

Audit Information



Audit Type: SQF Food Safety Audit Edition 8.0

Audit Number: 68015

Supplier: Smithfield Packaged Meats Corp.(45735)

Company Name: Smithfield Packaged Meats Corp. - Wilson

Company Number: 10151

Company Address:

2401 Wilco Blvd.
Wilson, NC 27893
United States

Certification Body: Mérieux NutriSciences Certification

Certification Body Address:

111 East Wacker Dr
Suite 2300
Chicago, IL 60601
United States

CB#: CB-1-Mérieux

Accreditation Body: JAS-ANZ

Accreditation Number: Z3720906AB

Audit Duration: 08/28/2018 - 08/30/2018

Time Spent Auditing: 24 hours

Time Spent Writing Report: 8 hours

Certification Issue Date: 11/06/2018

Certification #: 101893

Certification Type: Recertification

Audit Rating/Score: Excellent / 96

Certification Decision Date: 10/31/2018

Certification Expiration Date: 12/04/2019

Certification Decision: Certified

Food Sector Categories:

8. Processing of Manufactured Meats and Poultry

Products: bacon

Scope of Certification: bacon

Audit Team

FIRST NAME	LAST NAME	PERSON #	ROLE
Ute	Baker	9745	Lead Auditor

Non-Conformities

ELEMENT	PRIMARY RESPONSE	EVIDENCE
2.2.2.2	Minor	The revision dates on the document register did not match the revision dates for the Complaint policy and document control policy.
11.2.10.4	Minor	There were three maintenance employees that were observed with pens and tools in the breast pocket of their smocks. Two were not covering their mustaches per company policy.
11.3.7.3	Minor	There were candy wrappers and debris observed under the lockers in the men's locker room. Food is not allowed in the locker rooms per company policy.
11.7.5.8	Minor	Loose piping material was observed in the decombing area.

Root Cause Analysis

ELEMENT	PRIMARY RESPONSE	ROOT CAUSE
2.2.2.2	Minor	The Qualtrax database which houses all corporate and plant treated document does not provide a document register generated from the database forcing plants to develop there on.
11.2.10.4	Minor	Failure of Maintenance employees to use proper PPE to ensure compliance to the facility's policies and practices regarding GMP for Maintenance.
11.3.7.3	Minor	Signage is posted at locker room entrance. The root cause for this finding was the employees disregard for the facility's rules.
11.7.5.8	Minor	Damaged section of piping was not properly repaired but rather patched with loose tape.

Corrective Actions

CLAUSE	PRIMARY RESPONSE	CORRECTIVE ACTION	VERIFICATION OF CLOSEOUT	COMPLETION DATE	CLOSE OUT
2.2.2.2	Minor	Wilson Document Register was changed and the effective date, revision, and review date was removed from the register. The Procdere numbers are now hyperlinked to the Qualtrax database.	Reviewed the document register and corrective action. Approve the corrective action.	09/18/2018	09/25/2018
11.2.10.4	Minor	1) Plant reaching out to provider to have top pockets removed from Maintenance smocks. Plant personnel removing pockets from any smocks in house which have pockets.	Reviewed the training records and pictures of sewn up pockets. Approved the corrective action.	09/18/2018	09/25/2018
11.3.7.3	Minor	1) Retraining to be performed with all employees. 2) Continued inspection and emphasis on enforcing current policy.	Reviewed the training record and approved the corrective action.	09/18/2018	09/25/2018
11.7.5.8	Minor	1) Contractor to be brought in for pipe repair in the area	Damaged area was repaired. Reviewed and approved the corrective action.	09/18/2018	09/25/2018

Statements

SECTION	ELEMENT	EVIDENCE
Audit Statement Audit	Opening Meeting	Antiquea Allen: Corp. QA Manager, Gene Bartholomew: Corp. FS Director, Crystal Robinson: Corp. FS Manager, Cesar Cruz: PSSI Site Manager, Mark Burgio: FSQA Smithfield Charlotte, Luiquista Carlton: FSQA Supervisor, Lakeyla Coleman: CI/IE, Tierra Davis: Scheduler/Planner, Stacey Rose: Plant Controller, Marques Hoskins: FSQA Manager, Jose Pabon: Plant Manager, Tim Garcia: Plant Engineer, Caylin Stewart: Operations Trainee, Bill Thomas: Safety Manager, Fred Pitts: Warehouse Manager, Carey McKeithan: HR Manager, Andrea Tucker: Operations Manager, Ute Baker: Auditor.
	Auditor Recommendation	retain certification
	Closing Meeting	Crystal Robinson: Corp. FS Manager, Mark Burgio: FSQA Smithfield Charlotte, Luiquista Carlton: FSQA Supervisor, Lakeyla Coleman: CI/IE, Tierra Davis: Scheduler/Planner, Marques Hoskins: FSQA Manager, Jose Pabon: Plant Manager, Tim Garcia: Plant Engineer, Caylin Stewart: Operations Trainee, Bill Thomas: Safety Manager, Fred Pitts: Warehouse Manager, Carey McKeithan: HR Manager, Andrea Tucker: Operations Manager, Sean Johnson: Operations Superintendent, Ute Baker: Auditor.
	Facility Description	Smithfield is located in an industrial area of Wilson, NC. The facility was constructed in 1959 and is approximately 142,828 sq ft. The facility is two stories with shipping and receiving on the first floor along with the four coolers, smokehouses, pickle/injection room. The second floor includes the press room, slice and packaging area which has 17 lines. Palletizing is completed on the first floor. There are approximately 560 employees who work two production shifts 5 to 7 days per week. Sanitation is completed on the third shift by a contracted sanitation company. There is one HACCP plan in place. There are no CCP's identified in the plan. The facility produces bacon for the food service and retail industry under SQF category 8 for manufacturing. Non-conformances from the last audit have been closed.

Result List

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
2.1.1 Food Safety Policy	2.1.1.1	Compliant	
	2.1.1.2	Compliant	
<p><i>Section Summary:</i> A Food Safety and Quality Policy is in place. The policy was updated on Jun. 6, 2018 and signed by the Plant Manager. The policy statement includes the sites commitment to supply safe products that comply with customer and regulatory requirements. The policies are reviewed for compliance on a continuous basis. Through this process a continual improvement of the system will occur. The policy statement is posted at the main entrance, by the ATM machine, entrance to the administrative building and in the production plant. The policy is posted in English and Spanish.</p>			
2.1.2 Management Responsibility	2.1.2.1	Compliant	
	2.1.2.2	Compliant	
	2.1.2.3	Compliant	
	2.1.2.4	Compliant	
	2.1.2.5	Compliant	
	2.1.2.6	Compliant	
	2.1.2.7	Compliant	
	2.1.2.8	Compliant	
	2.1.2.9	Compliant	
	2.1.2.10	Compliant	

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
	2.1.2.11	Compliant	
<p><i>Section Summary:</i> An organizational chart is in place. The chart was updated on Aug. 27, 2018. The organizational chart shows who is responsible for food safety and the interaction between the different departments. Provisions and resources are in place to ensure that food safety practices have been adopted and are maintained. The FSQA Manager is the designated SQF Practitioner at the plant. He is a full time employee of the company and was HACCP trained on Feb. 21 - 22, 2017. During the audit he displaced knowledge in both SQF and HACCP. A training program is in place. All employees are trained at time of hire and annually thereafter. Employees interviewed during the audit stated that they will report food safety issues to their supervisor. Job descriptions are in place for all key positions. The job descriptions include who covers whom in case of absences. Extended runs for the press room, water reduction program is in place, added a recycling program and newslicers. The business continuity plan includes how the site will continue to operate in case of organizational and personnel changes. The site is aware of listing blackout dates prior to the 60 day unannounced audit time frame.</p>			
2.1.3 Management Review	2.1.3.1	Compliant	
	2.1.3.2	Compliant	
	2.1.3.3	Compliant	
	2.1.3.4	Compliant	
<p><i>Section Summary:</i> A Management Review was conducted on Jan. 21, 2018. The review included policy manual, internal and external audit findings, customer complaints and resolutions and follow up actions from previous management reviews. Monthly meetings are also conducted to update management on any issues. Monthly meeting notes were reviewed for Feb. 26, Mar. 29, and May 3, 2018. Notes were complete and includes issues that have occurred during the month.</p>			
2.1.4 Complaint Management	2.1.4.1	Compliant	
	2.1.4.2	Compliant	
	2.1.4.3	Compliant	
	2.1.4.4	Compliant	
<p><i>Section Summary:</i> A Customer and Consumer Complain Policy is in place. The policy was updated on July 20, 2017. All complaints are received by Consumer Affairs. Consumer Affairs documents the complaints and gives them to the plants depending on the issues. Trends of complaints are maintained. Main food safety complaints are for foreign material for bone and bone chips. Corrective actions have been implemented. AQL's are being conducted at time of receipt. Records of complaints were reviewed for Jan. through July 2018,</p>			
2.1.5 Crisis Management Planning	2.1.5.1	Compliant	
	2.1.5.2	Compliant	
	2.1.5.3	Compliant	
	2.1.5.4	Compliant	
<p><i>Section Summary:</i> A Crisis Management Plan is in place. The plan includes all potential crisis that could potentially affect the plant. The plant manager is the person responsible for decision making during a crisis at the plant. A crisis management team is also in place. The plan also includes how to ensure that product safety is not compromised. A crisis alert contact list is in place. The list includes customers, sources of legal and expert advice. Internal communications are from the plant manager and external communications are conducted by Corporate. The plan was tested on Jul. 20, 2018. The test was for a demonstration by an animal rights group. The group managed to penetrate the plant and cause damage. A damage assessment was made and raw materials and finished product were placed on hold for evaluation. Once an evaluation of the plant was conducted, the repairs were completed, the plant was cleaned and sanitized and operations resumed.</p>			
2.2.1 Food Safety Management System	2.2.1.1	Compliant	
	2.2.1.2	Compliant	
<p><i>Section Summary:</i> A Food Safety Manual is in place. The manual is maintained in both hard copy and electronically. The manual includes the methods used to meet the requirements of the SQF Food Safety Code and is made available to relevant employees. The manual includes the food safety policy, organizational chart, scope of certification, products covered under the certification and any other documentation necessary to support the SQF system. All changes made to the food safety plan, GMP's and other aspects of the SQF system will be validated or justified.</p>			

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
2.2.2 Document Control	2.2.2.1	Compliant	
	2.2.2.2	Minor	The revision dates on the document register did not match the revision dates for the Complaint policy and document control policy.
	2.2.2.3	Compliant	
<p><i>Section Summary:</i> A Document & Record Control Management policy is in place. The policy was updated on Apr. 27, 2018. The policy includes who is responsible for controlling documents, how the revisions are controlled and how revisions are documented. All documents are maintained in Qualtrax. A register of SQF documents is in place. The register was updated on Jan. 1, 2017. A minor was issued for the revision dates not matching the revision dates for the Complaint policy and document control policy on the document register. Documents are safely stored and were readily available.</p>			
2.2.3 Records	2.2.3.1	Compliant	
	2.2.3.2	Compliant	
	2.2.3.3	Compliant	
<p><i>Section Summary:</i> The Document and Record Management Policy includes how monitoring is to be undertaken and who verifies the records. Records were safely stored and readily available. Records are maintained per regulatory, customer and corporate requirements. Records were reviewed for cooling temperatures, decomb, palletizing, SSOP monitoring form, CQP for labeling, CQP leakers, and pickle make up sheets. All records were complete and verified. Corrective actions were documented for issues found.</p>			
2.3.1 Product Development and Realization	2.3.1.1	Compliant	
	2.3.1.2	Compliant	
	2.3.1.3	Compliant	
	2.3.1.4	Compliant	
	2.3.1.5	Compliant	
<p><i>Section Summary:</i> A Product Development Start-up Procedure is in place. The policy was updated on Jul. 6, 2016. All products are developed by Corporate Research and Development. Any new products will be validated by trial runs, shelf life studies and product testing. For any new products the HACCP will be verified and validated. There have not been any new products introduced since the last SQF audit. Shelf life trials are conducted weekly. Records were reviewed for June 2018. Products were in specification.</p>			
2.3.2 Raw and Packaging Materials	2.3.2.1	Compliant	
	2.3.2.2	Compliant	
	2.3.2.3	Compliant	
	2.3.2.4	Compliant	
	2.3.2.5	Compliant	
	2.3.2.6	Compliant	
	2.3.2.7	Compliant	
<p><i>Section Summary:</i> Specifications for all raw materials, ingredients and packaging materials are maintained in the ICIX data base. The raw materials, ingredients and packaging materials comply with relevant legislation. Specifications for raw materials, ingredients and packaging materials are developed by Corporate R & D. The ingredients are validated using letters of guarantee, ingredient testing and certificates of analysis. A specification was reviewed for salt. Packaging materials are validated by letters of guarantee. Letters of guarantee were reviewed for wood chips dated Aug. 6, 2018, Cherry blue chip dated Aug. 6, and Flavoring. Verification of packaging materials is with letters of guarantee. The letter was reviewed for film dated Sept. 7, 2010. Finished products are accurate and comply with relevant legislation. Labels are approved by the customer and by the Smithfield corporate labeling division. Registers are in place and were current for all materials reviewed.</p>			
2.3.3 Contract Service Providers	2.3.3.1	Compliant	

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
	2.3.3.2	Compliant	
<i>Section Summary:</i> Specifications are maintained for all contract service providers. The specifications were reviewed for pest control, uniform service and the cleaning company. All specifications were current. Training was completed. A register is maintained and was current for all service providers.			
2.3.4 Contract Manufacturers	2.3.4.1	Not Applicable	Contract manufactures are not used.
	2.3.4.2	Not Applicable	Contract manufactures are not used.
	2.3.4.3	Not Applicable	Contract manufactures are not used.
<i>Section Summary:</i> Contract manufactures are not used.			
2.3.5 Finished Product Specifications	2.3.5.1	Compliant	
	2.3.5.2	Compliant	
<i>Section Summary:</i> Finished product specifications are maintained in PMDM. The specifications include the quality attributes, labeling requirements, case requirements, packaging requirements and date code requirements. All specifications are available to relevant employees.			
2.4.1 Food Legislation	2.4.1.1	Compliant	
	2.4.1.2	Compliant	
	2.4.1.3	Compliant	
<i>Section Summary:</i> The facility ensures that at the time of delivery the products supplied meet applicable legislative requirements. The product was reviewed for weight, label, nutritional information and the USDA bug. The facility stays informed of changes to legislation from Smithfield corporate, USDA website and weekly USDA meetings. SQFI and the CB will be notified in writing within 24 hours in the event of a regulatory warning.			
2.4.2 Good Manufacturing Practices	2.4.2.1	Compliant	
	2.4.2.2	Compliant	
<i>Section Summary:</i> The site ensures that the GMP's described in module 11 are applied. There are no exemptions in place. The GMP's are documented and implemented.			
2.4.3 Food Safety Plan	2.4.3.1	Compliant	
	2.4.3.2	Compliant	
	2.4.3.3	Compliant	
	2.4.3.4	Compliant	
	2.4.3.5	Compliant	
	2.4.3.6	Compliant	
	2.4.3.7	Compliant	
	2.4.3.8	Compliant	
	2.4.3.9	Compliant	
	2.4.3.10	Compliant	
	2.4.3.11	Compliant	
	2.4.3.12	Compliant	
	2.4.3.13	Compliant	

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
	2.4.3.14	Compliant	
	2.4.3.15	Compliant	
	2.4.3.16	Compliant	
	2.4.3.17	Compliant	
<p><i>Section Summary:</i> There is one HACCP plan in place for the production of bacon. The plan is Heat treated, Not Fully Cooked, Not Shelf Stable. The plan was reassessed on Aug. 27, 2018. The plan was prepared in accordance with the Codex Alimentarius. A multi-disciplinary team is in place that is used for the development of the HACCP plan. The scope of the plan is from the incoming ingredients to the shipment of the finished products. All inputs and outputs are included. Product descriptions are in place along with how it is to be used, packaging requirements, where sold, labeling instructions, end user, special distribution control and shelf life. A flow chart is in place that shows all inputs and outputs including rework. A hazard analysis is in place which includes each step of the process. The Chemical hazards are identified as chemical residues. Biological hazards are identified as Salmonella, pathogenic E. Coli, and Trichina. Physical hazards are foreign material such as wood, plastic and metal. Pre-requisite programs are in place to mitigate all hazards. There are no critical control points identified in the facility. The plan is implemented and was reassessed on Aug. 27, 2018.</p>			
2.4.4 Approved Supplier Program	2.4.4.1	Compliant	
	2.4.4.2	Compliant	
	2.4.4.3	Compliant	
	2.4.4.4	Compliant	
	2.4.4.5	Compliant	
	2.4.4.6	Compliant	
	2.4.4.7	Compliant	
	2.4.4.8	Compliant	
	2.4.4.9	Compliant	
	2.4.4.10	Compliant	
<p><i>Section Summary:</i> Only ingredients and raw materials from approved suppliers were observed in the facility. Ingredients and raw materials can be received from a non-approved supplier, in cases of an emergency, once corporate purchasing has received all the required documentation. The criteria for selecting suppliers is at the corporate level. The food fraud assessment is included in the supplier approval program. Ingredients received from other facilities must meet the specified requirements and must be from an approved supplier. The approved supplier program is managed at Smithfield corporate. The program includes the methods and frequency for reviewing supplier performance. A register of approved suppliers is maintained. The register was current for the suppliers used.</p>			
2.4.5 Non-conforming Product or Equipment	2.4.5.1	Compliant	
	2.4.5.2	Compliant	
<p><i>Section Summary:</i> A Nonconforming Product Retention Policy is in place. The policy was updated on May 2, 2018. Any employee can show that an ingredient, work in process or finished product is out of specification. Only QA can place product on hold or release product. All items on hold are tagged with a red hold tag. The product is also quarantined. Any non-conforming equipment is also tagged out. Employees interviewed were aware of the hold policy. Hold records are maintained. The records include the reason for the hold, amount on hold and date. Corrective actions are documented. Records are maintained and were reviewed for August 2018. All records were complete.</p>			
2.4.6 Product Rework	2.4.6.1	Compliant	
	2.4.6.2	Compliant	
<p><i>Section Summary:</i> A Rework Procedure and Product Age Limits policy is in place which was updated on Sept. 9, 2018. Rework is supervised by the line lead and QA. Rework is identified on the rework documentation and is traceable. The rework is inspected prior to used. Documentation for rework was reviewed for Aug. 24, 2018. The original pallet id's are on the paperwork along with the new pallet id's.</p>			

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
2.4.7 Product Release	2.4.7.1	Compliant	
	2.4.7.2	Compliant	
<i>Section Summary:</i> A Product Release Procedure is in place. The product is considered to be good for release when all documentation has been reviewed for metal detection, palletizing, blade inspections, needle inspection, CPH/smokehouse and cooler/Decomb. Records were reviewed for Nov. 19 - 21, 2017, Feb. 19 - 21, May 22 - 24, and Aug. 13 - 15, 2018. All records were complete.			
2.4.8 Environmental Monitoring	2.4.8.1	Not Applicable	The facility does not have an environmental program in place.
	2.4.8.2	Not Applicable	The facility does not have an environmental program in place.
	2.4.8.3	Not Applicable	The facility does not have an environmental program in place.
	2.4.8.4	Not Applicable	The facility does not have an environmental program in place.
<i>Section Summary:</i> The facility does not have an environmental program in place. The facility is a raw bacon processor. A risk assessment was conducted that is dated Feb. 14, 2005 that shows that there are no environmental risks for raw bacon production. All packaging reviewed included the safe handling instructions and cook instructions.			
2.5.1 Validation and Effectiveness	2.5.1.1	Compliant	
	2.5.1.2	Compliant	
<i>Section Summary:</i> A Validation program is in place and criteria are in place to ensure the effectiveness of the SQF program. There are no CCP's in the plant. Validations were reviewed for pest control on May 25, 2018, GMP's on Jun. 12, 2018, metal detector on Jul. 24, 2018 and labels on Aug. 2, 2018. Validations are in place for all other programs.			
2.5.2 Verification Activities	2.5.2.1	Compliant	
	2.5.2.2	Compliant	
	2.5.2.3	Compliant	
<i>Section Summary:</i> A Verification schedule is in place. The schedule includes who is to do the verification, and frequency of verification. The records were reviewed for pest control on Mar. 9, 2018, Glass and Brittle plastic on Mar. 2, 2018 and Transport and Delivery on Jul. 12, 2018. Daily verifications were reviewed for monitoring records for Nov. 19 - 21, 2017, Feb. 19 - 21, May 22 - 24, and Aug. 13 - 15, 2018. Verifications were in place for all other programs.			
2.5.3 Corrective and Preventative Action	2.5.3.1	Compliant	
	2.5.3.2	Compliant	
<i>Section Summary:</i> A Product Quality & Food Safety Deviation Event policy is in place. The policy was updated on Apr. 25, 2018. The Corrective actions were documented for a metal detector check failure on Feb. 21, 2018. A corrective action was also reviewed for blue liner on Feb. 6, 2018 and grease on the film roller on Nov. 21, 2017.			
2.5.4 Product Sampling, Inspection and Analysis	2.5.4.1	Compliant	
	2.5.4.2	Compliant	
	2.5.4.3	Compliant	
	2.5.4.4	Compliant	
<i>Section Summary:</i> Methods are in place for checking the products on line and how to perform the sensory evaluations. Inspections are conducted on raw meat and finished products. Inspections include weights, leakers, labels, product appearance, length of solid fats, slice size, secondary lean, and total appearance. Proficiency testing for Rodac plating was completed on April 25, 2018. The external Smithfield laboratory used for testing is A2LA certified. Records for inspections were reviewed for Nov. 19 - 21, 2017, Feb. 19 - 21, May 22 - 24, and Aug. 13 - 15, 2018. All records were complete.			

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
2.5.5 Internal Audits and Inspections	2.5.5.1	Compliant	
	2.5.5.2	Compliant	
	2.5.5.3	Compliant	
	2.5.5.4	Compliant	
	2.5.5.5	Compliant	
<p><i>Section Summary:</i> An internal audit schedule is in place for the SQF code and for the monthly plant audits. The SQF code was audited between Mar. and Jun. 2018. All areas of the code were completed. Corrective actions were documented for issues found. Monthly internal audits are also conducted. Records for monthly audits were reviewed for Mar., Jun, and July 2018. Corrective actions were documented. Internal auditor training was conducted on Feb. 27, 2018. Employees conducting the audits are independent of the functions being audited.</p>			
2.6.1 Product Identification	2.6.1.1	Compliant	
	2.6.1.2	Compliant	
	2.6.1.3	Compliant	
<p><i>Section Summary:</i> A Product Identification Policy is in place. The policy was updated on Jan. 1, 2018. The ingredients are identified with the lot numbers from the supplier. The batches are made are identified with a computer generated label which allows the batch to be identified in the process. Finished product reviewed was labeled per customer and regulatory requirements. Product identification records were reviewed for Nov. 19 - 21, 2017, Feb. 19 - 21, May 22 - 24 and Aug. 13 - 15, 2018. All records were complete. Product start up and changeovers are documented. Labels and packaging are verified. QA and the line supervisor sign off on the change over documentation.</p>			
2.6.2 Product Trace	2.6.2.1	Compliant	
	2.6.2.2	Compliant	
<p><i>Section Summary:</i> A product trace policy is in place. The policy includes how product can be traced from time of receipt to the finished product. A trace was conducted during the audit for low salt bacon that was produced on Aug. 15, 2018. 587 cases were produced. They all were shipped to one distribution on Aug. 15, 2018. Bellies used were received on Aug 9, 10 and 13, 2018, sugar used was received on Aug. 13 and Jul. 13, 2018, phosphate was received on Aug. 2 and Aug. 9, 2018, salt was received on Aug. 9, 2018, nitrate was received on Jul. 24, 2018, and film was received on Aug. 14, 2018. The L-boards were received on Aug. 15, 2018. The trace last 2 hours. All items were accounted for and documentation was reviewed.</p>			
2.6.3 Product Withdrawal and Recall	2.6.3.1	Compliant	
	2.6.3.2	Compliant	
	2.6.3.3	Compliant	
	2.6.3.4	Compliant	
	2.6.3.5	Compliant	
<p><i>Section Summary:</i> A Recall Process Step is in place which was updated on Jan. 1, 2018. The policy includes who is responsible for the recall and the steps to be taken during a recall. The QA Manager and Corporate are responsible for initiating and investigating the recall. All customers are notified by corporate in case of a recall. A phone list is in place which includes the CB and the SQFI. SQFI and the CB will be contacted in writing within 24 hours in case of a recall or withdrawal. Investigations will be conducted in case of a recall. The facility has not had a recall since the last SQF audit. A trace exercise was conducted on Jul. 13, 2018 for bacon produced on Jul. 13, 2018. 100 % of the product was recovered in 2 hrs. All documentation was reviewed.</p>			
2.7.1 Food Defense Plan	2.7.1.1	Compliant	
	2.7.1.2	Compliant	
	2.7.1.3	Compliant	
	2.7.1.4	Compliant	

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
<p><i>Section Summary:</i> A Food Defense Plan is in place. The plan was reassessed on Jun. 11, 2018. The FSQA Manager is the senior manager responsible for the plan. The plan includes how access to the facility is controlled for visitors, employees and contractors. Sensitive areas in the facility are controlled. All trailers that enter the facility must be sealed or locked. Finished product trailers are sealed. Parking is outside of the fenced area. The plan was challenged on Aug. 7, 2018. An employee tried to smuggle an ingredient out of the plant and then back into the plant. The security team missed the item. Corrective actions have been implemented.</p>			
2.7.2 Food Fraud	2.7.2.1	Compliant	
	2.7.2.2	Compliant	
	2.7.2.3	Compliant	
	2.7.2.4	Compliant	
<p><i>Section Summary:</i> A Food Fraud Vulnerability Self-Assessment Plan is in place. An assessment was completed on Dec. 13, 2017. The food fraud vulnerability assessment included the site's susceptibility to product substitution, mislabeling and counterfeiting that may impact food safety. Food fraud mitigation is with the approved supplier program and plant pre-requisite programs. The plan was last reviewed on Dec. 13, 2017.</p>			
2.8.1 Allergen Management for Food Manufacturing	2.8.1.1	Not Applicable	The facility does not have any allergens in processing.
	2.8.1.2	Not Applicable	The facility does not have any allergens in processing.
	2.8.1.3	Not Applicable	The facility does not have any allergens in processing.
	2.8.1.4	Not Applicable	The facility does not have any allergens in processing.
	2.8.1.5	Not Applicable	The facility does not have any allergens in processing.
	2.8.1.6	Not Applicable	The facility does not have any allergens in processing.
	2.8.1.7	Not Applicable	The facility does not have any allergens in processing.
	2.8.1.8	Not Applicable	The facility does not have any allergens in processing.
	2.8.1.9	Not Applicable	The facility does not have any allergens in processing.
	2.8.1.10	Not Applicable	The facility does not have any allergens in processing.
	2.8.1.11	Compliant	
<p><i>Section Summary:</i> The facility does not have any allergens in processing. Annual training is completed with employees on the big 8 allergens. How the allergens could be introduced into the facility is included in the training. Receivers are trained on how to inspect ingredients to make sure that there is no allergen contamination.</p>			
2.8.2 Allergen Management for Pet Food Manufacturing	2.8.2.1	Not Applicable	This is not a pet food manufacturer.
	2.8.2.2	Not Applicable	This is not a pet food manufacturer.
<p><i>Section Summary:</i> This is not a pet food manufacturer.</p>			
2.8.3 Allergen Management for Manufacturers of Animal Feed	2.8.3.1	Not Applicable	This is not a animal feed manufacturer.
	2.8.3.2	Not Applicable	This is not a animal feed manufacturer.

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
<i>Section Summary:</i> This is not a animal feed manufacturer.			
2.9.1 Training Requirements	2.9.1.1	Compliant	
	2.9.1.2	Compliant	
<i>Section Summary:</i> The FSQA Manager and Human Resources are responsible for implementing the training at the company. SQF training was completed on Feb. 21 and 22, 2017.			
2.9.2 Training Program	2.9.2.1	Compliant	
<i>Section Summary:</i> A Food Safety and Quality Employee Training program is in place which was updated on Jan. 10, 2018. All employees are trained and time of hire. Training includes SQF, HACCP, Allergens, GMP's, and job specific training. Other training conducted is for pest control, food security, USDA Hold tags, foreign material control, housekeeping, donning and doffing, cross contamination and traffic patterns, color coding and hand washing.			
2.9.3 Instructions	2.9.3.1	Compliant	
<i>Section Summary:</i> SOP's are maintained which are well documented. The SOP's cover all instructions for the production floor and processing.			
2.9.4 HACCP Training Requirements	2.9.4.1	Compliant	
<i>Section Summary:</i> HACCP training for employees was conducted in March 2018.			
2.9.5 Language	2.9.5.1	Compliant	
<i>Section Summary:</i> Training materials are provided in both English and Spanish.			
2.9.6 Refresher Training	2.9.6.1	Compliant	
<i>Section Summary:</i> Refresher training is conducted annually.			
2.9.7 Training Skills Register	2.9.7.1	Compliant	
<i>Section Summary:</i> A training skills register is maintained. The register includes the employees name, training provided, date of training and who provided the training. Verification of training is with questions from the supervisor. The register was complete for the employees interviewed.			
11.1.1 Premises Location and Approval	11.1.1.1	Compliant	
	11.1.1.2	Compliant	
<i>Section Summary:</i> The facility is located in an industrial area. The surrounding grounds and buildings do not pose a food safety risk. The facility has a Grant of Inspection in place from the USDA est. 79C.			
11.2.1 Materials and Surfaces	11.2.1.1	Compliant	
<i>Section Summary:</i> Product and non-product contact surfaces are suitable for the industry.			
11.2.2 Floors, Drains, and Waste Traps	11.2.2.1	Compliant	
	11.2.2.2	Compliant	
	11.2.2.3	Compliant	
	11.2.2.4	Compliant	
<i>Section Summary:</i> Floors are in overall good condition. The floors are sloped toward the drains. Drains are located to allow for cleaning and do not poses food safety hazard. Waste traps are located away from entrances to the plant.			
11.2.3 Walls, Partitions, Floors and Ceilings	11.2.3.1	Compliant	
	11.2.3.2	Compliant	
	11.2.3.3	Compliant	

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
	11.2.3.4	Compliant	
	11.2.3.5	Compliant	
	11.2.3.6	Compliant	
	11.2.3.7	Not Applicable	There are no drop ceilings.
<p><i>Section Summary:</i> Walls, ceilings and doors are of solid construction. The internal surfaces are smooth. Wall to wall junctions were in overall good condition and clean. Ducting is located to allow for cleaning and was clean. Pipes carrying the drain water from the cooling units are labeled. Windows are made from shatter proof glass. The ceilings were in good condition. There are no drop ceilings.</p>			
11.2.4 Stairs, Catwalks and Platforms	11.2.4.1	Compliant	
<p><i>Section Summary:</i> Stairs over processing lines are of solid construction.</p>			
11.2.5 Lightings and Light Fittings	11.2.5.1	Compliant	
	11.2.5.2	Compliant	
	11.2.5.3	Compliant	
<p><i>Section Summary:</i> There was adequate lighting in the processing areas. All lighting is shielded. Lighting in the warehouse and cooler areas are shielded.</p>			
11.2.6 Inspection / Quality Control Area	11.2.6.1	Compliant	
	11.2.6.2	Compliant	
<p><i>Section Summary:</i> Inspection tables are in place for product inspection. The tables were clean, have adequate lighting, have access to a garbage can and sink.</p>			
11.2.7 Dust, Insect, and Pest Proofing	11.2.7.1	Compliant	
	11.2.7.2	Compliant	
	11.2.7.3	Compliant	
	11.2.7.4	Compliant	
<p><i>Section Summary:</i> All external windows, ventilations openings and doors were sealed. External personnel access doors are provided. There are air curtains on the doors and the doors are self closing. There was adequate sealing around the trailers in the dock doors. Electric insect devices are located away from product. There was no bait observed inside the facility.</p>			
11.2.8 Ventilation	11.2.8.1	Compliant	
	11.2.8.2	Compliant	
	11.2.8.3	Compliant	
<p><i>Section Summary:</i> There was an adequate amount of ventilation in the facility. The ventilation equipment used was clean. Extractor fans are provided in the smokehouse area. The fans and exhaust vents are insect proved.</p>			
11.2.9 Equipment, Utensils, and Protective Clothing	11.2.9.1	Compliant	
	11.2.9.2	Compliant	
	11.2.9.3	Compliant	
	11.2.9.4	Compliant	
	11.2.9.5	Compliant	
	11.2.9.6	Compliant	

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
	11.2.9.7	Compliant	
	11.2.9.8	Compliant	
<p><i>Section Summary:</i> Any new equipment is reviewed by engineering, FSQA and plant management. All equipment and utensils have to meet the specifications. Equipment and utensils do not pose a contamination issue. Benches, conveyors, mixers were in good condition and are located to allow for cleaning. Equipment surfaces were clean. Product containers are color coded and made of materials that are non-toxic. Waste and overflow water from equipment is directly to the drainage system. Protective clothing is manufactured from materials that do not contaminate product. Racks are provided for smocks and aprons. Protective clothing and equipment is cleaned after use.</p>			
11.2.10 Premises and Equipment Maintenance	11.2.10.1	Compliant	
	11.2.10.2	Compliant	
	11.2.10.3	Compliant	
	11.2.10.4	Minor	There were three maintenance employees that were observed with pens and tools in the breast pocket of their smocks. Two were not covering their mustaches per company policy.
	11.2.10.5	Compliant	
	11.2.10.6	Compliant	
	11.2.10.7	Compliant	
	11.2.10.8	Compliant	
	11.2.10.9	Compliant	
	11.2.10.10	Compliant	
	11.2.10.11	Compliant	
<p><i>Section Summary:</i> A preventative maintenance schedule is in place which is maintained in SAP. The program includes all areas of the facility. PM's are completed during non-production shifts. Failures of plant equipment are documented and used to adjust the PM schedule as needed. A minor was issued for three maintenance employees that were observed with pens and tools in the breast pocket of their smocks. Two were not covering their mustaches per company policy. Training on GMP's is conducted with contractors and maintenance employees. The maintenance supervisor and production supervisor are notified when repairs are to be conducted in the production area during production. The area is cleaned and inspected before it is turned back over to production. All tools and parts are removed. Temporary repairs are documented on the work orders and a notification is sent for the temporary repair. Only food grade lubricants are used in the production area. Paint is not used on product contact surfaces.</p>			
11.2.11 Calibration	11.2.11.1	Compliant	
	11.2.11.2	Compliant	
	11.2.11.3	Compliant	
	11.2.11.4	Compliant	
	11.2.11.5	Compliant	
	11.2.11.6	Compliant	
<p><i>Section Summary:</i> Calibration work instructions are in place for thermometers, metal detectors and scales. The work instructions include what to do with product when the equipment is found to be out of calibration. Calibrated equipment is protected from damage and unauthorized adjustment. Equipment is calibrated against NIST or instrument specific standards. Scales were calibrated on Mar. 28, 2018, the fluke calibration used to verify thermometers expires on May 4, 2018. Weights were recertified on Mar. 28, 2018. Records for calibration verifications were reviewed for Nov. 19 - 21, 2017, Feb. 19 - 21, May 22 - 24, and Aug. 13 - 15, 2018. All records were complete.</p>			
11.2.12 Pest Prevention	11.2.12.1	Compliant	
	11.2.12.2	Compliant	
	11.2.12.3	Compliant	

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
	11.2.12.4	Compliant	
	11.2.12.5	Compliant	
	11.2.12.6	Compliant	
	11.2.12.7	Compliant	
	11.2.12.8	Compliant	
	11.2.12.9	Compliant	
<p><i>Section Summary:</i> A Pest Control Policy is in place. The FSQA manager is responsible for managing the program. The company uses a contracted Pest Control Company to manage the program. Identified pest issues are communicated to the PCO and actions are taken. If an ingredient or product is affected that item is disposed off and the disposition is documented. The pest control program includes the frequency of service which is every other week or when needed. Methods that are used to prevent pest activities and methods for eliminating pests should they occur. A list of approved chemicals is in place. The device map was updated on Aug. 26, 2018. SDS sheets are available for all chemicals used. Records were reviewed for May through Aug. 2018. All records were complete and included the chemicals used. Written reports are given to the facility and are reviewed with the FSQA Manager. All chemicals are applied by a licensed PCO. He is licensed with the North Carolina Dept of Agriculture. The license expires Jun. 30, 2019. Empty chemical containers and old chemicals are removed by the PCO.</p>			
11.2.13 Cleaning and Sanitation	11.2.13.1	Compliant	
	11.2.13.2	Compliant	
	11.2.13.3	Compliant	
	11.2.13.4	Not Applicable	The facility does not have a CIP system in place.
	11.2.13.5	Compliant	
	11.2.13.6	Compliant	
	11.2.13.7	Compliant	
	11.2.13.8	Compliant	
	11.2.13.9	Compliant	
	11.2.13.10	Compliant	
	11.2.13.11	Compliant	
<p><i>Section Summary:</i> A Master Sanitation program is in place. The program includes what is to be cleaned, by whom, and frequency of cleaning. SSOP's are in place on how to clean the different areas and equipment. Titration logs are maintained to verify chemical concentrations. Verification of sanitation is with visual inspections and APC swabbing. The facility does not have a CIP system in place. COP tanks are in place for cleaning equipment. There are also two sanitation cleaning areas for specialty items. Pre-operational inspections are conducted by the production crew leaders. Employee welfare areas are checked during the daily GMP checks. Verification of sanitation is with 30 Rodac swabs per week. A randomizing program chooses the sites. A list of approved chemicals is maintained. The inventory is maintained weekly and was reviewed for Aug. 2018. Daily chemical titrations are conducted. Records are maintained and were reviewed for Jul. and Aug. 2018. Records for employee chemical training were reviewed for Jan. 12, 2018. Empty chemical containers are triple rinsed and recycled by the chemical company. Records were reviewed for pre-operational inspections were reviewed for Nov. 19 - 21, 2017, Feb. 19 - 21, May 22 - 24, and Aug. 13 - 15, 2018. Rodac (APC) results were reviewed for July and Aug, 2018. Corrective actions were in place for high counts. Sanitation records were reviewed for Jan. through Aug. 28, 2018. All records were complete.</p>			
11.3.1 Personnel	11.3.1.1	Compliant	
	11.3.1.2	Compliant	
	11.3.1.3	Compliant	
	11.3.1.4	Compliant	

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
<p><i>Section Summary:</i> There were no employees observed with any obvious illnesses. Employees are trained on how to prevent bodily fluid from touching product contact surfaces from sneezing or coughing. There are specific employees trained for cleaning up any bodily fluid spills. There were no employees observed with open wounds or cuts. Blue metal detectable band aids are used at the plant. There was no evidence of eating, drinking or smoking observed in the processing or storage areas.</p>			
11.3.2 Hand Washing	11.3.2.1	Compliant	
	11.3.2.2	Compliant	
	11.3.2.3	Not Applicable	The facility is not high risk but hands free taps are used.
	11.3.2.4	Compliant	
	11.3.2.5	Compliant	
	11.3.2.6	Compliant	
<p><i>Section Summary:</i> Sinks are located at the entrances to the production area. There are also sinks located in various areas of the production area. The sinks are provided with warm water, liquid soap, single use paper towels, and a garbage can. The sinks are hands free. Signage is posted for employees to wash hands. Employees were observed washing hands when entering the processing area. Hands are washed before putting on gloves.</p>			
11.3.3 Clothing	11.3.3.1	Compliant	
	11.3.3.2	Compliant	
	11.3.3.3	Compliant	
	11.3.3.4	Compliant	
	11.3.3.5	Compliant	
<p><i>Section Summary:</i> A risk analysis was conducted on Aug. 2, 2018 for clothing and the hair policy. The risk analysis showed that there is no risk from clothing or how hair nets are worn. Smocks worn by employees are maintained in a storage room and are handed to employees as needed. If smocks become soiled there are extra smocks to use. Disposable gloves are changed after breaks. Non-disposable aprons are cleaned as required.</p>			
11.3.4 Jewelry and Personal Effects	11.3.4.1	Compliant	
<p><i>Section Summary:</i> There were no employees observed that were wearing jewelry or loose items above the waist.</p>			
11.3.5 Visitors	11.3.5.1	Compliant	
	11.3.5.2	Compliant	
	11.3.5.3	Compliant	
	11.3.5.4	Compliant	
	11.3.5.5	Compliant	
<p><i>Section Summary:</i> Visitors, management and maintenance are required to wear smocks when entering the processing area. Steel toed shoes are required. All visitors are required to remove jewelry and loose items. Everyone must enter through the proper door ways and follow all GMP requirements including washing hands. Visitors are escorted at all times.</p>			
11.3.6 Staff Amenities	11.3.6.1	Compliant	
<p><i>Section Summary:</i> Amenities for employees have adequate lighting and ventilation. The areas were clean.</p>			
11.3.7 Change Rooms	11.3.7.1	Compliant	
	11.3.7.2	Not Applicable	This is not a high risk processor.
	11.3.7.3	Minor	There were candy wrappers and debris observed under the lockers in the men's locker room. Food is not allowed in the locker rooms per company policy.

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
	11.3.7.4	Not Applicable	Showers are not provided.
<p><i>Section Summary:</i> Locker rooms are provided for employees to change clothing. This is not a high risk processor. A minor was issued for debris and candy wrappers that were under the lockers in the men's locker room. Lockers are provided for employees to store personal items. The locker room is located in the administrative building which is away from the processing building. Showers are not provided.</p>			
11.3.8 Laundry	11.3.8.1	Compliant	
<p><i>Section Summary:</i> A contracted laundry service is used for laundering uniforms and smocks.</p>			
11.3.9 Sanitary Facilities	11.3.9.1	Compliant	
	11.3.9.2	Compliant	
	11.3.9.3	Compliant	
<p><i>Section Summary:</i> Restrooms are located in the main employee hallway of the processing building and in the administrative building where the locker rooms are. The restrooms were clean and are sufficient for the number of employees. Hooks are in place for storing outer garments. The sanitary drainage is connected directly to the drainage system. Sinks are designed as outlined in 11.3.2.2.</p>			
11.3.10 Lunch Rooms	11.3.10.1	Compliant	
	11.3.10.2	Compliant	
	11.3.10.3	Compliant	
	11.3.10.4	Compliant	
<p><i>Section Summary:</i> The lunch room is located in the administrative building which is located away from the processing building. The lunch room is well ventilated, has an adequate amount of seating, has a sink, microwave and refrigeration. The area was clean. The outside eating area was free of debris and has garbage cans. Signage is posted reminding employees to wash hands.</p>			
11.4.1 Staff Engaged in Food Handling and Processing Operations	11.4.1.1	Compliant	
	11.4.1.2	Not Applicable	Sensory evaluations are conducted in the laboratory area away from the production floor.
	11.4.1.3	Compliant	
<p><i>Section Summary:</i> Employees were observed entering the production area through the proper doorways. Hand washing was observed by employees. All ingredients and packaging materials were stored off of the floor. All doors were shut. Hair restraints were worn. All hoses were stored off of the floor.</p>			
11.5.1 Water Supply	11.5.1.1	Compliant	
	11.5.1.2	Compliant	
	11.5.1.3	Compliant	
	11.5.1.4	Compliant	
	11.5.1.5	Not Applicable	Water is not stored on site.
<p><i>Section Summary:</i> There was an adequate amount of hot and cold water available for sanitation. Employees questioned stated that there was an adequate amount of water available for cleaning. The water used is from the City of Wilson. Only potable water is used. Backflow prevention is in place. The backflow preventors were last tested on Dec. 3, 2017. Water is not stored on site.</p>			
11.5.2 Water Treatment	11.5.2.1	Not Applicable	Water is not treated on site.
	11.5.2.2	Not Applicable	Water is not treated on site.

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
	11.5.2.3	Not Applicable	Water is not treated on site.
	11.5.2.4	Not Applicable	Water is not treated on site.
<i>Section Summary:</i> Water is not treated on site.			
11.5.3 Ice Supply	11.5.3.1	Not Applicable	Ice is not used in the process.
	11.5.3.2	Not Applicable	Ice is not used in the process.
<i>Section Summary:</i> Ice is not used in the process.			
11.5.4 Monitoring Water Microbiology and Quality	11.5.4.1	Compliant	
	11.5.4.2	Compliant	
	11.5.4.3	Compliant	
<i>Section Summary:</i> Water used for sanitation is from the City of Wilson. The water report for 2017 shows that the water meets national water standards. Water testing was completed on Jan. 8, 2018. The results for Coliform were negative. The method used is Colilert/100ml.			
11.5.5 The Quality of Air and Other Gasses	11.5.5.1	Compliant	
	11.5.5.2	Compliant	
<i>Section Summary:</i> Compressed air is filtered with .01 micron filters. The filters are checked daily. Air testing was completed on July 5, 2018 on four lines. The air was tested for APC and results were 1 and < 1.			
11.6.1 Storage and Handling of Goods	11.6.1.1	Compliant	
	11.6.1.2	Compliant	
	11.6.1.3	Compliant	
	11.6.1.4	Compliant	
	11.6.1.5	Compliant	
	11.6.1.6	Compliant	
<i>Section Summary:</i> The facility receives raw meat which is received into the meat cooler. Drying redients are received on the dry dock and are stored in the dry storage areas. The facility uses First in First Out for stock rotation. There were no expired ing redients observed during the audit. Equipment rooms are designed to allow for cleaning and were clean. Reefers used for the storage of WIP product are monitored daily for temperatures. The trailers are sealed. Records for temperature checks were reviewed for Aug. 2018.			
11.6.2 Cold Storage, Freezing and Chilling of Foods	11.6.2.1	Compliant	
	11.6.2.2	Compliant	
	11.6.2.3	Compliant	
	11.6.2.4	Compliant	
	11.6.2.5	Compliant	
<i>Section Summary:</i> The temperatures of the coolers and processing rooms are monitored via a computerized system and every two hours by refrigeration. There is sufficient cooler space for raw materials and in process materials. The coolers were clean. Discharge from the defrost and condensate lines is directly to the drainage system. The temperature monitoring devices are located near the doors. Cool docks are in place for loading and unloading.			

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
11.6.3 Storage of Dry Ingredients, Packaging, and Shelf Stable Packaged Goods	11.6.3.1	Compliant	
	11.6.3.2	Compliant	
	11.6.3.3	Compliant	
<i>Section Summary:</i> Ingredients and packaging materials are stored on the second and first floors. The areas were clean and are located away from the wet processing areas. Only battery operated forklifts are used in the plant.			
11.6.4 Storage of Hazardous Chemicals and Toxic Substances	11.6.4.1	Compliant	
	11.6.4.2	Compliant	
	11.6.4.3	Compliant	
	11.6.4.4	Not Applicable	Pesticides are not stored on site.
	11.6.4.5	Compliant	
<i>Section Summary:</i> Chemicals are stored in a locked cage in the basement away from the processing area in a locked cage. The cage has signage, spill containment, ventilation and a safety shower on the exterior of the cage. Packaging materials and utensils were not stored in the chemical area. Daily supplies of chemicals are labeled. Pesticides are not stored on site. An inventory of chemicals is maintained and was current.			
11.6.5 Loading, Transport, and Unloading Practices	11.6.5.1	Compliant	
<i>Section Summary:</i> Loading and unloading practices are documented. All trailers are inspected prior to loading and unloading. Loading and unloading is from a cool dock. Dry ingredients are unloaded away from the raw materials.			
11.6.6 Loading	11.6.6.1	Compliant	
	11.6.6.2	Compliant	
	11.6.6.3	Compliant	
<i>Section Summary:</i> Transport vehicles are inspected prior to loading for cleanliness, odor, and trailer condition. The loading is directly from palletizing /cooler area into the trailers. All trailers are sealed after loading.			
11.6.7 Transport	11.6.7.1	Compliant	
	11.6.7.2	Compliant	
<i>Section Summary:</i> The reefer unit temperatures are set and documented prior to loading. The temperature must be below 35 F before loading can begin. Temperatures of the product are documented during loading. Records were reviewed for Aug. 2018 and were complete.			
11.6.8 Unloading	11.6.8.1	Compliant	
	11.6.8.2	Compliant	
<i>Section Summary:</i> The refrigerated temperatures of the reefers are checked by the guards when the trucks enter the plant. Temperatures are taken of the raw material during unloading. Temperatures are documented. Unloading is into the raw cooler area. Records were reviewed for Aug. 2018 and were complete.			
11.7.1 Process Flow	11.7.1.1	Compliant	
<i>Section Summary:</i> The process flow is from unloading to the tumbling area, combing, to the smokehouse, uncombing, upstairs to the press area, to slicing and packaging back downstairs to palletizing and loading.			
11.7.2 Receipt of Raw and Packaging Materials and Ingredients	11.7.2.1	Compliant	
<i>Section Summary:</i> Dry ingredients are received on a separate dock from raw materials. The dry ingredients and packaging materials are stored away from wet processing.			

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
11.7.3 Thawing of Food	11.7.3.1	Not Applicable	Thawing is not conducted.
	11.7.3.2	Not Applicable	Thawing is not conducted.
	11.7.3.3	Not Applicable	Thawing is not conducted.
	11.7.3.4	Not Applicable	Thawing is not conducted.
<i>Section Summary:</i> Thawing is not conducted.			
11.7.4 High Risk Processes	11.7.4.1	Not Applicable	The facility produces bacon that is ready to cook. There is no kill step in the process.
	11.7.4.2	Not Applicable	The facility produces bacon that is ready to cook. There is no kill step in the process.
	11.7.4.3	Not Applicable	The facility produces bacon that is ready to cook. There is no kill step in the process.
	11.7.4.4	Not Applicable	The facility produces bacon that is ready to cook. There is no kill step in the process.
	11.7.4.5	Not Applicable	The facility produces bacon that is ready to cook. There is no kill step in the process.
<i>Section Summary:</i> The facility produces bacon that is ready to cook. There is no kill step in the process.			
11.7.5 Control of Foreign Matter Contamination	11.7.5.1	Compliant	
	11.7.5.2	Compliant	
	11.7.5.3	Compliant	
	11.7.5.4	Not Applicable	There are no glass containers or equipment in the processing or laboratory areas.
	11.7.5.5	Compliant	
	11.7.5.6	Not Applicable	There are no glass instrument dial covers on the processing equipment.
	11.7.5.7	Compliant	
	11.7.5.8	Minor	Loose piping material was observed in the decumbing area.
	11.7.5.9	Compliant	
<i>Section Summary:</i> A Foreign Material Control policy is in place. The policy was updated on Aug. 27, 2018. All employees are trained on the policy and are responsible for reporting foreign material. Daily inspections are conducted on equipment to see that they are in good condition. There are no glass containers or equipment in the processing or laboratory areas. A glass register is in place. A glass and brittle plastic register is in place. The register was updated on Aug. 24, 2018. A glass audit is conducted quarterly and the lines are checked daily. There are no glass instrument dial covers on the processing equipment. Wooden pallets were in good condition. A minor was issued for loose piping material in the decumbing area. Knives and scissors are controlled and cleaned after each shift.			
11.7.6 Detection of Foreign Objects	11.7.6.1	Compliant	
	11.7.6.2	Compliant	
	11.7.6.3	Compliant	

SECTION	ELEMENT	PRIMARY RESPONSE	EVIDENCE
<p><i>Section Summary:</i> The facility uses metal detection for foreign material control. The metal detectors are challenged hourly to verify that they are working properly. The sizes used depend on the product and can range from 2.0 to 6.0 mm ferrous, 3.0 to 6.0 mm non-ferrous and 4.0 to 7.0 mm stainless steel wands. The belt stops when metal is detected. The metal detector checked during the audit was working properly. Employees understood what to do if the metal detector did not reject the wands. Records were reviewed for Nov. 19 - 21, 2017, Feb. 19 - 21, May 22 - 24, and Aug. 13 - 15, 2018. Corrective actions were documented when there was a metal detector failure.</p>			
11.7.7 Managing Foreign Matter Contamination Incidents	11.7.7.1	Compliant	
	11.7.7.2	Compliant	
<p><i>Section Summary:</i> In case of foreign material contamination the area is isolated and inspected. The product is either disposed off or reworked. In case of glass or brittle plastic breakage the area is isolated, cleaned and inspected. The product in the area is disposed off.</p>			
11.8.1 Location	11.8.1.1	Compliant	
	11.8.1.2	Compliant	
	11.8.1.3	Compliant	
<p><i>Section Summary:</i> Only Rodac plates are used in the plant. The Rodex plates are autoclaved prior to disposal. The laboratory is located away from the processing area and is restricted to authorized personnel only. The laboratory waste is disposed of directly into the compactor.</p>			
11.9.1 Dry and Liquid Waste Disposal	11.9.1.1	Compliant	
	11.9.1.2	Compliant	
	11.9.1.3	Compliant	
	11.9.1.4	Compliant	
	11.9.1.5	Compliant	
	11.9.1.6	Compliant	
	11.9.1.7	Compliant	
	11.9.1.8	Compliant	
	11.9.1.9	Compliant	
<p><i>Section Summary:</i> A Waste Disposal Policy is in place. The policy was current. Waste was removed from the processing area on a regular basis by the sanitation crew. Trolleys and bins used for waste collection are well maintained and clean. Solid processing waste is stored in combos and is denatured. The full combo's are stored on a refrigerated trailer that goes to rendering when it is full. All labels are destroyed and the destruction is documented. Liquid waste goes into the drainage system which goes to the waste water facility. The program is reviewed daily during the SSOP review. Records were reviewed for Nov. 19 - 21, 2017, Feb. 19 - 21, May 22 - 24, and Aug. 13 - 15, 2018. Records were complete.</p>			
11.10.1 Grounds and Roadways	11.10.1.1	Compliant	
	11.10.1.2	Compliant	
	11.10.1.3	Compliant	
	11.10.1.4	Compliant	
	11.10.1.5	Compliant	
	11.10.1.6	Compliant	
<p><i>Section Summary:</i> The exterior of the facility is monitored during the monthly facility audits. The exterior of the plant was dust free and there was no accumulated dust. Paths and roadways are paved. There was adequate drainage in the loading and unloading areas. The surrounding areas were free of debris. Paths from amenities are paved.</p>			

