 Corrective actions for CCP
Corrective measures must be defined if monitoring shows that a critical control point exceeds the set limit values.

2.3.12 Responsibilities
Responsibilities must be clearly defined in an organigram.

2.3.13 Documentation
Records suited to the type and size of the abattoir in order to verify that the actions outlined in 2.3.1 to 2.3.12 must be implemented.

2.3.14 HACCP verification
The implementation of the HACCP concept must be checked (verified) at least once a year (approx. every 12 month).

2.4 Good manufacturing and hygiene practice

2.4.1 Water quality
Irrespective of origin and aggregation state, water that is used for the manufacture, treatment, conservation or marketing of food as well as the cleaning of objects and facilities that come into contact with food must comply with the current version of the Drinking Water Ordinance. Drinking water must be provided in suitable quantities and may not pose any risk of contamination.

A risk-based sampling of the tapping points must take place in line with the latest version of the German drinking water ordinance (TrinkwV). Water or ice that is used as an ingredient and/or to treat food during the production process, or that is used for cleaning objects and equipment (which may come into contact with food within the scope of their intended use), must be subject to risk-based sampling in accordance with Purpose C of DIN EN ISO 19458.

The method and frequency is to be stipulated in the company's sampling plan.

- Tapping point plan

2.4.2 Cleaning and disinfection
Based on a risk analysis, cleaning and disinfection plans must be drawn up that detail the following:

- Responsibilities
- Used products and their instructions for use
- Areas and plants (incl. cooling areas and break rooms) requiring cleaning or disinfection
- Cleaning intervals
- Recording obligations
- Hazard symbols (if required)

Implementation of the cleaning and disinfection plans must be documented.

- Cleaning and disinfection proof
Training

Cleaning personnel must undergo training that includes first aid and labelling practices.

Requirements for the monitoring of cleaning and disinfection measures

To facilitate microbial monitoring of the cleaning and disinfection measures, a risk-based sampling plan is available, which adequately takes into account the physical scale of the business, the complexity of the production processes and the type and quantity of the products. The examinations must be repeated within a time scale of 4–8 weeks as a minimum.

Sampling

Sampling should be carried out before the start of production in areas that have a direct influence on product hygiene (e.g. knives, knife sterilizers). Once selected, sample extraction points should be used on an alternating basis. Sampling must be performed in line with a recognised procedure and defined in a sampling plan. Furthermore, the requirements of the current version of the Regulation on the monitoring of zoonoses and zoonotic agents in food law must be considered.

Assessment

In order to determine the hygienic status of a company, the samples must be tested for aerobic colony count as well as Enterobacteriaceae and Listeria. The assessment should be repeated within 4 weeks. The assessment can be conducted according to the assessment schedule (see tab. 4).

Tab. 4: Assessment schedule for monitoring the success of cleaning and disinfection

<table>
<thead>
<tr>
<th>Area</th>
<th>Bacteria type</th>
<th>Limit</th>
</tr>
</thead>
<tbody>
<tr>
<td>Surfaces that get in contact with food: immediately after cleaning and disinfection</td>
<td>Aerobic colony count</td>
<td>&lt;100 CFU/100 cm²</td>
</tr>
<tr>
<td></td>
<td>Enterobacteriaceae</td>
<td>0 CFU/100 cm²</td>
</tr>
<tr>
<td></td>
<td>Listeria spp.(1)</td>
<td>0 CFU/100 cm²</td>
</tr>
<tr>
<td>Surfaces that get into contact with food: immediately before production</td>
<td>Aerobic colony count</td>
<td>&lt;10 CFU/cm²</td>
</tr>
<tr>
<td></td>
<td>Enterobacteriaceae</td>
<td>&lt;1 CFU/cm²</td>
</tr>
<tr>
<td></td>
<td>Listeria spp.(1)</td>
<td>risk based depending on the product</td>
</tr>
</tbody>
</table>

(1) According to REG (EC) No 2073/2005 food manufacturer that produce ready to eat foods which may put public health at risk because of L. monocytogenes must analyse samples the working areas and work equipment in regard to L. monocytogenes.

Feedback

The results are to be reported to the responsible cleaning staff as quickly as possible and corresponding measures implemented (e.g. training/instruction, checking the cleaning equipment and agents, maintenance of cleaning equipment, monitoring of the cleaning process), particularly if the results are unsatisfactory. The implemented measures must be documented.

Cleaning and disinfection plans, sampling logs, measures

2.4.3 Pest control

It must be ensured that a high level of cleanliness and hygiene is maintained in all work/storage areas in order to prevent the attraction of pests and vermin. In the operating rooms, precautionary measures
must be taken to repel pests that adversely affect food. Appropriate measures for pest monitoring or, if necessary, for pest control must be introduced.

Within the implementation of pest monitoring and control, measures and qualifications of the user must comply with the legal requirements of the country as well as the particular product specifications. Monitoring and bait points need to be controlled at least every month as long as no other control interval is determined on the basis of a risk assessment. In order to guarantee the safety of the food as well as that of the employees, suitable pest control methods and pesticides must be used. This pest control treatment must not endanger the safety of the produced or stored products.

A permanent baiting (without infestation) with rodenticides is only permissible in exceptional cases if the implementation takes place via a professional and qualified pest controller who meets the legal requirements of the appropriate country. The exceptional case needs to be proven and documented in the context of an annual risk assessment of the pest controller. Only baits that are approved for this purpose may be used, if applicable, different legal regulations apply abroad and must be complied with accordingly.

The documentation must contain at least the following information:

- Information on used products for pest prevention and control
- Date of treatment as well as the specification of the applied quantities
- Proof that the employees involved in pest control are suitably qualified
- Checkpoint plans showing the positioning of monitor- and bait stations
- Records of pests found (findings)
- Measure plans in case of pest infestation
- Documentation of pest control

2.4.4 Foreign substance management

An appropriate and effective foreign matter management has been implemented in the company, which excludes or reduces the entry of foreign matter into food. Based on risk assessments, hazards and possible sources of entry must be identified and evaluated for at least the following categories of foreign matter:

- metal
- hard plastic
- soft plastic
- glass
- stone
- pests
- paper
- wood
- lubricants
- lacquers / Coatings (Teflon)
- species-specific foreign matter (e.g. bone, cartilage)

In general, foreign matter detectors (e.g. X-ray or metal detectors) should be used, the necessity is checked in a risk assessment. Detection limits, functional tests (including rejection) for the individual devices are defined and are demonstrably complied with. For products to be delivered to the final consumer, a technically possible detection size for metallic foreign matter of <7mm should be ensured. The devices are serviced annually according to the manufacturer’s specifications. Plastics that are in direct contact with food should preferably have a clear colour contrast (excluded from this are e.g. red E2 boxes customary in the industry). Before the production starts, each machine/plant must be inspected for damage. In case foreign matter (including metal-detected units) are found, measures must be defined.
and product hazards must be safely excluded. Foreign matter findings are categorised, the frequency of occurrence, the cause of entry and the measures taken are evaluated (e.g. evaluation of complaints, process inspections, error messages).

The responsible employees must be trained regularly on the prevention and control measures.

### 2.4.5 Production permission

Before production begins each day, a site inspection must take place for the production area to be approved. An optical check of successful cleaning as well as damages must be performed. This approval must be documented in a corresponding form.

In case of deviations corrective measures must be defined. Implementation of the corrective actions is documented.

- Documentation of the production permission, Implementation of corrective measures

### 2.4.6 Maintenance and repair

To guarantee that all processes can be performed in a hygienic and safe fashion, a maintenance plan including planned maintenance measures must be compiled and implemented for all business premises, facilities and equipment (e.g. stunning equipment) that serve to ensure or have a direct influence on product safety. Maintenance work must not compromise food safety. Maintenance and repairment work must be documented.

The maintenance plan must include the following elements:

- (Business) areas and operations rooms
- Facilities and (internal) transport systems
- Conformity of the used excipients and lubricants
- Responsible employees (own staff or from external companies)
- Frequency

- Maintenance plan, documentation of maintenance and repairment work

### 2.4.7 Monitoring of Test Equipment

When calibrating and monitoring the functionality of the instruments and devices used as test equipment (e.g. thermometers), the intervals stipulated by the manufacturers must be complied. If a manufacturer has not made any specifications in this regard, the test equipment must be calibrated or checked in line with the perceived estimation of the risk but at least once a year (approx. every 12 months). The measuring methods of the various test devices must be taken into consideration. The calibration or check procedure is described for each test device. The results must be documented, and clearly traceable to each piece of test equipment (incl. deviations, corrective actions). The measuring precision, reliability and functionality of operational test equipment must be guaranteed.

- Proof of calibration and surveillance of measuring equipment

### 2.4.8 [K.O.] Cross-contamination

During production, it must be ensured that no cross-contamination takes place between products. Contamination with other products must be completely ruled out, especially when processing products that contain allergens. For this purpose, the appropriate guidelines and work instructions must be in place within the company. Team members must be adequately trained.

Allergen management procedures incorporate the following as a minimum:
2.5 Technical/structural condition

In line with REG (EC) No 852/2004, Annex II, facilities involved in the handling of food and rooms in which food products are stored, prepared, treated or processed must be well maintained and clean. They must be designed and built in such a way that they permit adequate cleaning and/or disinfection, avoid airborne contamination or reduce it to a minimum level and ensure that sufficient work surface is available to permit proper and hygienic work steps.

All rooms in which foods are stored, prepared, treated or processed must be designed and built in a way that ensures proper food hygiene and prevents contamination between and during work steps. An overall plan for the business in terms of the flow of goods and labour and the allocation of hygiene zones is defined in proportion to the sensitivity of the product.

The following requirements must be fulfilled:

- All floor and wall coverings must be kept in a flawless condition and must be easy to clean and, if required, easy to disinfect. They must be waterproof, water-repellent and abrasion-resistant and consist of non-toxic material. Where applicable, floor surfaces must be fitted with a suitable drainage system. Wall areas must have a smooth surface up to the height that is appropriate for the work processes that are performed.
- Ceilings (or if there are no ceilings, interior roofs) and ceiling structures must be built and treated in such a way that any accumulation of dirt is avoided and that condensate, undesired mould and the peeling away of material particles is reduced to an absolute minimum.
- Windows and other openings must be designed in a manner that avoids the accumulation of dirt. Openings extending outward require insect mesh that can be easily removed for cleaning. If opened windows promote contamination, they must remain closed and sealed during the entire manufacturing process.
- Doors must be easily cleaned, and if required, disinfected. They must have water-repellent and smooth surfaces.

Surfaces (including equipment surfaces) in areas in which food materials are handled, and in particular surfaces that come into contact with food, must be kept in a flawless condition and must be easy to clean and, if required, to disinfect. They must be made of smooth, abrasion-proof, corrosion-proof and non-toxic material.

2.6 Room, equipment and plant hygiene

All rooms, plants and machines in which foods are stored, prepared, treated or processed must be in a clean, hygienic and dirt free condition. Pooling of water in "dead areas" and larger patches of corrosion on the equipment and machines must be avoided. Equipment (knives, saws, etc.) are to be kept functional and clean.

2.7 Ground Clearance

Products may not come into direct contact with the floor. The goods must be stored and transported in such a way that there is no risk of contamination. Containers approved for the transport of foods may not stand directly on the ground and must be kept on pallets or mobile plates.

This does not apply to industrial containers (e. g. BIG Boxes), whose runners and legs are concepted to be standing on the floor. In case these containers are stacked, internal rules must be followed so that a contamination is prevented.
2.8 Staff hygiene

2.8.1 General rules of conduct

Documented guidelines must be in place for staff hygiene and communicated to staff during training sessions. The staff hygiene guidelines must be followed and observed by all persons (employees, service providers, etc.). The guidelines must at least cover the following points:

- Cleaning and disinfection of hands
- Eating, drinking, smoking and chewing gum
- Steps to be taken in the event of any injuries
- Fingernails, jewellery, piercings and watches
- Hair and beards

Each member of staff must be provided with adequate protective clothing as well as headgear (eventually beard protection). There must be sufficient options to ensure hand hygiene and instruction signs on use of the disinfectant. Hand hygiene facilities in the production area must at least fulfil the following requirements:

- Running hot and cold water from hands-free fixtures (sensors/knee switches)
- Liquid soap and disinfectant from dispensers
- Device for hygienic hand drying

If coat hooks are present, they must be mounted in a suitable and appropriate location.

A process must be in place for the regular monitoring of systematic implementation of staff hygiene in the company. The findings must be evaluated, and optimisation measures taken where necessary. All persons whose activities directly affect product safety must have the necessary experience/training.

 Procedure for implementation and monitoring of staff hygiene

2.8.2 Staff rooms and sanitary facilities

Staff and external persons must have access to suitable changing rooms. Outdoor and protective clothing must be stored separately. The sanitary facilities and staff rooms must be in a clean condition. If showers are available, they must be intact and properly maintained.

2.8.3 [K.O.] Hygiene sluice

All individuals may only enter the production area through an inevitable hygiene sluice (exceptions are only allowed in the event of an emergency). Shoes and hands must be cleaned and disinfected thoroughly.

2.9 Training of staff

2.9.1 [K.O.] Hygiene training/Protection against Infection Act

Based on REG (EC) No 852/2004, hygiene training courses are to be held in the company every year (approx. every 12 month). Documented training programmes must be defined for employees in line with the product requirements and their areas of activity.

This training plan must contain the following points:

- Contents
- Training intervals
- Participants and trainer
- Languages

Staff is to be trained in line with the provisions of the Infection Protection Act and this training must be documented. Such training courses are to be staged at least once a year (approx. every 12 month).
Training plan and training proof, Instruction/certificate from the health authorities

2.9.2 Information on the QS scheme

All responsible employees must be informed about the requirements of the QS scheme manual. This includes not only the basic principles of the QS scheme but also the specific requirements in the area of activity of the employees in question.

3 Requirements for slaughtering

3.1 General requirements

The carcasses form cattle and pigs must be labelled with a consecutive slaughtering number (e. g. stamp or label).

The requirements of REG (EC) No 1099/2009 on the protection of animals at the time of killing and the national Ordinance on the protection of animals in connection with slaughter must have been implemented in the company.

3.1.1 [K.O.] Animal welfare officer

The company must appoint an animal welfare officer. The responsibilities of the animal welfare officer are defined in the standard work instructions of the abattoir. The animal welfare officer must meet the requirements of REG (EC) No 1099/2009, Article 17 and perform the tasks outlined in the regulation.

These include:

- Monitoring of the animal welfare work of the employees (observation of staff during stunning, sticking).
- Ensure that the inspection and maintenance of the equipment required for stunning and slaughtering in terms of damage, maintenance level, functionality and electrical specifications is done daily.
- Daily inspection and documentation of the stunning success (for cattle and pigs) twice a day or spread over the day at 10% of the average hourly slaughter rate or at (poultry for) approx. 1% of the daily slaughter capacity. If necessary, documentation of measures taken.
- Obligation to provide proof of competence in handling and care as well as stunning and bleeding of animals.
- Appointment of a deputy with a proof of competence in the handling, care, stunning and bleeding of animals.
- Regular participation in further training (internal/external) at intervals of max. 3 years.
- Documentation of measures taken regarding animal welfare.
- Reports directly to the management on animal welfare matters.
- Ensures that all consignments with animals are checked by a qualified person and that this is documented and that animals that require special care are treated accordingly.
- Ensures that the general wellbeing and state of health of animals in the waiting area/pen is checked regularly.

3.1.2 Standard work instruction

The standard work instructions must be available for all areas from unloading to bleeding and the form (e.g. film, pictures etc.) of the handing-over must be regulated. When developing the standard work instructions for cattle, calves and pigs, the national guidelines according to Regulation (EC) No. 1099/2009 must be observed. In Germany these guidelines "Bewährte Verfahrensweisen für eine tierschutzgerechte Schlachtung", "Handbuch Tiertransport" and "Handbuch Tierschutzüberwachung bei der Schlachtung und Tötung" are available in the member area of the VDF or on the homepage of the FLI. If in the country of the scheme participant no guidelines according to Regulation (EC) No. 1099/2009 are available, guidelines from other EU Member States for the corresponding animal species should be considered.
The standard work instructions must include the following points:

- clear objectives,
- responsibilities,
- procedures,
- measurable criteria and
- procedures for monitoring and recording.

When determining the values, it must be ensured that measurability is guaranteed. In addition, measures must be defined in case of deviations from the standard.

**Personal details**

For each point, responsible and implementing staff must be named. Internal documents/records have to indicate who is responsible on which day.

**Minimum requirements**

Monitoring points must be established. Key parameters and recommendations from the stunning equipment manufacturer must be considered.

- Measures and nonconformities

**3.2 Monitoring of livestock transport – transport practice**

**3.2.1 [K.O.] Check of livestock transport company**

If animals from QS-certified companies are delivered by commercial livestock transport companies, these transporters must possess a QS eligibility of delivery in the QS database and the process of verification must be documented, so that the meat can be marketed as QS meat.

- Documented procedure to query the eligibility of delivery in the QS-database

**3.2.2 Delivery**

When transporting emergency slaughtered animals from the agricultural farm to the slaughterhouse unnecessary delays must be avoided.

Deliveries are planned such that it is possible to unload animals promptly after the arrival of the transport vehicle at the business. If prompt unloading is not possible, adequate weather protection must be guaranteed.

For pigs and cows, careful evaluation of each animal during unloading is in the area of responsibility of the abattoir.

Lactating cows must be milked within 12 hours of the last milking. A visual assessment of the udder must be made to check whether the animal may need to be milked.

**3.2.3 Check of certificates of origin**

The tagging of the animals and delivery papers must be compared to ensure compliance with **REG (EC) No 1760/2000** for cattle in combination with national regulations, and for pigs and poultry for compliance with indication of origin in line with **REG (EU) No 1337/2013**.

**3.3 Ramp area, stalls, waiting area**

**3.3.1 Unloading facilities**

Facilities for the loading and unloading of animals including the floor covering must be designed, built, maintained and used in such a way that injury, suffering and stress are avoided or reduced to a minimum.
and the safety of the animals is assured. Access to the stalls and waiting areas must be regulated; where necessary, an "Unauthorised access prohibited" sign must be mounted.

### 3.3.2 [K.O.] Treatment of animals

Care must be taken to ensure that the well-being of the animals is not impaired during unloading. It is forbidden:

- To hit or kick animals.
- To apply pressure to particularly sensitive parts of the body that may cause animals unnecessary pain or suffering.
- To hoist up animals with the mechanical gear fastened to their bodies.
- To pull at an animal's head, ears, horns, legs, tail or coat, or to treat them in any manner that may cause unnecessary pain or suffering.
- To use driving aids or other implements with pointed ends or sharp edges.
- Further is to be considered:
  - All employees in contact with the animals must have a proof of competence (handling and care of the animals).
  - Annual training of the competent staff who have contact with the animals for slaughter.
  - Staff and visitors in the shed area, as well as in the areas of access and stunning of cattle and pigs, must wear dark clothing.
  - Animal welfare violations and measures taken must be documented.

The abattoir must take precautions to ensure that the animals are not subjected to unnecessary stress. Driving aids such as a drive boards or paddles may only be used in a manner that spares the animals. The use of electrical driving aids is avoided. They may only be used for full-grown cattle and pigs that absolutely refuse to move and do not respond to contactless stimuli (visual and phonetic) and mechanical contact (e.g. drive paddle on rump) and only if the animals have sufficient space to move forward. Electric prods may only be used for separation purposes prior to and during guiding of animals towards a fixation device. They may only receive impulses at a maximum of one second at suitable intervals and only to the muscles on the hind quarters. This must not be repeated if the animal does not respond.

### 3.3.3 Technical/structural condition

⇒ 2.5 Technical/structural condition

The floor in the ramp area and in the stalls must be non-slip and undamaged. The floor must be equipped with drains. The stall area must be adequately ventilated and lighted. The animals must not be blinded by glaring light.

The guidelines for ramp angle of chutes (Ordinance on the protection of animals in connection with slaughter No. 1099/2009) must be fulfilled with exception to officially approved deviations:

- Equipment and chutes for unloading no steeper than 20 °
- Equipment and chutes for anaesthetising pigs no steeper than 10 °
- Chutes for anaesthetising cattle no steeper than 7°

### 3.3.4 Room, equipment and plant hygiene

⇒ 2.6 Room, equipment and plant hygiene

Accumulated dung, bedding and feed remains must be disposed of in a non-harmful manner.

### 3.3.5 Climate conditions

Animals may not be subjected to extreme heat or cold in the stall areas. The temperature should be between 5 °C and 35°C. Draft and high levels of air humidity should also be prevented in these areas.
3.3.6 Drinking troughs and feeding

In line with the Ordinance on the protection of animals in connection with slaughter, suitable troughs must be provided for all slaughtering animals (cattle and pigs) in waiting areas in sufficient numbers. The troughs must be hygienically clean and must function properly. Feeding facilities are available if animals are housed for more than six hours. One feeding place per animal must be available in case of housing for more than 12 hours.

3.3.7 Resting times

Slaughtering and delivery times must be coordinated. Resting times for delivery animals must be specified by the farm. Decisive factors in determining resting time are the well-being of the animals, the meat quality as well as the structural requirements.

- Definition of resting times

3.3.8 Sprinkler system

Operating instructions for the sprinkler system for pigs (if one is installed) must be present.

- Description for sprinkler system

3.3.9 Bay allocation

Bay allocation must be defined and observed. The following values must be observed for the bay allocation:

- **Pigs**
  - 0,6m²/animal

- **Cattle**
  - 2 m²/animal

- **Calves**
  - 1 m²/animal

The space required in the waiting house or the pen allocation must be constructed in such a way that even the heaviest animals have the possibility to lie down.

- Bay overview

3.3.10 [K.O.] Identification of QS farmers

If the goods are to marketed as QS goods, all deliveries must be checked to determine whether the farmers are shown in the database as authorised to deliver to the QS scheme (with the correct production type, overview of production types located on the QS-Homepage). Only then may the meat be marketed as "QS goods". The check is based on the VVVO No.

QS goods are taken to mean goods produced and/or marketed in line with the requirements of the QS scheme in a QS-certified company.

- Documented procedure for determining delivery eligibility in the database

3.3.11 [K.O.] Sluice option

If animals are taken to slaughter, a designated person must visually inspect the animals and remove any sick or injured animals.
3.4 Slaughtering

3.4.1 Herding livestock to the stunning area

Animals must be herded without agitation. Driving aids may only be used in a manner that spares the animals. The use of electrical driving aids is to be avoided. They may only be used for full-grown cattle and pigs that absolutely refuse to move and that do not respond to contactless stimuli (visual and phonetic) and gentle mechanical contact (e.g. drive paddle on rump) and only if the animals have sufficient space to move forward. Electric prods may only be used for separation purposes prior to and during guiding of animals towards a fixation device.

They may only receive impulses for max. one second at suitable intervals and only to the muscles on the hind quarters. This must not be repeated if the animal does not respond.

3.4.2 [K.O.] Effective stunning

Animals should be stunned in a manner that leads quickly and without pain or suffering to a condition of unconsciousness until the death of the animal. Animals that are to be stunned using a mechanical or electrical device must be brought into a position in which the device can be applied and operated accurately without difficulty. Pigs and cattle may not enter the stunning plant and may not be sedated until the designated person is present for immediate stunning.

If there is a special approval for the stunning system, this approval from the competent authority must be presented during the audit.

Tab.6: Stunning procedure based on species

<table>
<thead>
<tr>
<th>Species</th>
<th>Stunning method</th>
<th>Sign of correct stunning</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cattle</td>
<td>Electric stunning</td>
<td>No regular respiration, no directional movement, no recurrent spontaneous movements of eyelids or eyeballs, no vocalizations</td>
</tr>
<tr>
<td></td>
<td>Bolt shot device</td>
<td></td>
</tr>
<tr>
<td>Pig</td>
<td>Electric stunning</td>
<td>No regular respiration, no directional movement, no recurrent spontaneous movements of eyelids or eyeballs, no vocalizations</td>
</tr>
<tr>
<td></td>
<td>CO2 stunning</td>
<td></td>
</tr>
<tr>
<td>Poultry</td>
<td>Electric stunning</td>
<td>No regular beak opening, no recurrent spontaneous movements of eyelids or eyeballs, no regular movements of the pelvic floor, no straightening of the body during bleeding</td>
</tr>
<tr>
<td></td>
<td>CO2 stunning(^{(1)})</td>
<td></td>
</tr>
</tbody>
</table>

\(^{(1)}\) In accordance with REG (EC) No 1099/2009 Annex I Chapter 1 Tab. 3 CO2 stunning of water fowl is not admissible. In Germany, CO2-stunning of chickens requires approval from the competent authority.

Where an animal is slaughtered or otherwise killed through the removal of blood, the sticking process must be performed immediately following stunning within the predetermined period.

Tab.7: Maximum duration between stunning and sticking cut

<table>
<thead>
<tr>
<th>Stunning method</th>
<th>Seconds</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bolt shot for:</td>
<td></td>
</tr>
<tr>
<td>cattle</td>
<td>60</td>
</tr>
<tr>
<td>other animals or other shot positions</td>
<td>20</td>
</tr>
<tr>
<td>Electric stunning of warm-blooded animals</td>
<td>10 (for horizontal sticking)</td>
</tr>
<tr>
<td></td>
<td>20 (for sticking while hanging)</td>
</tr>
</tbody>
</table>
3.4.3 Stunning system

In line with the Ordinance on the protection of animals in connection with slaughter, stunning devices and systems are to be checked for proper functioning every workday prior to the start of work and cleaned several times a day if necessary. Backup equipment is to be kept ready for use and must be checked for proper functioning at the necessary intervals. Any defects must be remedied without delay.

Permissible stunning methods and related information are described in Regulation (EC) No 1099/2009 EC in Annex 1, Chapter 1.

According to Regulation (EC) No. 1099/2009 EC, electric stunning equipment is equipped with a device that displays and records data on electronic key parameters. For cattle and pigs, these must exist for each animal that is stunned. The device is placed in such a way that it is clearly visible to the personnel and sends out clearly visible and audible warning signals if the duration of the electricity flow is below the required time. These records must be kept for at least one year.

Records on the stunning system

3.4.4 Sticking

During sticking, it must be ensured that by opening one carotid artery or the corresponding main blood vessel strong bleeding occurs rapidly and leads to the extraction of blood from the animal. Sticking must be performed while the animal is still incapable of sensation and perception. It must be possible to monitor the sticking process.

Following sticking, further slaughtering tasks may only be performed on the animal when no movement of the animal is registered. The efficacy of stunning must be regularly checked before and/or after sticking to determine whether the animal is unconscious.

When the blood is captured for further processing, it must be stored/transported in such a way that a temperature of 3 °C is reached as quickly as possible. An explicit assignment of carcasses and blood is essential if the share of slaughtered QS animals is not 100 % and the blood is also marketed as QS goods.

Only persons with the requisite proof of competence in line with Art. 4 of the Ordinance on the protection of animals in connection with slaughter are authorised to kill animals.

Poultry

Operators of abattoirs in which poultry is stuck using automatic neck cutters must ensure that animals that are not cut by the cutters are cut by hand.

3.4.5 Skin/bristle/feather removal

The procedure for handling of abscesses, boils and infectious areas of the carcasses, that pose a risk of cross-contamination must be specially monitored and observed. The preparation procedures prior to the opening of the carcasses must be designed in such a way as to comply with good professional practice. Contamination of carcasses must be avoided as far as possible.
3.4.6 Removal of stomach and chest organs

Evisceration is a point in the slaughtering process that can pose the highest risk of contamination. Employees performing this task must be specially aware of this risk. Staff-, slaughtering- and knife hygiene is significance in this respect. Hygiene requirements for hand and tool hygiene must be defined and implemented in the company in a risk-oriented manner.

3.4.7 Animal carcass splitting

Hygienic working practices should be ensured when splitting carcasses, and contamination must be avoided. The handling of risk material must be defined and documented.

3.4.8 Meat inspection

The responsible authority performs proper meat inspection following the slaughtering process. Meat inspection is performed in line with valid Community law and may also be performed in a risk-oriented manner in line with REG (EC) No 1244/2007.

3.4.9 [K.O.] Sluice option

After meat inspection, it must be possible to remove problem carcasses and by-products (e. g. innards/blood) from the production flow. The clear connection between the carcass and the by-products (e. g. innards, blood) must be ensured.

3.4.10 Post-processing line

The carcasses are subject to a further inspection on the post-processing line, and any claws, coat remains and loose fat are removed.

If bovine carcasses are treated using lactic acid, this must be performed in line with the requirements outlined in REG (EC) No 101/2013.

3.4.11 Technical/structural condition

⇒ 2.5 Technical/structural condition

A functional separation must be in place between stall and stunning area. This separation must prevent odours and noise.

Pressure conditions between clean and unclean areas should be such that the air of the unclean area cannot enter the clean area. The separation between unclean and clean areas must be clearly identifiable and maintained.

3.4.12 Room, equipment and plant hygiene

⇒ 2.6 Room, equipment and plant hygiene

3.4.13 [K.O.] Order and organisation

The slaughtering process must follow structured workflows. The division of work among staff must be clearly structured (e. g. clear demarcation of hygiene areas).

3.4.14 Cutting utensil hygiene

⇒ 2.4 Good manufacturing and hygiene practice

Effective hygiene measures for knives and cutting equipment must be taken during the slaughter process. The handling (including replacing, cleaning and disinfecting) of knives, cutting equipment and system components (e.g. saws, drill units on poultry evisceration equipment) is defined internally in such a way as to reduce the risk of contamination to a minimum.
+ Cleaning and disinfection plan for cutting utensils

3.4.15 Climate conditions
The temperature and humidity must support optimal work conditions and should not affect the meat negatively. Enough ventilation of the room must also be ensured. Drafts should be avoided.

3.4.16 [K.O.] Diagnostic data
The diagnostic data must be recorded and reported back to the livestock owner, supplier or coordinator in accordance with a standardised procedure.

**Cattle:**
With female cattle, determination of pregnancy in the last trimester is recorded during official meat inspection when removing organs.

⇒ Annex 8.2 Determination of pregnancy in female cattle during the slaughtering process

The reporting of cattle slaughter findings data will be mandatory and will be carried out for cattle slaughtering within Germany in accordance with the guidelines on findings data in cattle slaughtering. The technical requirements must be met in order to record all findings in accordance with the guidelines on findings data in cattle slaughtering.

A review of this requirement in the audit will take place from January 1, 2023.

Cattle slaughtering outside Germany applies:

Reporting of the findings data to the QS findings database is not required. A recording and feedback of the findings data to the cattle holding company is carried out in accordance with the requirements of Regulation (EU) No. 2019/627.

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**Pig:**

For pig slaughtering within Germany the Guideline Diagnostic Data from Pig Slaughter applies. The technical requirements must be fulfilled in order to monitor the results accordingly to Guideline Diagnostic Data from Pig Slaughter.

Pig slaughtering outside of Germany:

Reporting the diagnostic data into the QS-database is only necessary for abattoirs within Germany. Outside of Germany the recording and reporting of diagnostic data to the livestock owner must be done in accordance with the REG (EC) No 2019/627.

Besides this, the following points must be implemented for abattoirs outside of Germany:

- The diagnostic data must be entered in the company’s IT-system.
- The diagnostic data must be reported to the livestock owner.
- The livestock owner must be able to compare his own data with those of all livestock owners delivering the abattoir.
- Once a quarter, the abattoir must report an overview of the diagnostic data and an evaluation of these data for all QS-certified livestock owners to the QS head office. Therefore, an Excel-form must be used. This form will be provided by the QS head office on demand. The report must be sent to diagnosticdata@q-s.de at the beginning of each quarter.
Poultry:

For poultry slaughtering the Guideline Diagnostic Data in Poultry Slaughtering applies.

##### 3.4.17 [K.O.] Salmonella monitoring

A concept for reducing salmonella contamination during the slaughter process (salmonella reduction plan) must be developed for pigs and poultry according to HACCP principles and implemented accordingly in the abattoir.

**Pigs**

Salmonella monitoring must be performed in line with the Guideline Salmonella Monitoring Pig.

**Poultry**

Salmonella monitoring must be performed in line with the Guideline "Salmonella Monitoring and Reduction Programme for Poultry Meat Production".

##### 3.4.18 Logistical slaughtering of Salmonella-positive herds (poultry)

Positive herds as defined by REG (EC) No 2073/2005 and non-tested herds must be slaughtered at the end of the slaughtering day (logistical slaughtering).

##### 3.4.19 Turkey slaughtering: participation in PAI monitoring

The abattoir is responsible for the testing of every turkey herd (hens, roosters) destined for slaughtering for antibodies against the avian influenza virus. The abattoirs must test at least 10 samples per herd. The tests may only be analysed by accredited laboratories, and the findings must be documented and findings are to be reported to the turkey farmer.

##### 3.4.20 Odour detection

Companies that slaughter uncastrated male pigs (young boars or immunocastrated boars treated with a vaccine against boar odour) or cannot exclude this possibility in the future must have procedures in place to ensure reliable detection of carcasses with potential boar taint. Detection via sense of smell, must at least meet the following criteria:

- Work instructions must define how the detection of boar taint in the abattoir is performed. The instructions must describe all the relevant aspects for the detection of boar taint by the human nose.
- The sensitivity, specificity and repeatability of the test procedure must be specified and documented. The method to determine the validity of the performed tests must also be documented.
- The test times per individual animal and maximum continuous testing time per test person are to be specified.
- Procedures for the monitoring of test persons and the performance of parallel controls must be defined and implemented.
- Employees selected to detect boar taint must be adequately trained (initial training and regular further training). Training content and frequency must be documented.
- Separate logistic processes for the separation of carcasses with specific odour must be in place and documented.
- In the event of deviations from the defined procedure and/or the objectives, appropriate correction and prevention measures must be implemented and documented.
The findings for each batch tested for boar taint must be reported back to the farmer/sender.

Proof of procedure for odor detection, where applicable work instructions, proof of training

3.5 Cold storage (unpacked goods)

3.5.1 Technical/structural condition

⇒ 2.5 Technical/structural condition

3.5.2 Room, equipment and plant hygiene

⇒ 2.6 Room, equipment and plant hygiene

Mould accumulation must be prevented in the cold storage rooms and steps taken to remove mould if necessary. Care should also be taken to ensure that icing is reduced to a minimum. Transport containers and vehicles must be in a hygienically flawless condition.

3.5.3 Ground clearance

⇒ 2.7 Ground clearance

To prevent floor contact parts of the forequarters must be removed prior to cooling if necessary.

3.5.4 Stock management

A logical storage management system must be in place, based on which it is possible to recognise rapidly and clearly when goods have been entered into storage. It must be possible to uniquely identify each stored and temporarily "parked" product or packaging unit. The first-in-first-out principle is to be followed. Storage conditions should not have any negative effects on the product properties (packaged/unpackaged).

A procedure must also be specified and known to the responsible members of staff that specifies the measures and steps in the event of a breakdown or malfunction. Here as well, the top priority must always be food safety – as with all other deviations in production or storage.

Storage management method

3.5.5 Species-specific product separation

Species-specific product separation must be ensured to prevent any negative reciprocal effects. Companies that, due to a lack of space, separate species based on time schedules must ensure interim cleaning procedures. From the deboning stage, the goal of reducing Salmonella calls for the following sequence – first cattle, then pork, then poultry.

3.5.6 [K.O.] Temperature recording and monitoring

Temperature recording and monitoring must be performed in line with the currently valid version REG (EC) No 853/2004, unless the meat is deboned in warm condition.

Cattle and pigs: cooling following slaughtering

The following internal temperatures must be achieved for cattle and pig carcasses:

- Slaughtering animal carcasses immediately to maximum +7 °C
- Slaughtering by-products immediately to maximum +3 °C

Poultry: cooling following slaughtering
In the case of QS poultry meat including offal, an internal temperature of maximum +4 °C is to be achieved without delay. Considering carcass weight, temperature and cooling time, all necessary precautions must be taken to avoid contamination of carcasses.

For hygienic reasons, cooling by using a spinchiller or comparable cooling methods are not permitted in QS companies. NEW: If such a cooling system is used for offal, these offal are excluded from the QS marketing.

Temperature documentation

3.5.7 Cattle quartering

Upon quartering the cattle halves, a hygienic working method is required. A contamination of the carcasses and the parts must be avoided

4 Requirements for deboning

4.1 Deboning

4.1.1 Technical/structural condition
⇒ 2.5 Technical/structural condition

4.1.2 Room, equipment and plant hygiene
⇒ 2.6 Room, equipment and plant hygiene

4.1.3 Ground clearance
⇒ 2.7 Ground clearance

4.1.4 [K.O.] Order and organization

Structured work processes, responsibilities and process inspections are defined for the deboning area and implemented accordingly. Potential risks for food safety and detrimental effects are avoided.

4.1.5 Handling deviating products

The handling of non-conforming products (abscesses, punctures and products that have fallen), auxiliary materials and packaging materials must be defined, and the relevant processes must function properly.

The decision as to their further use (release, post-treatment, blocking, rejection/disposal) must be made by a designated member of staff.

Proof of use/disposal of deviating products

4.1.6 [K.O.] Temperature recording and monitoring

The legally required temperatures (REG (EC) No 853/2004 see tab. 8) must be adhered to. The cold chain may not be interrupted. A room temperature of 12 °C must be maintained during deboning or it must be ensured that the meat temperature does not exceed the specified temperatures, e. g. by using an actively refrigerated work table.

Tab. 8: Maximum Cooling product temperatures during the deboning, storage and transport of meat
### Products

<table>
<thead>
<tr>
<th>Products</th>
<th>Measuring point (P)&lt;sup&gt;(1)&lt;/sup&gt;</th>
<th>Maximum temperature [°C]</th>
<th>Source</th>
</tr>
</thead>
<tbody>
<tr>
<td>Meat, fresh (except poultry)</td>
<td>P</td>
<td>+7</td>
<td>REG (EC) No 853/2004 Annex III Section I Chapter V Number 2b</td>
</tr>
<tr>
<td>Slaughtering by-products (e.g. offal)</td>
<td>P</td>
<td>+3</td>
<td>REG (EC) No 853/2004 Annex III Section I Chapter V Number 2b</td>
</tr>
<tr>
<td>Minced meat/Ground meat</td>
<td>P</td>
<td>+2</td>
<td>REG (EC) No 853/2004 Annex III Section V Chapter III Number 2c</td>
</tr>
<tr>
<td>Meat preparations</td>
<td>P</td>
<td>+4</td>
<td>REG (EC) No 853/2004 Annex III Section V Chapter III Number 2c</td>
</tr>
<tr>
<td>Poultry meat (incl. poultry offal)&lt;sup&gt;(2)&lt;/sup&gt;</td>
<td>P</td>
<td>+4</td>
<td>REG (EC) No 853/2004 Annex III Section II Chapter V Number 3</td>
</tr>
</tbody>
</table>

<sup>(1)</sup> Product temperature (P) is the maximum temperature that must be observed at all points for food that is subject to refrigeration.

<sup>(2)</sup> In line with REG (EC) No 1308/2013, poultry meat processed in fresh poultry preparations must be stored at temperatures ranging between -2 °C and +4 °C at all times.

Meat may be cut and deboned during the cooling period without having achieved the above-mentioned temperatures if the deboning is at the same location as the slaughtering. In this case, the meat must either be brought directly to the deboning from slaughtering or first be placed in cold storage. Once deboning and, if applicable, packaging has been completed, the meat must be cooled to the mentioned temperatures.

#### 4.2 Cutting, portioning and minced meat production

The cutting, portioning and minced meat production process incorporates portioning pieces of meat (e.g. steaks, barbecue items), cutting up joints of meat – with and without a marinade coating – and producing minced meat.

##### 4.2.1 Technical/structural condition

⇒ 2.5 Technical/structural condition

##### 4.2.2 Room, equipment and plant hygiene

⇒ 2.6 Room, equipment and plant hygiene

##### 4.2.3 Ground clearance

⇒ 2.7 Ground clearance

##### 4.2.4 [K.O.] Order and organization

Structured work processes, responsibilities and process inspections are defined for cutting, portioning and minced meat production and implemented accordingly. Potential risks for food safety and detrimental effects are avoided.

##### 4.2.5 [K.O.] Temperature recording and monitoring

The legally prescribed temperatures (Reg. (EC) No. 853/2004, Table 7) must be observed throughout the process as well as during storage and transportation. The cold chain must not be interrupted and the health of the consumer must not be endangered by an increase in temperature. An ambient temperature
of 12°C must be maintained, or it must be ensured that the temperature of the meat does not surpass the specified temperatures.

4.3 Labelling and packaging

4.3.1 Technical/structural condition

⇒ 2.5 Technical/structural condition

4.3.2 Room, equipment and plant hygiene

⇒ 2.6 Room, equipment and plant hygiene

Cleaning must take place in a different area and at a different time from the packaging operations.

4.3.3 [K.O.] Packaging material

Packaging material is to be stored in a separate storage area. Packaging material and any supplementary material must be stored and transported in such a way that the risk of contamination is kept to a minimum. Damage to packaging material must be prevented. Packaging material and any supplementary material must be suitable for the purpose and correspond to legal requirements.

A current declaration of compliance must be available for plastic packaging materials that come into direct contact with food (per Art. 16 of Reg. (EC) No. 1935/2004) and the packaging material must be suited to the specific product characteristics (e.g. fat content, pH level) and equipment (e.g. pasteurisation). The safety of all other primary packaging materials used (e.g. glass jars) is confirmed.

⇒ Annex 8.1 Declaration of conformity with the food laws for food packaging made of plastic (sample form)

Declaration of conformity/Declaration of compliance

4.3.4 [K.O.] Final product control

Test procedures must be specified for final product control that ensure the flawless nature of the products. This includes:

- Seal tightness check
- Filling weight check: scales used must be calibrated and subject to regular testing device inspections. Filling weight checks are to be performed on a regular basis; they must be documented and must comply with the legal regulations. Quantity and content (less tolerance) must correspond to the information on the packaging or the specifications.
- Cover gas concentration
- Temperature monitoring
- Check for proper labelling (labels, packing slips, QS-certification marks, Best-before date/Use-by date/Storage notes)

There must be a procedure for establishing best before dates/use-by dates in the company. These dates must be defined for each product group.

Procedure for final product control, establishing best-before dates/use-by dates

4.3.5 [K.O.] Product labelling

All beef products must be marked/labelled in accordance with REG (EC) No 1760/2000 with observance of REG (EC) No 1308/2013 Annex 7. With pigs and poultry, the provisions of REG (EU) No 1337/2013 must be complied. Compliance with these regulations can be verified by the traceability and labelling system for meat from ORGAINVENT.
The following information must be listed on the product packaging of food intended for the final consumer:

- Designation of the food
- List of ingredients (QUID if necessary)
- Reference to allergenic substances (also applies to bulk goods in line with LMIV)
- Total net quantity of the food
- Best-before date/Use-by date
- If necessary, special instructions for storage and/or use
- Name and address of the food company
- Nutrition declaration (not for primary products and for food regarding Annex V of the REG (EC) No 1169/2011)
- EU license/registration number
- Date of freezing
- Indication of origin, if legally required
- Note regarding oxygen pressure treatment where necessary

4.3.6 [K.O.] Recipes and specifications

Recipes/specifications must be created for all self-produced products. Specifications/ingredient lists that at least fulfil all legal requirements must be present for all purchased products. All ingredients/specifications must be listed in the recipes. The recipes/specifications must be known and accessible to the responsible member of staff. A procedure for the modification of recipes/specifications must be defined and applied.

Specifications, recipes, procedure for changing recipes

4.3.7 [K.O.] Sampling plans – final product

The specifications of REG (EC) No 2073/2005 (or equivalent testing methods based on the cascade model) are used for analytical testing.

Companies that do not have to conduct analyses in accordance with REG (EC) No 2073/2005 follow the recommendations of the Experts Committee for Food Microbiology and Hygiene of the German Association for Hygiene and Microbiology.

4.4 Meat cold storage (packaged goods)

4.4.1 Technical/structural condition

⇒ 2.5 Technical/structural condition

4.4.2 Room, equipment and plant hygiene

⇒ 2.6 Room, equipment and plant hygiene

Cold storage rooms must be in a clean and hygienically sound condition. Mould accumulation must be prevented in the cold storage rooms and steps taken to remove mould if necessary. Care should also be taken to ensure that icing is reduced to a minimum. The cooling units must be serviced on a regular basis and kept in a hygienically sound condition. A documented cleaning plan must be in place for the cooling systems complete with proof of performed cleaning.

4.4.3 Ground clearance

⇒ 2.7 Ground clearance

4.4.4 Stock management

⇒ 3.5.4 Storage management
In cold storage rooms compliance with the shelf life date (best-before date/Use-by date) is to be respected. Therefore, a regular checking of the best-before-date and the Use-by date must be guaranteed. Products with expired Use-by date are not allowed to be sold or shipped. Products with expired best-before date must be dealt with according to internal Guidelines.

4.4.5 [K.O.] Temperature recording and monitoring

Rooms or equipment in which products, raw materials, additives or auxiliary materials are stored must adhere to specific climatic conditions such as temperature, humidity, etc. in line with the specifications of the products to be stored.

Temperature documentation

4.5 Frozen storage rooms

4.5.1 Technical/structural condition

⇒ 2.5 Technical/structural condition

4.5.2 Room, equipment and plant hygiene

⇒ 2.6 Room, equipment and plant hygiene

Cold storage rooms must be in a clean and hygienically sound condition. Mould accumulation must be prevented in the cold storage rooms and steps taken to remove mould if necessary. Care should also be taken to ensure that icing is reduced to a minimum. The cooling units must be serviced on a regular basis and kept in a hygienically sound condition. A documented cleaning plan must be in place for the cooling systems complete with proof of performed cleaning.

4.5.3 Ground clearance

⇒ 2.7 Ground clearance

4.5.4 Stock management

⇒ 3.5.4 Storage management

In deep-freeze storage rooms compliance with the shelf life date (best-before date/Use-by date) is to be respected. Therefore, a regular checking of the best-before-date and the Use-by date must be guaranteed. Products with expired Use-by date are not allowed to be sold or shipped. Products with expired best-before date must be dealt with according to internal Guidelines.

4.5.5 [K.O.] Temperature recording and monitoring

Rooms or equipment in which products, raw materials, additives or auxiliary materials are stored must adhere to specific climatic conditions such as temperature, humidity, etc., as per the specifications of the products to be stored and in line with the regulation on deep-frozen foods (TLMV). Maximum temperature that must be observed at all points for food requiring cooling is -18 °C for deep-frozen food. Variation of temperature of these products up to 3 °C is acceptable in accordance with the regulation on deep-frozen foods (TLMV).

Temperature documentation, procedure of storage management
5 Other plant sections and areas

5.1 Cleaning rooms and material storage

5.1.1 Cleaning rooms

The cleaning of containers wherein meat and meat products are stored and transported (E2-crates and charging carts) must be performed in an effective and proper manner. It must be ensured that the crates are sufficiently dried and that no moisture remains in the crates.

5.1.2 Packaging material storage

Packaging material is to be stored separately from other goods. The room must be clean and in proper condition. Packaging material may only be used in production areas if the outer packaging has already been removed. Packaging material and any supplementary material must be stored and transported in a way that minimises the risk of contamination.

5.1.3 Cleaning and disinfection agent storage

The rooms or facilities in which cleaning agents and cleaning equipment are stored must be clean and in proper condition. They ensure hygienic storage of devices and, if necessary, permit clear separation of equipment for the clean/non-clean areas. The equipment is serviced and maintained on a regular basis. A procedure for cleaning and disinfecting rooms and equipment must be in place and staff must be familiar with this procedure.

All containers used to store cleaning agents must be labelled accordingly. Potential environmentally hazardous substances must receive special treatment (e.g. protective tubs).

Updated safety data sheets and instructions for use must be present for cleaning chemicals and cleaning agents. The responsible members of staff must be familiar with the instructions for use, which are to be stored on site. Cleaning equipment and chemicals must be clearly labelled and stored separately from food.

Safety data sheets, instructions

5.1.4 [K.O.] Spice storage

A specification must be present for spices. The products must be stored in a clean and orderly manner and furnished with a best-before date. If spices are removed from their original packing, the marking and the best-before date must be transferred along to the new storage container. The spice container must be entirely emptied, cleaned and disinfected before new goods can be put into the container.

The contamination with allergens must be ruled out in spice storage. A special area must be designated for the storage of spices containing allergens.

5.2 Disposal

5.2.1 Waste disposal logistics

Suitable measures must be taken for the storage and disposal of food waste, inedible by-products and other waste products.

These products must be removed from locations in which food is handled as quickly as possible. They must be collected in closed containers if they are located outside the buildings/rooms. These containers must be suitable for maintaining and be easy to clean and disinfect if necessary.

All waste must be disposed of in line with the hygiene regulations and in an environmentally sound manner and may not affect any food directly or indirectly.
5.2.2 Disposal area
The area of room where waste is collected and temporarily stored as well as the containers therein must be in a clean and hygienically flawless condition.

5.2.3 Slaughtering by-products and risk material
On site, the handling of slaughter waste and risk materials must be defined and implemented in line with the **By-product elimination law (TierNebG)**, **REG (EC) No 1069/2009** and its **Implementing Regulation 142/2011**.

Notwithstanding other arrangements with the competent plant responsible for removing animal carcasses, separate collection in accordance with legally required categories must be performed. Separate internal transport arrangements must also be assured.

Labelling must be as follows:

- "K1 – disposal only" (means of transport to be marked with black colour)
- "K2 – may not be used as feed" (means of transport to be marked with yellow colour)
- "K3 – not for human consumption" (means of transport to be marked with green colour with a high percentage of blue)

Where packages, containers or vehicles are not completely marked with colour, imprints, stickers and signs must be used with the corresponding colour; these must be clearly visible and affixed for the duration of transport. The company must present verification which provides quantitative information concerning the utilisation of products. When supplying animal by-products and derived products that are not suitable for human consumption, preparation of commercial documentation is mandatory.

- Documentation of slaughter waste, receipt from carcass removal agency, section handover receipt, company register

BSE sampling in cattle must be carried out in accordance with EU law (**TSE Regulation (EC) No. 999/2001**, in its current version). The relevant specifications of the EU member state must be observed.

- Findings, laboratory approval

5.3 Vehicle fleet
5.3.1 Washing options for transporters
Suitable washing and disinfection options must be present in sufficient number for the transport/delivery vehicles.

5.3.2 Cleaning and disinfection
The cleaning and disinfection of animal transport vehicles and refrigerated vehicles for food must be separated in terms of space or time. It must be ensured that no negative two-way effects occur (aerosols!).

A process to monitor the success of cleaning and disinfection of refrigerated vehicles must be used regularly and documented.

If no suitable measures are taken to clean and disinfect trucks during winter (carwash), then a disinfectant that also works at temperatures below zero must be available during the colder months of the year.

- Monitoring of cleaning and disinfection
5.3.3 System for temperature monitoring
The prescribed product temperature must always be guaranteed. The correct temperature must always be verified using a suitable procedure, such as temperature measurement on the product, or a functional temperature recorder.

6 Purchase, traceability, labelling, use of the certification mark and goods separation
6.1 Incoming/outgoing goods
6.1.1 Technical/structural condition
⇒ 2.5 Technical/structural condition
6.1.2 Room, equipment and plant hygiene
⇒ 2.6 Room, equipment and plant hygiene
6.1.3 Ground clearance
⇒ 2.7 Ground clearance
6.1.4 [K.O.] Incoming goods inspection
Inspection of incoming goods (purchase reception) must be defined and documented. This includes all products relevant. If necessary, incoming goods inspection must be adapted to any changed manufacturing, storage or transport conditions. Issues of relevance in terms of food safety must be recorded during the inspection of incoming goods (e.g. temperatures).

incoming goods documentation

QS supplier list
It must be possible to trace which goods are purchased from which supplier. A supplier list of all suppliers in the QS-scheme must present.

Supplier list
6.1.5 [K.O.] Outgoing goods inspection
In the area of shipping, clear procedures and processes must be defined which cover at least the following points and which ensure compliance with regard to these points:

- Identity of the goods
- Temperature
- Damage/Contamination and Transport safety

A structured and traceable outgoing goods inspection must be carried out in the company. Contingency plans for deviations must be defined. The responsible employees must be trained to handle non-standard products. Transportation must comply with product requirements. Appropriate certification must be provided to ensure this.

Carcasses and the meat obtained therefrom must not exceed an internal temperature of +7 °C before shipping. This temperature regulation shall not apply in companies which cut carcasses exclusively for their own requirements or where the carcasses are intended for specific marketing routes (e.g. warm meat cutting) and are covered by an appropriate derogation.

Outgoing goods inspection procedure
QS customer list

It must be possible to trace which goods are delivered to which customer. A customer list of all QS customers must exist. When delivering the goods, the company must check the approval of the customer in the QS scheme in the database in case of pre-packaged food is intended for sale to the final consumer.

6.1.6 [K.O.] Returns management

A system to process returns must be implemented. Measures must be implemented to prevent the reoccurrence of the deviation. The separation of QS goods and non-QS goods must be observed.

6.1.7 Documentation of returns management

6.2 Labelling and use of certification mark

6.2.1 [K.O.] Labelling of marketed QS produce

Goods marketed as QS goods must be provided with clear labels at the outgoing goods stage (e. g. stamp on the carcass halves showing the QS certification mark, use of the QS certification mark, the labelling of E2 crates with the QS certification mark, tracing with the slaughter number etc.). In addition, the produced goods must be clearly labelled as QS goods on the delivery note.

- QS goods must be uniquely and traceably labelled as such throughout all process stages. In addition, the transport documents must also be labelled uniquely (delivery note) so that a reference can be made from the QS goods and the corresponding dispatch notes or invoices etc. at any time.

Scheme participants may only label QS goods as such in the accompanying documents if the reseller is also a QS scheme participant. If at a business customer level QS products are marketed to non-QS scheme participants, these goods may not be identified as such in the accompanying documents, unless it is to be expected that the reseller will no longer actively advertise the goods as QS goods in his business dealings and in contact with his customers (e. g. by a general note on the related documents).

6.2.2 Use of QS certification mark

⇒ [K.O.] 6.2.1 Labelling of marketed QS goods

Scheme participants are entitled to use the QS certification mark once they have been permitted to do so by an explicit agreement with the coordinator (QS).

The QS certification mark may only be used in accordance with the style guide for the QS certification mark.

Scheme participants may market goods, that are already packaged for sale to the final consumer and are marked with the QS certification mark, only to QS scheme participants. Marketing to non-QS scheme participants is not allowed.
6.3 Traceability and origin of goods

6.3.1 [K.O.] Traceability method

Produced batch sizes must be defined to secure traceability. Traceability should be ensured to at least to a fattener group of one day or one shift. The systems and procedures for traceability must be traceable by third parties and allow a distinct identification of the QS goods as well as a traceable and plausible commodity flow. System partners must set up traceability systems and procedures in accordance with REG (EC) No 178/2002.

When forming beef batches, the provisions of REG (EC) No 1825/2000, Article 4 must be compulsory fulfilled. For pork and poultry, Articles 4 and 5.3 of REG (EC) No 1337/2013 must be complied with. Furthermore, national regulations must also be complied with.

Scheme participants must implement systems and procedures for traceability that ensure that traceability data is submitted to QS within 24 hours of contact with the scheme participants. Internal traceability processes during the audit should be structured so that the corresponding information can be collated within four hours.

The following customer and supplier information is relevant in accordance REG (EC) No 931/2011 and within the context of the QS scheme:

- Name, address and telephone number of the food business operator from whom the food was dispatched
- Name and address of the consignor (goods owner), if this is not the food business operator from whom the food was dispatched
- Name and address of the food business operator to whom the food is dispatched
- Name and address of the consignee (owner), if this is not the food business operator to whom the food is sent
- QS ID or location number (if this identification number has been assigned within the framework of the QS scheme)
- Type and quantity of delivered products
- Dispatch date, delivery data and/or slaughtering data (slaughtering date only relevant for the stage slaughtering/deboning)
- Batch or lot number (if created during the production process)

At the slaughtering/deboning stage, the VVVO numbers (and, if available, also name and address data) of the farmers whose animals were slaughtered should be passed on to QS in an electronically readable format (Excel-format).

6.3.2 [K.O.] Traceability test

The labelling and registration system implemented within the company must allow unique identification of QS goods and product traceability on the basis of a sample from production or outgoing goods at any given time according to REG (EC) No 178/2002. This also applies to packaging and spices.

The labelling and registration system used in the company is tested at least once a year (approx. every 12 months). All relevant flows of goods should be considered. The test must be documented and the findings must be presented in a plausible manner.

Products that are known to contain QS goods, but are not marked as QS goods, must also be considered for the traceability test.
6.3.3 **[K.O.] Reconciliation**

Care should be taken to ensure that there is a plausible relationship between the quantity of purchased goods and the quantity of produced or stored goods.

- Incoming goods documents (e.g. delivery notes, incoming goods inspection) and outgoing goods documents as well as quantity of goods in cold/frozen storage

6.3.4 **[K.O.] Check on QS eligibility of delivery**

Companies that deliver QS goods must be identified as scheme participants in the QS database with eligibility to deliver at the time of delivery. The approval of the customer in the QS scheme must also be reviewed in the QS database when the goods are handed over.

- Documented procedure for requesting information on eligibility of delivery in the QS database

6.4 **Goods separation**

6.4.1 **[K.O.] Separation of QS produce/non-QS produce**

A logical system for marking and (batch) separating QS goods from non-QS goods must be present in the company. If no QS goods are yet present in the company, the procedure for goods separation must be demonstrated in a suitable manner.

Mix-ups of QS goods and non-QS goods must be avoided. All employees working with these products must work in a way that ensures that no mix-ups occur.

- System for separation of QS goods and non-QS goods

7 **Definitions**

7.1 **Explanation of symbols**

K.O. criteria are marked **[K.O.]**.

Reference to related documents are highlighted with **bold text**.

- This sign means: A written proof must be kept. Next to this sign documents are listed that can be used as proof. All (including digital) control and documentation systems that prove that the requirements are fulfilled, can be used.

References to other sections of the Guideline are indicated by ⇒

Notes are identified by **Note in italics**.

7.2 **Abbreviations**

- CCP Critical Control Point
- HACCP Hazard Analysis and Critical Control Points
- K. O. Knock out
- QUID Quantitative Ingredient Declaration
- VVVO VVVO livestock transport ordinance
7.3 Terms and definitions

- **Shipment**
  The entire transport process from place of dispatch to destination, including unloading, temporary storage and loading at interim stations.

- **CCP (Critical Control Point)**
  A point, process, procedure or work step at which inspection can be performed and is necessary to prevent or remove a food safety hazard or to reduce it to an acceptable level.

- **CP (Control Point)**
  A point, process, procedure or work step at which health hazards could occur or at which the inspection of hygiene measures is necessary.

- **HACCP (Hazard Analysis and Critical Control Point)**
  A system that identifies, assesses and monitors hazards that are significant in terms of food safety.

- **HACCP concept**
  Documentation in compliance with HACCP principles to ensure the monitoring of hazards relevant to food safety.

- **QS goods**
  QS goods means goods that are produced and/or marketed in a QS-certified company in line with the requirements of the QS scheme.

- **QUID**
  QUID (Quantitative Ingredient Declaration) refers to the percentage quantity labelling of food ingredients.

- **Red meat**
  The term red meat applies to beef and veal as well as pork.

- **White meat**
  The term white meat applies to chicken, turkey and duck.

You can find a list of general terms and definitions in the Guideline "General Requirements".

8 Annexes

8.1 Declaration of conformity with the food laws for food packaging made of plastic (sample form)

Annex 8.1 is published as an excerpt.

8.2 Determination of pregnancy in female cattle during the slaughter process

**Objective**

The last trimester of the pregnancy must be recorded and documented. Therefore, the main criterion is the crown-coccyx length of the foetus. Gravidity at the beginning of the last trimester (assumption: Ø pregnancy of 284 days; i.e. 95 days before birth; early in the 7th month) is assumed by a foetus length of 45 cm and more.

**Implementation and recording of data**

The abattoir must provide suitable spatial and technical prerequisites to establish gravidity.

**Reporting back to the farm of origin**

The result of pregnancy determination must be prepared by the abattoir and reported to the farm of origin in such a way that the livestock owner can easily recognise the delivery of a female cow in the last trimester of its pregnancy, thereby signalling a possible need for action. The provision of this information with the invoice is one possible way to fulfil this requirement of notifying the farm of origin. Positive findings must be reported back using a standardised, verifiable process. Positive findings must not be
reported, if the slaughter was performed due to epizootic diseases or was executed by the means of a veterinarian indication.
### Revision Information 01.01.2022

<table>
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<tr>
<th>Criterion/Requirement</th>
<th>Changes</th>
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<tr>
<td>1.1 Scope</td>
<td><strong>Addition:</strong> Scope extended to include the production of meat cuts and portioning of meat.</td>
<td>01.01.2022</td>
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<td>2.1.3 Food safety culture</td>
<td><strong>New:</strong> New criterion.</td>
<td>01.01.2022</td>
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<td>2.1.4 [K.O.] Commissioning of service providers</td>
<td><strong>Addition:</strong> Requirements for the transport of meat and meat products were added.</td>
<td>01.01.2022</td>
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<td>2.3.2 Listeria monitoring</td>
<td><strong>New:</strong> Own criterion.</td>
<td>01.01.2022</td>
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<td>2.3.3 [K.O.] HACCP</td>
<td><strong>Concretization:</strong> The basis and precondition for the implementation of a HACCP system are basic hygiene measures, including the codes of good hygiene practice (GHP) and good manufacturing practice (GMP).</td>
<td>01.01.2022</td>
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<tr>
<td>2.3.8; 2.3.9; 2.3.10; 2.3.11 Control points (CP)</td>
<td><strong>Deletion</strong> of the requirements for control points (CPs).</td>
<td>01.01.2022</td>
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<tr>
<td>2.3.15 [K.O.] Salmonella reduction plan</td>
<td><strong>Deletion:</strong> The requirements were assigned to criterion 3.4.17 Salmonella monitoring.</td>
<td>01.01.2022</td>
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<tr>
<td>2.4.1 Water quality</td>
<td><strong>Concretization:</strong> Water/ice used as an ingredient and/or for the treatment of food in the manufacturing process or for cleaning objects and equipment (which could come into contact with food as intended) must be tested in a risk-oriented manner according to purpose C of DIN EN ISO 19458.</td>
<td>01.01.2022</td>
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<td>2.4.2 Cleaning and disinfection</td>
<td><strong>Concretization:</strong> risk-based approach to sampling for cleaning and disinfection controls.</td>
<td>01.01.2022</td>
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<td>2.4.8 [K.O.] Cross-contamination</td>
<td><strong>Addition:</strong> Risk assessment for cross-contamination and minimum requirements for allergen management were added.</td>
<td>01.01.2022</td>
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<td>2.5 Technical/structural condition</td>
<td><strong>Addition:</strong> The criterion has been extended to include the definition and classification of hygiene zones.</td>
<td>01.01.2022</td>
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<td>2.9.3 Manufacturing and work instructions</td>
<td><strong>Renaming:</strong> Requirement not applicable and covered in terms of content in point 2.1.6 Food safety culture.</td>
<td>01.01.2022</td>
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<td>3.4.13 [K.O.]; 4.1.4 [K.O.]; 4.2.4 [K.O.] Order and organization</td>
<td><strong>Renaming:</strong> The criteria have been renamed &quot;Order and organization&quot;, with requirements to define and implement work processes, responsibilities and process controls.</td>
<td>01.01.2022</td>
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<tr>
<td>3.4.14 Knife hygiene</td>
<td><strong>Addition</strong> of hygiene measures and handling of cutting equipment and cutting technologies.</td>
<td>01.01.2022</td>
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<tr>
<td>3.4.16 [K.O.] Diagnostic data</td>
<td><strong>New:</strong> from 01.01.2022 the reporting of diagnostic data for cattle is mandatory.</td>
<td>01.01.2022</td>
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<tr>
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<tr>
<td>4.2 Cutting, portioning and minced meat production</td>
<td><strong>Addition:</strong> Criteria for the processes cutting, portioning and minced meat production were added.</td>
<td>01.01.2022</td>
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<td>4.2.3 [K.O.] Packaging material</td>
<td><strong>Concretisation</strong> of the requirements for declarations of conformity.</td>
<td>01.01.2022</td>
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<td>4.3.6 [K.O.] Recipes/Specifications</td>
<td><strong>Addition:</strong> The term &quot;specifications&quot; was added to the criterion.</td>
<td>01.01.2022</td>
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<tr>
<td>6.3.1 [K.O.] Traceability methodology</td>
<td><strong>Concretization:</strong> The information must be passed on to QS in a structured, common and machine-readable format.</td>
<td>01.01.2022</td>
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</tbody>
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