

BMPA Standard

Module: British Quality Assured Pork

Processing standards and product specifications
for the production of British Quality Assured Pork

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BMPA Standard – British Quality Assured Pork

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Processing standards and product specifications for the production of British Quality Assured Pork

1.0 Introduction

This document defines the processing standards and product specifications for the production of British quality assured pork. The standard is owned by the British Meat Processors Association (BMPA) and will be reviewed regularly in the context of developing practice and market demand. The document should be read in conjunction with any relevant BMPA Guidance documents.

The standard has been developed to ensure the maintenance of high standards of animal welfare and hygiene, slaughter practice and production of pigmeat in abattoirs, cutting and further processing plants. There is independent evaluation to ensure compliance with the standard. It is complementary to the standards in the pig industry (Assured British Pigs and equivalent) and contributes to the assurance behind the British pig industry's Quality Standard Mark.

Where "shall" is used in the standard this indicates a requirement to comply with the content of the clause.

Compliance is required against other standards, see 2.1. below.

2.0 General requirements

2.1 Compliance with other BMPA standards

Participants shall comply with the following BMPA core standard and module:

- 2.1.1 **The BRC Global Food Standard (Issue 4).** This is the core element of all BMPA standards. Participants shall hold a valid Certificate of evaluation assessed against this standard. This requirement applies to any site handling assured product.
- 2.1.2 **The BMPA Animal Welfare and Slaughter Module.** It is a requirement of this standard that pork used in the manufacture of British Quality Assured Pork is produced to the requirements of the BMPA Animal welfare and slaughter standard module.

2.2 Legislation

- 2.2.1 Participants shall comply with all relevant legislative requirements.
- 2.2.2 Abattoirs, cutting plants and further processors shall be approved under The Food Hygiene (England) (*devolved authorities*) Regulations 2005 and fully comply with the terms of that Approval, all subsequent amendments or replacements to the Regulations and all relevant legislation and Codes of Practice for both Hygiene and Welfare.
- 2.2.3 Abattoirs and cutting plants operating under temporary or permanent derogations are not acceptable.

2.3 Evaluation regime

- 2.3.1 Participants shall undergo two surveillance evaluations annually, one of which shall be carried out in conjunction with the BMPA core standard evaluation with an additional surveillance evaluation.
- 2.3.2 Participants are advised that observations or non-compliances against the core standard may be identified during a British Quality Assured Pork evaluation and these will be recorded and be subjected to the normal

non-compliance procedures where appropriate.

3.0 Pork supplies

Only pork carcasses, cuts and boneless product from pigs compliant with the requirements of the BMPA Animal Welfare and Slaughter Standard shall be used in the manufacture of British Quality Assured Pork. All pork raw material shall be derived from pigs which have been sourced under any of the following Certification Schemes: Assured British Pigs, Quality Meat Scotland Assurance - Pigs or the Genesis Quality Assurance Pig Module.

If purchased from outside the company, product shall carry a warranty which confirms its assured status.

4.0 Quality policy

- 4.1 Abattoirs and cutting plants shall have in place a collection of documented procedures outlining methods of working which adhere to the requirements laid down in the MHS Operations Manual and the plant HACCP procedures.
- 4.2 Abattoir and cutting plants shall comply with auditing frequency and any corrective action defined by the enforcement authorities.
- 4.3 Further Processors and cutting plants shall not purchase meat from abattoirs and/or cutting plants that do not comply with evaluation frequency and any corrective action defined by the enforcement authorities.

5.0 Temperature control

- 5.1 In-process product and work room temperatures shall ensure the product maintains its safety and quality throughout its stated shelf-life. The temperature of further processing areas shall not exceed 12°C.
- 5.2 After dressing, sides shall be transferred without delay to a temperature controlled environment. The chilling regime shall be designed and monitored to ensure the deep muscle temperature does not fall below 10°C during the first three hours after stunning.
- 5.3 The temperature of deep musculature shall be reduced to -2°C to +5°C before further processing.

6.0 Process control

- 6.1 Unless Frozen, chilled pork should be further processed within 4 days of slaughter. However, provided that the carcasses or cuts are held in chill rooms which are not disturbed, the storage period may be extended by up to three days. For vacuum packed, gas flushed and deep chilled products further additional time can elapse given satisfactory documentary support.
- 6.2 **Incoming Product**
 - 6.2.1 The temperature of all incoming chilled or frozen products shall be checked before accepting the delivery. Temperature shall not exceed 5°C for chilled deliveries and -12°C for frozen. Any variation should be investigated and "between pack" or "product core" temperature checks carried out.
 - 6.2.2 Movement of pork between plants shall be in clean refrigerated vehicles. Carcasses shall be hung in vehicles. Cuts and prepared meats shall be hung or held in clean containers.

6.2.3 All incoming products shall be labelled and pre-inspected, before cutting takes place, by a visual examination for signs of damage, defects, bone splinters, contamination or infestation.

6.2.4 The microbiological condition of the incoming pork shall be monitored to a schedule and details recorded in order to meet the following standard:

TVC	Target	<1 x 10 ⁴ CFU per gram
	Upper Limit	<1 x 10 ⁶ CFU per gram

6.3 **Product Organoleptic Sampling (Excluding Carcasses)**

Pork primals, food service and retail packs of pork shall be subject to organoleptic sampling to ensure a consistently acceptable standard in accordance with the Pork Eating Quality Assessment (Appendix 1).

7.0 **Product identification and traceability**

7.1 All approved abattoirs, cutting plants and further processors shall operate a documented traceability system to ensure that:

7.1.1 Materials from raw material source to finished product and from finished product back to raw material source can be traced for both conforming and non-conforming product.

7.1.2 All abattoirs or groups of abattoirs shall maintain a current list of farm suppliers cross referenced with the lists held by the pig schemes referred to in clause 3.0.

7.2 Unwrapped product shall be identifiable as British Quality Assured Pork either by proper labelling of the rack, chandelier or other transport medium.

7.3 Wrapped primals shall be clearly identifiable as British Quality Assured Pork by appropriate labelling.

7.4 All companies shall ensure a rigorous traceability system is in place for all product in the plant and is regularly checked for its effectiveness (see Appendix 2).

7.5 All companies shall ensure that the traceability system is independently monitored on a regular basis (see Appendix 2). These inspections can be undertaken in house but shall be carried out by someone competent and independent of the manufacturing operation. The Scheme shall be notified and have approved the individual or company undertaking this monitoring. The BQAP Traceability Audit form and Non-compliance report sheet shall be used.

Records shall be kept for twelve months and be available for evaluation.

The aim of the monitoring procedure is to ensure that any product described as British Quality Assured Pork is derived from product compliant with the requirements of the pig schemes.

7.6 **Surveillance**

As standard owner the BMPA reserves the right to carry out random checks to ensure that product identified with the Quality Standard Mark (QSM) or described as British Quality Assured Pork originates only from carcasses or cuts that comply with the standard.

8.0 **Storage**

- 8.1 Storage shall be in proper conditions which ensure an even temperature is maintained at all times. Fresh British Quality Assured Pork should be stored between -2°C and 5°C.
- 8.2 Packaging of primal cuts shall adequately protect the pork during transport.
- 8.3 Outer cases shall be printed with the name and EC number of the packer on a printed label.
- 8.4 In addition, each outer case shall be marked or labelled with the following information:
- a) Contents
 - b) Weight
 - c) Slaughter code or production code
 - d) EC number
 - e) Confirmation of BQAP assured status
- 8.5 Primals packed in modified atmosphere or vacuum packed should be labelled as such and a durability date or code should be shown.
- 8.6 The joints and cuts shall be packed in such a way as to protect the pork properly during handling and transit and to enhance the visual appeal of the joint or cuts at point of sale.
- 8.7 Where frozen, the meat shall be in good condition at the time of freezing. Meat shall be effectively packaged to prevent the ingress of air during storage. A date of freezing shall be applied to each unit. Frozen pork shall not be stored for longer than 12 months.

9.0 Specific HACCP requirement

In addition to the HACCP requirements in the BMPA core standard the participating site shall be compliant with the following specific requirement:

Companies shall be able to demonstrate that the HACCP plan is validated to the Food Hygiene (England) (*devolved authorities*) Regulations 2005, and the Microbiological Criteria in Foodstuffs Regulations 2005.

10.0 Specifications

In addition to the specifications requirements of the BMPA core standard, the following specifications shall apply to British Quality Assured Pork for further processing and for sale as fresh pork.

10.1 General standards

The following general standards shall apply for clean carcasses, primals and cuts:

- a) The fat shall be firm and white.
- b) The muscle shall be firm and of good colour.
- c) The muscle and fat shall show no sign of bruising and blood splash.

10.2 Clean carcass specification

10.2.1 Carcasses with a P2 or P1 + P3 in excess of the permitted maximum, may be used to produce primals provided they are trimmed.

10.2.2 The carcass shall be free from blemish, bruising, hair, cuts and loose skin. The carcass shall have a maximum rindside blemish score of 2 on

the MLC's 5 point scale. Carcasses that do not meet this standard are not excluded from the scheme provided that they conform in all other respects with the product specification and are further processed on the participant's site for rindless product only.

10.2.3 The carcass shall be clean and free from extraneous matter.

10.2.4 In addition to the requirements above, only carcasses which conform to the following specifications are eligible for use in the manufacture of fresh pork for sale as British Quality Assured product:

Weight Range (Kg) (Cold dead weight)	P2 Range (mm)	P1 & P3 Range (mm)
55 – 100	Max 16	Max 32

As an alternative the use of a measured lean meat percentage of 52% would be treated as equivalent.

Meat from gilt carcasses in excess of 100kg may be used for manufacturing purposes, including sausage.

10.3 **Sow carcass specification**

Meat from farm assured sow carcasses may be used for manufacturing purposes, including sausage, provided it meets the clean carcass specifications above with the exception of clause 10.2.4.

Meat from sows is not eligible for sale as fresh pork under the British Quality Assured Pork standard.

10.4 **Primals and cuts**

10.4.1 Joints shall be separated by clean cuts and should be free from unnecessary cuts and slash marks.

10.4.2 The product shall be clean and free from loose pieces of meat glands and any other extraneous matter.

10.4.3 The rind, if present, shall be free from blemish, bruising, hair, cuts, loose skin and any trimming resulting from meat inspection.

11.0 Use of the Quality Standard Mark for Pork

Only finished product that has been processed to the requirements of the British Quality Assured Pork standard is eligible to be identified with the Quality Standard Mark for Pork. It is a requirement that the participating site shall be registered with the British Pig Executive (BPEX) to use the mark.

Appendix 1

PORK EATING QUALITY ASSESSMENT

OBJECTIVES

- To develop routine product sampling as a measure of the consistency of product quality.
- To maintain a constant awareness among plant personnel of the eating quality of current production.
- To provide a means of identifying quality problems.
- To accumulate sufficient data over time and have such data analysed for real effects on quality.

SUGGESTED METHODOLOGY

(Variation to this methodology shall be registered with and agreed by the Scheme)

Sampling shall be carried out against a defined sampling plan and appropriate records maintained.

The source of each sample shall be recorded.

Samples shall normally be drawn from loins or legs. Where these are not available other suitable cuts are acceptable.

Product sampling shall cover tenderness, succulence, flavour and visual appearance and assessed against a clearly defined scale. Detailed records shall be kept.

Appendix 2

TRACEABILITY IN PLANT

Traceability is a vital part of British Quality Assured Pork standard.

Companies should note that they are responsible for operating a Traceability System in plant as set out in the standard under Section 7.0: Product identification and traceability.

In particular, clause 7.5 states "All companies shall ensure that the traceability system is independently monitored on a regular basis".

The following points clarify the requirement:

1. The meat plant operator shall appoint a suitably qualified independent person or company acceptable to the Scheme, to monitor the internal traceability system.
2. The task is to independently verify that the traceability systems are being operated correctly. This shall involve checking the paper work system and undertaking spot checks on product. A minimum of 3 slap marks or finished products shall be checked for each week's production.
3. This task shall be completed on a regular basis. For abattoirs and cutting plants the requirement is weekly. For further processors the requirement is monthly with each week's production checked. A copy of the traceability audit form and traceability documentation shall be sent to the evaluation body on completion.
4. The Scheme Inspectorate shall visit the plant twice a year and will diligently check that the traceability audit is being completed. Checks will include full traceability exercises back to farm.
5. The independent auditor shall report any irregularities found directly to a senior manager within the company and to the evaluation body.
6. The Scheme's Traceability Audit form and Non-Compliance form shall be used for the traceability checks.
7. Where an abattoir has a co-located cutting/processing plant on the same site questions 2.3, 2.4 and 2.5 may be marked as "not applicable".
8. It will be necessary to show on the consignment documentation that the product is to BQAP standard unless otherwise stated.

**BRITISH QUALITY ASSURED PORK
PORK TRACEABILITY AUDIT**

Plant Name:.....

Date of Audit:.....

Carried out by:.....
(Please Print Name)

1.0 Abattoir Evaluation

- 1.1 Does the abattoir have access to the current monthly list of pig suppliers who are Approved Producers of Assured British Pigs? **Yes/No**
- 1.2 Are carcasses/sides identified as British Quality Assured Pigs or those recognised as equivalent stamped with the QSM and/or carry a unique identification mark e.g. a bar code? **Yes/No**
- | | | |
|---------------------------------------|--------------|---------------------------------------|
| 1.3 Slap marks of 3 carcasses checked | Date of Kill | Suppliers ABP Pig Registration Number |
| | | |
| | | |
| | | |
- 1.4 Can the slap mark/s be traced back to an Assured British Pigs approved producer or those recognised as equivalent? **Yes/No**
- 1.5 Can the slap mark/s be traced back to a DEFRA despatch note? **Yes/No**
- 1.6 Are the despatch notes fully and correctly completed? **Yes/No**
- 1.7 Has the approved status been confirmed for all suppliers identified? **Yes/No**
- 1.8 If the plant kills Farm Assured and Non-Farm Assured pigs is a batch code system used? **Yes/No/NA**
- 1.9 Are all BQAP products for despatch identified to allow traceability to a batch of a maximum of one day's kill or defined production run? **Yes/No**
- 1.10 Does the abattoir have a structured auditable traceability system for BQAP conforming and non-conforming Products? **Yes/No**

2.0 Further Processor and all Cutting Plants

- 2.1 Does all incoming BQAP product have a unique identification mark e.g. a bar code, that enables the product to be identified back to a batch from the abattoir/cutting plant? **Yes/No**
- 2.2 Does the processor/cutting plant have a structured auditable traceability system all for BQAP products that allows traceability back to a known batch? **Yes/No**
- 2.3 Does the processor/cutting plant hold a list of BQAP abattoirs/cutting plants? **Yes/No/NA**
- 2.4 Can the product be traced back to Goods Received Documentation? **Yes/No/NA**
- 2.5 Does the Goods Received Documentation specify BQAP product? **Yes/No/NA**
- | | | | |
|------------------------------------|---------------------|-----------|--|
| 2.6 Finished Products to be traced | Product Description | Pack Date | Suppliers Product Traceability Code/No |
| | | | |
| | | | |
| | | | |
- 2.7 Enter the name of the supplier/s. **BQAP No.**
- | | |
|-------|-------|
| | |
| | |
| | |
- 2.8 Is the supplier/s on the list of BQAP Abattoirs/Cutting Plants? **Yes/No**
- 2.9 Has approved status of supplier/s been confirmed? **Yes/No**
In the event of any non compliance enter the senior plant managers name who has been informed. (Manager's name.....)
In the event of any non-compliance a copy of this report shall be sent to the evaluation body with a Non-conformance report giving further details.

Signature **Date**
(Approved Auditor)

Print Name

BRITISH QUALITY ASSURED PORK
REPORT ON NON-COMPLIANCE PORK TRACEABILITY AUDIT

Company Name: _____

BQAP No.

Address: _____

Date of Audit: _____

REFERENCE	DETAILS OF NON-COMPLIANCE

Auditor's Signature

Print Name

Date.....

Please return to: The office of the Evaluation body

Appendix 3

USEFUL PUBLICATIONS AND CONTACTS

Publications

Guidelines for meat plant operators on the implementation of Hazard Analysis and Critical Control Point (HACCP) principles and microbiological testing procedures.

Crown copyright 2002. Published by the Food Standards Agency May 2002 FSA/0590/0502

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