MODULE 2 - BMPA QUALITY ASSURED PORK (BQAP)

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| 1.0    | Scheme rules | **Guidance:** A current copy of the BMPA pork scheme rules can be found on the BMPA website- http://www.bmpa.uk.com/Content/standards.aspx  
The scheme participant shall be aware that where specific scheme rules have been highlighted that these are auditable points within the scope of this pork module against which compliance shall be assessed by the service provider.  
**Evidence:** Compliance with the specific auditable points of the BMPA pork scheme rules. |
| 1.1    | The scheme participant **shall** be compliant with the requirements of the BMPA pork scheme rules at all times. |  |
| 2.0    | Pork supplies | **Guidance:** Heart, lungs and liver obtained from assured pigs may be categorised as BQAP.  
Pork raw material may be supplied from a number of sources:  
- internally (integrated site)  
- intra-company (‘sister site’)  
- externally  
The site shall hold copies of all suppliers’ BMPA pork scheme certification.  
It is not sufficient for a single header/logo to be the sole indicator of assured status on the delivery document. Where there is doubt regarding the status of the supply chain, verification shall be sought.  
**Evidence:** Copies of suppliers certificates of conformity against the BMPA pork module shall be held by the site and these shall be valid for the period under review. For each consignment of BQAP material delivered there shall be a warranty that clearly confirms the materials’ assured status and origin information of the pork. |
| 2.1    | a) All pork raw material to be used for the manufacture of BMPA Quality Assured Pork (BQAP) **shall** be compliant with the requirements of the BMPA Pig Welfare and Slaughter module.  
b) To maintain traceability all pork carcasses and raw material **shall** be accompanied by clearly marked delivery documentation which confirms its assured status and country of birth, rearing and slaughter or statement of pigs’ origin. Where pigs are born, reared and slaughtered in one country, a single statement of origin shall be sufficient for the traceability declaration. | **Guidance:** As read.  
**Evidence:** Review traceability systems for the segregation of sow meat. Challenge a single product date where sow meat was processed to include relevant production records and verify product types where the sow meat was used. |
| 2.2    | a) Sows **shall** not be processed as BQAP unless being used for the manufacture of comminuted meat preparations approved by the BMPA pork scheme e.g. sausage, providing that the pork complies with all aspects of the BQAP product quality standards with the exception of the P2 measurement. |  |
b) The site **shall** have developed appropriate systems/procedures for the identification, handling and processing of sow meat.

### 3.0 Reception of pork in processing plant

3.1

a) The site **shall** have in place a documented procedure and records for the reception, examination and temperature monitoring of all deliveries and a system for notification to the supplier **shall** be in place if the requirements are not met.

b) When placed in the transport vehicles, pork raw material **shall** be either hung on clean well-maintained stands/hooks or supplied in covered, clean, intact containers, cartons or trays that pose no risk of contamination to the contents.

c) Pork raw material supplied to the site **shall** be transported on clean, well-maintained temperature controlled vehicles that pose no risk of product contamination.

d) Each consignment of pork raw material **shall** be carefully examined on arrival to ensure that it is compliant with specification, free from contamination and indications of spoilage and that assured status and traceability back to source has been maintained.

**Guidance:** If incoming pork material is not being received at the time of the audit, verification shall be sought by talking to key personnel to confirm the system for the transport of product. Verification of the cleanliness and temperature compliance may be taken by sampling/examining the most recent deliveries in the intake chill or associated areas.

Packaging shall be appropriate to the product being delivered. E.g. naked product delivered in dolavs/shrouded (liners). Vacuum packed product in boxes or containers. Consideration shall be given to the type of product and protection of any exposed bone for bone-in materials using a secondary layer of packaging.

**Evidence:** Documented procedure. Visual inspection of the incoming material. Checks on the integrity of packaging. Examples of intake records since the last audit.

3.2

a) The doors of the delivery vehicle **shall** remain closed up to the point when the product temperature is being checked.

b) During transport and on arrival the temperature of chilled pork raw material **shall** not fall outside of the range of -2°C to +5°C.

c) The target temperature of frozen pork raw material **shall** be -18°C or less during transport and **shall** not exceed -12°C at intake.

**Guidance:** Verification is invariably undertaken whilst the product is on the delivery vehicle and at different points within the storage unit of the transporter. Whether a ‘between pack’ or ‘product core’ temperature is recorded this shall be determined by the product type, e.g. unwrapped, overwrapped or packed.

Further verification may be sought by checking the temperature recording instrument of the vehicle.

**Evidence:** Examples of intake records since the last audit.

3.3

Each batch of pork raw material **shall** be marked or labelled with the following as a minimum requirement on intake:

a) Site identification code (health mark)

b) Product description

**Guidance:** Whether the material is being transported in dolav, rigid container or as boxed, the labelling information shall remain attached to the unit.

For clarification:

a) As read.
d) Traceability batch code  

b) Description of product e.g. rindless bellies.  
c) Weight. The number of units may also be indicated.  
d) In the majority of cases the traceability batch code is the kill date however, where a production date is used, the information shall be able to trace the product backwards to a kill date. Slaughter code may be in ‘Julian’ calendar format or the actual kill date may be shown.  
e) The lettering BQAP may be used to confirm the products’ assured status to relate to the product within the container/box. Non-eligible material shall not be packed within the same dolav, container or box.  
f) Where pigs are born, reared and slaughtered in one country, a single statement of origin is sufficient for the traceability declaration.  
g) As read.  
h) As read.  
i) As read.  

Evidence: Verification of labelling or markings.

3.4  
a) The site shall have a microbiological sampling plan and testing schedule that covers the scope of all incoming pork raw material. The sampling plan shall relate to the number of suppliers (including those transferred between sites of the same company) and the volume of material and the range of cuts being processed.  

b) The scheme participant shall have undertaken a risk assessment to justify the frequency of microbiological sampling.  
c) The microbiological condition of the incoming pork shall meet the following standard:  

<table>
<thead>
<tr>
<th></th>
<th>Target</th>
<th>Upper Limit</th>
</tr>
</thead>
<tbody>
<tr>
<td>ACC</td>
<td>&lt;1 x 10⁴ cfu/g</td>
<td>1 x 10⁶ cfu/g</td>
</tr>
</tbody>
</table>

d) Where microbiological results above these targets are found, there shall be evidence that these are subject to trend analysis and that corrective action has taken place.

Guidance: As read.
Evidence: a) Sampling plan and testing schedule.  
b) Copy of risk assessment.  
c) Examples of microbiological reports since the last audit.  
d) Trend analysis and where applicable corrective action reports since the last audit.

4.0 Temperature control and storage  

4.1 a) The storage area shall be capable of maintaining product temperatures within specification and operated to ensure specified temperatures are maintained. The operational

Guidance: The storage area may be equipped with auto door closure, air or strip curtains to minimise ingress of warm air during stock transfers. Dependent on the process e.g. cold storage or
capability of the temperature monitoring system **shall** ensure that the specified temperature can be achieved at maximum load.

b) The temperature of chilled pork raw material during storage **shall** be -2°C to +5°C.

c) The temperature of meat preparations during storage **shall** be between -2°C to +4°C.

d) The temperature of offal during storage **shall** be between -2°C to +3°C.

e) Where deep chilling is carried out, the process **shall** be validated to ensure product quality and safety. Deep chilled material **shall** be suitably packaged and labelled with a durability date.

f) The temperature of frozen pork raw material during storage **shall** be -18°C or colder.

tempering the refrigeration temperature may be set to a target temperature to allow for temperature fluctuations caused by defrost cycles, doors opening during stock transfer etc.

It may be acceptable for the air temperatures to be exceeded for short periods during defrost cycles/stock transfer etc. providing the product temperature remains within specification.

**Evidence:** Examples of temperature control records since the last audit.

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4.2

a) Chilled pork raw material **shall** be processed within kill +4 days. However, provided that the raw material is held in chill rooms which are not disturbed, the storage period **may** be extended by up to three days. Additional storage life **may** be permitted e.g. by vacuum packing, gas flushing and/or deep chilling.

b) Shelf life **shall** be established by a combination of sensory and microbiological evaluation.

c) Any extension to shelf life in excess of kill +4 days **shall** be subject to satisfactory documented shelf life verification that shows that the extension of life does not, under worst case conditions, adversely affect product quality.

d) Chill temperature, traceability and shelf life records **shall** be maintained.

**Guidance:** For a co-located site where the pork has been slaughtered, cut and processed on the same site, extension of life beyond kill + 4 days can be verified through the review of chill temperature monitoring records, without the requirement to package or deep chill the raw material.

**Evidence:** Examples of temperature monitoring records since the last audit. Review kill dates aligned to storage period. In relation to vacuum packed, gas flushed or deep chilled raw material, additional supporting evidence e.g. shelf life records.

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4.3

Where frozen:

a) Pork raw material **shall** be labelled with a date of kill. It **shall** not exceed kill +4 days at the point of freezing however, an extension **may** be made when the pork raw material is vacuum packed or gas flushed and it has been held in chilled conditions at +3°C or colder. Any extension **shall** be subject to satisfactory documented shelf life

**Guidance:** The integrity of the packaging shall be appropriate for the product.

**Evidence:** Review examples of stock control and defrost records since the last audit. Visual inspection of storage area to include product labelling. Review the documented procedure for the defrosting of frozen product process and align to participant’s processing specification.
verification that shows that the extension of life does not, under worst case conditions, adversely affect product quality.

b) The pork material shall be in good condition at the time of freezing and shall be effectively packaged to prevent contamination and degradation of quality.

c) Pork raw material to be frozen shall be placed into a freezer immediately following receipt.

d) Frozen pork shall be labelled with a freezing durability date and it shall not be stored for longer than 12 months.

e) Where frozen product is to be defrosted (tempered), it shall be carried out to a documented and validated procedure in line with the scheme participant’s processing specification.

f) Stock control and defrost records shall be maintained.

4.4 All pork raw material shall be used within its stated durability date.

Guidance: As read.

Evidence: Examples of shelf life records since the last audit. Verification of maximum period of storage.

5.0 Processing standards

5.1 a) All documented procedures, work instructions, quality attribute specifications (QAS), in-house ‘mini specifications’ and finished product specifications shall specify the product type being manufactured and relevant staff shall be trained against them.

b) The in-house ‘mini specification’ shall be developed in line with the QAS specified in clause 7.2.1 and it shall provide through the use of words, measurements and/or photographs, specific quality attributes relating to defines acceptable and unacceptable key attributes for each finished product approved by the BQAP module.

c) This information shall be prominently displayed at appropriate points of the production line to assist with quality monitoring and compliance.

Guidance: The ‘mini specification’ is a short version of specific key quality attributes from the QAS displayed on the manufacturing line.

Evidence: Visual inspection of butchery and finished product standards at point of production. Review ‘mini specification’, records of QAS verification check and evidence of siting the pictorial information and that the mini spec displayed is relevant to the product going down the packing line at the time of the audit. Training records of relevant staff.
5.2 a) In-process checks shall be undertaken to monitor the product temperature up to the point of packing and the details shall be recorded.

b) During cutting and packing operations the temperature of pork raw material shall not exceed +5°C (+3°C for offal).

**Guidance:** As read.

**Evidence:** Examples of product temperature records aligned to in-process and up to the point of packing since the last audit.

6.0 **Traceability and mass balance**

6.1 All pork raw material shall be identified as BMPA Quality Assured Pork or “BQAP” by labelling of the rack, chandelier or other transport medium.

**Guidance:** As read.

**Evidence:** Visual inspection of labelling.

6.2 Each batch of pork to be used as a raw material for the manufacture of any BMPA pork scheme products shall be marked or labelled with the following information as a minimum:

a) Site identification code (health mark)

b) Product description
c) Weight
d) Traceability batch code
e) Confirmation of assured status
f) Country of birth, rearing and slaughter or statement of pigs’ origin
g) Date of freezing (if frozen)
h) Durability / process-by date

Guidance:** As read.

**Evidence:** Visual inspection of labelling of outer case and/or retail pack.

6.3 a) The scheme participant shall carry out 4 mass balance and 8 traceability audits during each period of certification. The schedule may take into account the mass balance requirements specified within BRC GFS.

b) All scheme participants shall ensure that they have a documented system and schedule for challenging traceability and mass balance of all assured pork raw material, work in progress material (WIP), rework and finished products and that these are clearly identified with assured

Guidance:** Traceability checks are carried out to verify the assured supply chain and mass balance checks may be carried out on part of the process and may include non-eligible products.

Product identification shall facilitate both backwards and forwards traceability i.e. from which batch did it originate and within which batch(s) was it used. See below an example of a suggested schedule. The mass balance and traceability exercises carried out during a BRC GFS and BMPA pork scheme surveillance audit may count towards this.
status at each stage of the process from intake through to dispatch. The system shall facilitate both forward and backwards traceability and mass balance of both assured and non-eligible pork raw material by the conclusion of the audit and that mass balance shall include any wastage and processing yield losses to account for the full batch to be completed within an accuracy of not less than 95% accountability. It shall include all forms of assured pork material used in the product i.e. rind, added back fat etc.

c) The scheme participant shall have a sampling plan for the traceability and mass balance audits that include all the products approved by each module of the BMPA pork scheme and as a minimum one product per month shall be challenged.

d) These traceability and mass balance audits may be undertaken in-house but shall be carried out by a competent, trained individual who is independent of the manufacturing operation. For further guidance, refer to the BMPA pork scheme rules appendix 3 ‘Competency and independence of internal/external auditors undertaking traceability and mass balance audits’ and appendix 4 ‘Traceability and mass balance guidance’.

e) Documentary evidence containing a summary of each traceability and mass balance exercise shall be made available to the service provider to demonstrate that the requirements of the pork scheme are being met.

f) Where a non-conformance is raised for traceability and mass balance exercises, records shall detail evidence of root cause analysis, corrective action and monitoring to prevent the non-conformance from re-occurring.

g) Scheme participants shall carry out a risk assessment at least once during each certification period to verify that the traceability systems and procedures are robust and effective for the identification and traceability of all pork materials.

<table>
<thead>
<tr>
<th>Month</th>
<th>Scope</th>
<th>Basis</th>
</tr>
</thead>
<tbody>
<tr>
<td>April</td>
<td>BRC annual mass balance</td>
<td>On BMPA quality assured product (incorporating a backward trace to farm)</td>
</tr>
<tr>
<td>May</td>
<td>BMPA backward trace to assured farm</td>
<td>On BMPA quality assured product</td>
</tr>
<tr>
<td>June</td>
<td>BMPA forward trace from raw material intake to finished product</td>
<td>*On non-eligible product</td>
</tr>
<tr>
<td>July</td>
<td>BMPA forward mass balance from raw material intake to finished product</td>
<td>On BMPA quality assured product (incorporating a forward trace from raw material intake to finished product)</td>
</tr>
<tr>
<td>August</td>
<td>BMPA backward trace to assured farm</td>
<td>On BMPA quality assured product</td>
</tr>
<tr>
<td>September</td>
<td>BMPA forward trace from raw material intake to finished product</td>
<td>*On non-eligible product</td>
</tr>
<tr>
<td>October</td>
<td>BRC provenance mass balance</td>
<td>On BMPA quality assured product (incorporating a backward trace to farm)</td>
</tr>
<tr>
<td>Month</td>
<td>Action Description</td>
<td>Notes</td>
</tr>
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<td>----------</td>
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<td>----------------------------------------------------------------------</td>
</tr>
<tr>
<td>November</td>
<td>BMPA backwards trace to assured farm</td>
<td>On BMPA quality assured product</td>
</tr>
<tr>
<td>December</td>
<td>BMPA forward trace from raw material intake to finished product</td>
<td>*On non-eligible product</td>
</tr>
<tr>
<td>January</td>
<td>BMPA forward mass balance from raw material intake to finished product</td>
<td>On BMPA quality assured product (incorporating a forward trace from raw material intake to finished product)</td>
</tr>
<tr>
<td>February</td>
<td>BMPA backward trace to assured farm</td>
<td>On BMPA quality assured product</td>
</tr>
<tr>
<td>March</td>
<td>BMPA forward trace from raw material intake to finished product</td>
<td>*On non-eligible product</td>
</tr>
</tbody>
</table>

*Note - sites that do not handle non-eligible material shall carry out the required mass balance and traceability exercises on BMPA quality assured products*

**Evidence:** In seeking compliance, objective evidence shall be aligned to the following sub clauses:
- Clauses 6.3 a), b) and e). Review traceability and mass balance reports since the last audit.
- Clause 6.3 c) review sampling plan.
- Clause 6.3 d) verify independency and competency of the auditor undertaking the traceability and mass balance checks.
- Clause 6.3 f) Where non-conformance has been raised by the independent auditor review evidence of root cause analysis, corrective action and monitoring.
- Clause 6.3 g) Copy of risk assessment.
| 6.4 | In addition to clause 6.3, BQAP participants **shall** ensure that the traceability system is monitored on a weekly basis. The following points clarify the requirements:  

a) The scheme participant **shall** develop an appropriate standard operating procedure (SOP) to assist the independent auditor in undertaking the weekly traceability audit. The SOP **shall** detail the traceability documentation to be collated.  

b) The weekly traceability audit **shall** be completed using the BQAP Traceability Audit form (Appendix 2). A copy of the traceability audit and supporting documentation **shall** be retained on file for a minimum of 6 months.  

c) The task is to independently verify that the traceability systems are being operated correctly as follows:  

i) For an abattoir 3 slap marks from 3 separate producers from the same kill date **shall** be checked against the pig producer’s animal movement document. Verification of the slap mark **shall** include the assured status of the farm, livestock vehicles and where applicable assured collection centres using the relevant assurance checker.  

ii) For a standalone cutting/packing plant a sample of finished product from 3 separate production dates of the same week **shall** be checked. Verification of the traceability system **shall** be back to intake.  

d) The independent auditor **shall** report any irregularities found directly to a senior manager within the company using the BMPA traceability audit non-conformance report in Appendix 3 and establish root cause and implement corrective action.  

e) Consignment documentation retained with the traceability audits **shall** show that the product is designated as BQAP. |

**Guidance:** For clarification the following requirements apply for the backward trace:  

**Standalone abattoirs and co-located sites i.e. slaughter, cutting and further processing on the same site:** The weekly traceability audit shall be back to farm.  

**Standalone cutting plants and further processors:** The weekly traceability audit shall be back to point of intake at the site.  

**Evidence:** In seeking compliance verification shall be aligned to the following sub clauses:  

- **Clauses 6.4 a) and c)** review a comprehensive sample of the weekly traceability reports since the last audit. Verify that the correct version of the traceability audit form has been used.  

- **Clause 6.4 b)** verify independency and competency of the auditor undertaking the traceability audits.  

- **Clause 6.4 d)** where a non-conformance has been raised verify that the correct version of the non-conformance has been used by the independent auditor, review evidence of root cause analysis and corrective action.
### 7.0 Finished product standards

#### 7.1 Product specifications

7.1.1 All BQAP carcases, primals and cuts **shall** achieve the standards set by the BMPA Quality Assured Pork module as well as the following quality attributes:

a) The fat **shall** be firm and white.

b) The muscle **shall** be firm and of good colour without evidence of being pale, soft, exudative (PSE) or dark, firm, dry (DFD).

c) The muscle and fat **shall** show no sign of excessive bruising and blood splash.

d) Product **shall** be clean and free from extraneous matter.

e) Joints **shall** be separated by clean cuts and free from unnecessary cuts, slash marks and free from loose pieces of meat and exposed glands.

f) Rind-on cuts **shall** be free from hair, cuts and loose skin.

g) A maximum rind side blemish score of 2 on the Agricultural and Horticultural Dairy Board (AHDB) 5 point scale is permitted (see appendix 1). Carcases that do not meet this standard **may** be classified as BQAP provided that they conform in all other respects with the product specification and that they are further processed for rindless products only.

h) Rind-on cuts **shall** be sourced from carcases of P2 maximum 16mm or P1+P2 maximum 32mm.

i) Where carcases are scanned, a measured lean percentage of 52% **shall** be treated as equivalent to this grade. Carcases or primals in excess of this grade **may** be utilised providing fat is trimmed to meet the above specification.

### 7.2 Quality standards

7.2.1 a) The scheme participant **shall** monitor the quality attributes of each product type certified by this module against a documented quality attribute specification (QAS) that has been formally agreed by the supplier and customer.

**Guidance:** The QAS is the formal agreement on quality parameters by the scheme participant and their customer.

**Evidence:** Review examples of formally agreed QAS

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**BMPA Pork Scheme Operations Manual**
All products **shall** achieve the standards set by the BMPA Quality Assured Pork module.

b) Where product is to be despatched for further processing e.g. prinals, the QAS monitoring **shall** be undertaken post butchery up to the point of despatch.

c) Where there is evidence of attribute failure, the site **may** investigate the root cause, agree and implement corrective action to minimise/prevent the issue from re-occurring. Follow up checks **may** be undertaken.

and that these are aligned to the approved products listed on the certificate of conformity. Visual inspection of finished product standards. Review examples of daily records of QAS verification checks since the last audit.

| 7.2.2 | a) A documented procedure for organoleptic testing **shall** be in place and assessments **shall** be conducted by a member of staff who is trained against the procedure.  
b) An organoleptic sampling schedule **shall** be established for pork prinals, food service and retail packs of pork certified by the BMPA Quality Assured Pork module at an appropriate frequency and as a minimum once per week to demonstrate compliance against the documented QAS. The product assessment **shall** include tenderness, succulence, flavour and visual appearance.  
c) Records of assessment **shall** be retained. Where there is evidence of attribute failure, the site **shall** investigate root cause and implement corrective action to minimise/prevent the issue from re-occurring and this this **shall** be documented. |
| Guidance: As read. |
| Evidence: Review of organoleptic testing procedure, sampling schedule, assessment and training records. |

| 7.3 | Technical standards |
| 7.3.1 | Microbiological standards: |
| a) The site **shall** have sampling plans in place for the routine monitoring of finished product. The scope of the sampling plan shall cover those approved products listed on the certificate of conformity.  
Finished products **shall** be tested weekly in accordance with a documented sampling schedule to demonstrate compliance with the following microbiological targets: | Guidance: As read. |
<p>| Evidence: Review sampling schedule aligned to the scope of approved products and microbiological reports since the last audit. Evidence of corrective actions taken where non-conformance has been highlighted. |</p>
<table>
<thead>
<tr>
<th>Target</th>
<th>Upper Limit</th>
</tr>
</thead>
<tbody>
<tr>
<td>ACC</td>
<td>$&lt; 1 \times 10^4$ cfu/g</td>
</tr>
</tbody>
</table>

b) Where non-conformance is highlighted there **shall** be evidence that this is subject to investigation via trend analysis or other specific corrective actions.
### 8.0 Requirements for external cold stores

#### 8.1 Reception into external cold store

| 8.1.1 | a) The cold store shall have in place a documented procedure and records for the reception, examination and temperature monitoring of all deliveries and a system for notification to the supplier shall be in place if the requirements are not met.  

b) During transport, pork raw material shall be either hung on clean well-maintained stands/hooks or supplied in covered, clean, intact containers, cartons or trays that pose no risk of contamination to the contents.  

c) Pork raw material shall be transported on clean, well-maintained temperature controlled vehicles that pose no risk of product contamination.  

d) Each consignment of pork raw material shall be carefully examined on arrival to ensure that it is compliant with specification, free from contamination and indications of spoilage and that assured status and traceability back to source has been maintained. |

**Guidance:** If product is not being received at the time of the audit, verification shall be sought by talking to key personnel to confirm the system for the transport of product. Verification of the cleanliness may be taken by examining the cleanliness of any deliveries in the intake chill or associated area.  

Packaging shall be appropriate to the product being delivered. E.g. naked product delivered in dolavs/shrouded (liners). Vacuum packed product in boxes or containers.  

**Evidence:** Documented procedure aligned to clause 8.1.1 a). Visual inspection of interior of transport, condition of storage containers for product, integrity of packaging (where applicable). Examples of intake records since the last audit.

| 8.1.2 | a) The doors of the delivery vehicle shall remain closed up to the point when the product temperature is being checked.  

b) During transport and on arrival the temperature of chilled pork raw material shall not fall outside of the range of -2°C to +5°C.  

c) The target temperature of frozen pork shall be -18°C or less during transport and shall not exceed -12°C at intake. |

**Guidance:** Verification is normally undertaken whilst the product is on the delivery vehicle and at different points within the storage unit of the transporter.  

Verification shall be sought by checking the temperature recording instrument of the vehicle.  

**Evidence:** Verification of product temperature records during transport and at point of receipt since the last audit.

#### 8.2 Temperature control and storage

| 8.2.1 | a) The storage area shall be capable of maintaining product temperatures within specification and operated to ensure specified temperatures are maintained. The operational capability of the temperature monitoring system shall ensure that the specification can be achieved at maximum load.  

b) The temperature of chilled pork raw material during storage shall be -2°C to +5°C. |

**Guidance:** The storage area may be equipped with auto door closure, air or strip curtains to minimise ingress of warm air during stock transfers. Dependent on the process e.g. cold storage or tempering the refrigeration temperature may be set to a target temperature to allow for temperature fluctuations caused by defrost cycles, doors opening during stock transfer etc.  

**Evidence:** The following sub clauses shall be verified:  
- Clause 8.2.1 a) records of temperature monitoring
<table>
<thead>
<tr>
<th>BMPA Pork Scheme Operations Manual</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>8.2.2</strong> The freezing of pork raw material:</td>
</tr>
<tr>
<td>a) Pork raw material <em>shall</em> not exceed kill+4 days at point of freezing.</td>
</tr>
<tr>
<td>b) The pork material <em>shall</em> be in good condition at the time of freezing and <em>shall</em> be effectively packaged to prevent contamination and degradation of quality.</td>
</tr>
<tr>
<td>c) Pork raw material to be frozen <em>shall</em> be placed into a freezer immediately following receipt.</td>
</tr>
<tr>
<td>d) Frozen pork <em>shall</em> be labelled with a date of kill, freezing durability date and <em>it shall</em> not be stored for longer than 12 months.</td>
</tr>
<tr>
<td>e) Frozen pork <em>shall</em> be stored at -18°C or colder.</td>
</tr>
<tr>
<td>f) Where frozen product is to be defrosted (tempered), this <em>shall</em> be in line with the scheme participant’s specification. The tempering process <em>shall</em> be to a documented and validated protocol.</td>
</tr>
<tr>
<td>g) Stock control and defrost records <em>shall</em> be maintained.</td>
</tr>
</tbody>
</table>

**Guidance:** The integrity of the packaging shall be appropriate for the product. The site may have procedures in place for the control of stock and this shall be supported by stock control checks.

**Evidence:** Visual inspection of storage area to verify integrity of packaging. Verification of product labelling in storage. Review documented protocol for tempering process. Examples of stock control and temperature control records since the last audit.

| **8.2.3** The cold store *shall* have procedures in place for the control of stock and this *shall* be supported by stock control checks. |

**Guidance:** As read.

**Evidence:** Examples of stock control checks since the last audit. Verification of the process for the movement and stock control of product on site.
### 8.3 Product identification and traceability

#### 8.3.1

Scheme participants **shall** carry out a risk assessment of the cold store to verify that the traceability systems and procedures are robust and effective for the identification, stock rotation, handling and traceability of all materials received by the cold store.

**Guidance:** The labelling of pork material shall clearly indicate that the pork material is assured and the product is traceable to point of intake at the cold store.

**Evidence:** Copy of risk assessment undertaken. Discussion with key site personnel to confirm the systems for the identification, traceability and segregation of assured and non-assured product. Review sites documented procedures and their appropriateness.

#### 8.3.2

Scheme participants **shall** ensure that the cold store traceability system is independently monitored on a regular basis. The following points clarify the requirements:

- **a)** These audits **shall** be undertaken by the scheme participant and **may** be an extension to the scope of the monthly traceability and mass balance checks undertaken at the participant’s site.
- **b)** These audits **shall** be carried out by someone competent and independent of the cold store operation.
- **c)** Traceability and mass balance checks of the raw material back to intake **shall** be undertaken in alternate months to check that the materials in the cold store comply with the requirements of the pork scheme.
- **d)** Documentary evidence containing a summary of each traceability and mass balance check undertaken **shall** be made available to the service provider to demonstrate that the requirements of the pork scheme are being met.

**Guidance:** At the time of the announced surveillance audit, the service provider shall undertake a mass balance exercise and challenge simultaneously the robustness and effectiveness of the traceability systems and procedures at the cold store. The service provider shall record the details from a specific batch of assured material received from the cold store at the processing site, establish the size of the batch and systematically challenge the mass balance, verifying the ‘road map’ e.g. volumes despatched/received and destination.

Consideration shall be given to any remaining batches/volumes still held in stock at the cold store and whether the volumes reconcile with the original quantities despatched/received at the processing site. It is expected that the scheme participant shall have developed appropriate procedures to assist the independent auditor in undertaking the traceability exercise at the cold store.

The verification of the traceability exercise shall include all the process steps at the cold store including associated delivery and despatch documentation. The procedure shall detail the administration that shall be used to carry out the traceability exercise and the documentation to be collated. The procedure shall detail the system for the management of non-conformances that may arise.

**Evidence:** Copies of the traceability and mass balance exercises. Non-conformance reports to include root cause analysis, corrective action and monitoring.
8.3.3 Each batch of pork to be used as a raw material for the manufacture of any BMPA pork scheme products **shall** be marked or labelled with the following as a minimum requirement on reception, storage and despatch:

a) Site identification code (health mark)  
b) Product description  
c) Weight  
d) Traceability batch code  
e) Confirmation of assured status  
f) Country of birth, rearing and slaughter or statement of pigs’ origin  
g) Date of freezing on all frozen raw material  
h) Process-by or use by date  
i) Kill date

**Guidance:** Whether the material is being transported in dolav, rigid container or as boxed, the labelling information shall remain attached to the unit.

For clarification:

a) Scheme participant’s site licence number.  
b) Description of product e.g. rindless bellies.  
c) Weight. The number of units may also be indicated.  
d) In the majority of cases the traceability batch code is the kill date however, where a production date is used, the information shall be able to trace the product backwards to a kill date. Slaughter code may be in ‘Julian’ calendar format or the actual kill date may be shown.  
e) The lettering BQAP may be used to confirm the products’ assured status to relate to the product within the container/box. Non-eligible material shall not be packed within the same dolav, container or box.  
f) Where pigs are born, reared and slaughtered in one country, a single statement of origin is sufficient for the traceability declaration.  
g) As read.  
h) As read.  
i) As read.

**Evidence:** Verification of labelling or markings.
Appendix 1 - AHDB Blemish Scale

1. Unblemished
2. Very slight blemish
3. Slight blemish
4. Moderate blemish
5. Severe blemish
Appendix 2 - BQAP Traceability Audit Form

Plant Name: ........................................

Date of Audit: .........................  Carried out by: ...........................................................(Print name)

1.0 For abattoirs:
1.1 Have all current producers supplying pigs to the site for the BMPA pork scheme been certified to the Red Tractor, Quality Meat Scotland or an equivalent farm assurance scheme recognised by the BMPA?  Yes/No

1.2 Three different carcase slap marks to be checked:

<table>
<thead>
<tr>
<th>Slap mark</th>
<th>Date of Kill</th>
<th>RTA or QMS Farm Assurance Number</th>
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1.3 Can each slap mark be reconciled with the consignment’s animal movement document?  Yes/No

1.4 Has the animal movement document been completed fully and correctly?  Yes/No

1.5 Where a collection centre has been used, has the approval status of these facilities been verified?  Yes/No/NA

1.6 Three different carcase slap marks checked  Name of Collection Centre  RTA Certification Number

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1.7 If the site slaughters both farm assured and non-farm assured pigs, is a batch code system used to identify and segregate carcases?  Yes/No/NA

1.8 Are all BQAP products for despatch clearly identified to allow traceability to a batch of a maximum of one day’s kill or defined production run?  Yes/No

1.9 Are carcases/sides labelled as BQAP and/or have a unique identification mark to confirm the assured status?  Yes/No

2.0 For cutting plants and further processors:

2.1 Has the assurance status of all incoming BQAP material been verified?  Yes/No/NA

2.2 Is all BQAP material correctly labelled?  Yes/No

2.3 Does the scheme participant have a documented traceability system for all BQAP products?  Yes/No

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 Three different finished products to be traced

<table>
<thead>
<tr>
<th>Product Description</th>
<th>Pack Date</th>
<th>Product Traceability Code</th>
<th>BQAP supplier name</th>
<th>BQAP participant number</th>
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In the event of any non-conformance, enter the name of the senior plant manager who has been notified (Manager’s name..........................................................)

For any non-conformance, a copy of this report shall be sent to the service provider with the BQAP traceability audit non-conformance report.
# Appendix 3- BQAP Traceability Non-Conformance Report

<table>
<thead>
<tr>
<th>Company Name:</th>
<th>BQAP Module Participant Number</th>
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<tr>
<th>REFERENCE NUMBER</th>
<th>DETAILS OF NON-CONFORMANCE</th>
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Auditor’s Signature ........................................

Print Name ...................................................

Date.........................................................

(The completed form shall be sent to the service provider’s schemes manager)