

# BMPA Standard

## Module: British Quality Assured Pork

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

British Meat Processors Association  
12 Cock Lane  
London  
EC1A 9BU

Tel: 020 7329 0776  
[Email: info@bmpa.uk.com](mailto:info@bmpa.uk.com)  
Website: [www.bmpa.uk.com](http://www.bmpa.uk.com)

# **BMPA Standard – British Quality Assured Pork**

## **Contents**

Introduction	1.0
General Requirements	2.0
Pork Supplies	3.0
Food Safety and Quality Policy	4.0
Temperature Control	5.0
Process Control	6.0
Product Identification and Traceability	7.0
Storage	8.0
Specifications	9.0
Use of the Quality Assurance Mark for Pork	10.0

<u>Appendices</u>	<u>Number</u>
Pork eating quality assessment	1
Traceability in plant, BQAP audit and traceability report	2
Useful publications and contacts	3

# 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 (Red Tractor Farm Assurance - Pigs and equivalent) and contributes to the assurance behind the Assured Food Standards Red Tractor 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 Standard for Food Safety (Current Issue).** 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 European Food Hygiene Regulations 2004 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 audits annually one of which will be unannounced, which shall be undertaken by the BMPA appointed service provider. One of these should be carried out in conjunction with the BMPA core standard audit. (The BRC Global Standard for Food Safety)

- 2.3.2 Where a participant uses an alternative provider for their BRC audit the annual Scheme inspection must be undertaken on an alternative day by the BMPA service provider.
- 2.3.3 Participants are advised that a non compliance against the BMPA core standard may be identified during a British Quality Assured Pork inspection, these will be recorded and be subjected to the normal non compliance procedure where appropriate.
- 2.3.4 The BMPA appointed service provider for the BMPA Schemes shall implement the required procedures for a non compliance raised against the core standard. This may involve requesting from the participant documented evidence to satisfactorily close out any non compliance raised.
- 2.3.5 In the event of a participant receiving core standard certification from an alternative service provider, the participant shall be required to forward a copy of their current BRC audit report to the BMPA Scheme service provider. If a non compliance is raised at the time of the BMPA Scheme inspection against the BMPA core standard, the current BRC report shall be reviewed to ascertain whether the non compliance is a repeat non compliance and if this has been satisfactorily closed out. This is required to give integrity to the BMPA Schemes where an alternative provider is used.
- 2.3.6 Where an alternative service provider is used and either a Critical or Major Non compliance is raised against the core requirement during a scheme inspection the BMPA service provider shall inform the BMPA and the alternative service provider.
- The BMPA reserves the right to undertake a follow-up or spot check at the participants cost where issues are identified against the core standard during the BMPA Scheme surveillance inspection.
- 2.3.7 The BMPA service provider reserves the right to charge for costs incurred in any administration relating to non compliance raised against the core standard.
- 2.3.8 Where a participant uses the services of an alternative provider for the Global Standard for Food Safety audit (BRC), and a Critical Non Compliance or a Major Non Compliance is raised against a Fundamental clause of the Global Standard for Food Safety or a Product Recall has been instigated, the participant is required to contact the BMPA/BMPA Scheme service provider without delay. This requirement also relates to where a participant may achieve a Grade D on the day of the audit or does not achieve certification against the Global Standard for Food Safety because non compliances had not been satisfactorily closed out within the timescale. The participant shall be required to provide written details of the Critical or Major Non Compliance and further evidence shall be required to confirm the ongoing status in relation to the core standard requirement.
- 2.3.9 When a participant's Certification is suspended it shall be the responsibility of the participant to inform their customer that the sites' Certification has been suspended and that the site cannot make any claim under the Scheme until such time as the sites' certification has been reinstated.

#### **2.4 Notification of Movement of Site**

In the event of a movement or closure of site, the participant shall be required to inform the BMPA in writing of the exact details.

### **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: Red Tractor Farm Assurance - Pigs, Quality Meat Scotland Assurance - Pigs or the Genesis Quality Assurance Pig Module.

If purchased from outside the company, product shall be accompanied by clearly marked documentation which confirms its assured status.

### **4.0 Food Safety and 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 FSA Manual for Official Controls 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 when taken within leg does not fall below 10°C during the first three hours from the commencement of the cooling cycle.
- 5.3 The temperature of deep musculature shall be reduced to -2°C to +5°C within 24 hours 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, recorded 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 risk assessed schedule and details recorded in order to meet the following standard:

TVC	Target	<1 x 10 <sup>4</sup> CFU per gram
	Upper Limit	<1 x 10 <sup>6</sup> 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 identified as British Quality Assured Pork either by proper labelling of the rack, chandelier or other transport medium.

7.3 Wrapped primals shall be clearly identified 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.

Monthly traceability checks shall be undertaken to check that the materials used in manufacture, both meat and non-meat, and packaging, comply with the requirements of this Standard. These inspections may be undertaken in-house, but shall be carried out by someone competent and independent of the manufacturing operation. Records shall be maintained.

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 Red Tractor 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 In addition, each outer case shall be marked or labelled with the following information:
- a) Packer
  - b) Contents
  - c) Weight
  - d) Slaughter code or production code
  - e) Confirmation of BQAP assured status
- 8.4 All pork shall be labelled with a kill date, in addition primals packed in modified atmosphere or vacuum packed shall be labelled as such and a durability date or code should be shown.
- 8.5 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.
- 8.6 Where frozen, the meat shall be in good condition at the time of freezing. Meat shall be effectively packaged. A date of freezing shall be applied to each unit. Frozen pork shall not be stored for longer than 12 months and include a durability date.

## 9.0 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.

### 9.1 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.

### 9.2 Clean carcass specification

- 9.2.1 Carcasses with a P2 or P1 + P3 in excess of the permitted maximum, may be used to produce primals provided they are trimmed.
- 9.2.2 The carcass shall be free from blemish, bruising, hair, cuts and loose skin. The carcass shall have a maximum rind side blemish score of 2 on the AHDB'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.
- 9.2.3 The carcass shall be clean and free from extraneous matter.

9.2.4 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)	P2 Range (mm)	P1 & P3 Range (mm)
(Cold dead weight)		
Max 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 manufactured products. For example sausages and pies. Pluck obtained from an assured source which does not meet the weight requirements may still be marketed as BQAP approved.

### 9.3 **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 9.2.4.

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

### 9.4 **Primals and cuts**

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

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

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

9.4.4 There shall be no evidence of PSE or DFD

## **10.0 Use of the Quality Assurance Mark for Pork**

Only individual products that have been manufactured to the requirements of the British Quality Assured Pork Standard are eligible to be identified with the Red Tractor mark for Pork

It is a requirement that the participating site shall be registered with Assured Food Standards prior to applying 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 the 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 at least weekly for abattoirs, cutting plants and further processors. A copy of the traceability audit form and traceability documentation shall be kept on file.
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.
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" unless pork is bought from third parties.
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 Red Tractor Assurance - Pig Registration Number  

.....	.....	.....
.....	.....	.....
.....	.....	.....
- 1.4 Can the slap mark/s be traced back to a Red Tractor Assurance - 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 for all BQAP product 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 name of the senior plant manager 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:** \_\_\_\_\_

<b>REFERENCE</b>	<b>DETAILS OF NON-COMPLIANCE</b>

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

Additional Information provided by the FSA on HACCP in meat plants is available via the following link: <http://www.food.gov.uk/foodindustry/meat/haccpmeatplants/>

#### Contacts

BMPA (Standard Owner)  
12 Cock Lane  
London  
EC1A 9BU  
Tel: +44 (0)20 7329 0776  
E-Mail: [info@bmpa.uk.com](mailto:info@bmpa.uk.com)  
Website: [www.bmpa.uk.com](http://www.bmpa.uk.com)

Genesis QA  
Ryknield House  
Alrewas  
Staffordshire DE13 7AB  
Tel: +44 (0)1283 791400  
E-Mail: [info@genesisqa.com](mailto:info@genesisqa.com)  
Website: [www.genesisqa.com](http://www.genesisqa.com)

Humane Slaughter Association  
The Old School  
Brewhouse Hill  
Wheathampstead AL4 8AN  
Tel: +44 (0)1582 831919  
Website: [www.hsa.org.uk](http://www.hsa.org.uk)

Assured Food Standards  
4<sup>th</sup> Floor  
King's Building  
Smith Square  
London SW1P 3JJ  
Tel: +44 (0) 7630 3320  
E-mail enquiries@redtractor.org.uk  
Website: [www.redtractor.org.uk](http://www.redtractor.org.uk)

Quality Meat Scotland  
Head Office  
The Rural Centre  
Ingliston  
Newbridge  
Midlothian EH28 8NNZ  
Tel: +44 (0)131 472 4040  
E-Mail: [info@qmscotland.co.uk](mailto:info@qmscotland.co.uk)  
Website: [www.qmscotland.co.uk](http://www.qmscotland.co.uk)

British Pig Executive (BPEX)  
Stoneleigh Park  
Warwickshire  
CV8 2LZ  
Tel: 0247 669 2051  
Website: [www.bpex.org.uk](http://www.bpex.org.uk)

Assured British Pigs  
Unit 4b  
Highway Farm  
Horsley Road  
Downside  
Cobham  
Surrey  
KT11 3JZ  
E-Mail [info@assuredpigs.co.uk](mailto:info@assuredpigs.co.uk)

Assured British Meat  
PO Box 5273  
Winterhill House  
Snowdon Drive  
Milton Keynes  
MK6 1HL  
Tel: + 44 (0)1908 844353  
E-Mail: [abmsec@abm.org.uk](mailto:abmsec@abm.org.uk)  
Website: [www.abm.org.uk](http://www.abm.org.uk)