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الشروط الصحية في مسالخ الدواجن والعاملين بها

**Hygienic Regulations For Poultry Processing  
Abattoirs And Their Personnel**

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## Hygienic Regulations For Poultry Processing Abattoirs And Their Personnel

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## **HYGIENIC REGULATIONS FOR POULTRY PROCESSING ABATTOIRS AND THEIR PERSONNEL**

### **1- SCOPE AND FIELD OF APPLICATION**

This standard is concerned with hygienic regulations which shall be followed in all poultry processing abattoirs and their personnel.

It applies to all premises in which poultry is slaughtered, processed, packed and handled and all premises in which poultry parts and edible parts are processed, packed and handled.

### **2- COMPLEMENTARY REFERENCES**

- 2.1 GSO 149/1993 “Unbottled Drinking Water”.
- 2.2 GSO 21/1984 “Hygienic Regulations for Food Plants and Their Personnel”.
- 2.3 GSO 9/1995 “Labelling of Prepackaged Foods”.
- 2.4 GSO 323/1994 “General Requirements for Transportation and Storage of Chilled and Frozen Foods”.
- 2.5 GSO 969/1997 “Cold Stores for Frozen and Chilled Foodstuffs”.
- 2.6 GSO 1023/2000 “Expiration Periods of Food Products – Part I”.
- 2.7 GSO 993/1998 “Animal Slaughtering Requirements According to Islamic Law”.

### **3- DEFINITIONS**

- 3.1 Poultry abattoir: Premises approved and registered by the controlling authority, used for slaughtering, inspection and preparation of poultry for human consumption.
- 3.2 Poultry : Any domesticated bird including chickens, turkeys, ducks, geese, pigeons, quails, and guinea fowls.
- 3.3 Carcass: The whole body of a bird after slaughtering, bleeding, plucking and eviscerating. However, removal of the kidneys, of the legs at the tarsus, or of the head is optional.
- 3.4 Giblets: The liver from which the bile sac has been removed, the heart and the gizzard from which the lining and contents have been removed and any other edible parts provided that all such material has been properly washed.
- 3.5 Lux : The unit of illumination that can be interpreted as the illumination on a surface at a specified point of one metre distance from light source.

#### 4- REQUIREMENTS

Without prejudice to the requirements of the GSO standard mentioned in 2.2, the following requirements shall be met in poultry processing abattoirs:

##### 4.1 General requirements

4.1.1 An ample supply of both hot and cold water shall be available and distributed to all production lines and other areas in which water is needed. The water used shall comply with the GSO standard mentioned in 2.1.

4.1.2 It is permissible to add chlorine or any other suitable disinfectant (allowed to be used) to the water used in processing lines according to GSO standards issued by GSMO. If chlorine will be used in water tanks, its portion shall not be more than 50 ppm.

4.1.3 The temperature of hot water used for disinfection and washing purposes, while processing, shall not be less than 82°C.

4.1.4 Illuminance in the processing lines should not be less than 400 lux, and in inspection areas it shall not be less than (600) lux. It should not affect colour distinction and be properly directed to the product.

4.1.5 Complete separation shall be made between production stages such that each processing line be separate from the succeeding ones, specially slaughtering, evisceration, cutting, packing and wrapping operations.

##### 4.2 Equipment and utensils requirements

4.2.1 All food contact surfaces shall be non-toxic, smooth and free from unacceptable taste or flavour, and capable of withstanding repeated exposure to normal cleaning. It shall be also free from pits, crevices and loose scale, unaffected by food products and non-absorbent unless the nature of a particular process renders the use of other surfaces necessary.

4.2.2 Stationary equipment and utensils shall be so designed and constructed as to prevent hygienic hazards and permit easy cleaning and disinfection. At the end of each work day, equipment and utensils shall be washed and disinfected with hot water not less than 82°C with the use of approved disinfectants.

##### 4.2.3 Slaughtering and blood collecting equipment

4.2.3.1 Bleeding equipment shall be constructed of non-corrodable metal which is easy to clean.

4.2.3.2 By-product tunnels shall be constructed of non-corrodable metal or any other suitable material. They shall have adequate capacity and be fitted with head shields easily removable for cleaning and the base trough shall have a suitable fall to a by-product container which can be easily emptied and cleaned.

##### 4.2.4 Scalding tanks

4.2.4.1 When scalding tanks are used, particular care shall be taken to ensure they are conforming to hygienic standards. The rate of flow of water into these tanks shall provide for continuous replacement of water so as to minimize the possibility of build-up of contamination.

- 4.2.4.2 The temperature of water inside the scalding tanks be  $55 \pm 1^{\circ}\text{C}$ . Tanks shall be emptied regularly at least once every working day and cleaned well and disinfected.
- 4.2.4.3 Scalding tanks filled with melted wax can be used to pluck the fluff after plucking of feathers.
- 4.2.4.4 The flow rate of water into the tank shall be in the opposite direction to that in which the poultry is travelling, so that the scalded poultry is pulled out on that side of the scalding tanks at which the clean hot water enters the tank.
- 4.2.5 Plucking machines
  - 4.2.5.1 They shall be designed so as to control the scatter of feathers as much as possible, with the continuous removal of feathers from the plucking site.
  - 4.2.5.2 Feathers shall be collected in suitable, clean, covered containers to be disposed of at least once daily.
  - 4.2.5.3 Feathers disposed of by water flushing shall be removed from the water which shall be run to waste.
- 4.2.6 Evisceration
  - 4.2.6.1 Evisceration trough shall be constructed of stainless steel or any other suitable material.
  - 4.2.6.2 The main water flow shall be in the opposite direction to that in which carcasses are travelling and shall be commensurate with the rate of production flows.
  - 4.2.6.3 Supply of both cold and hot water should be provided along both sides of the evisceration trough to ensure cleaning of carcasses from outside and inside, disinfection of knives, tools, and aprons when necessary.
  - 4.2.6.4 Evisceration vent machines shall be flushed with water between venting operations.
  - 4.2.6.5 Washing equipment shall be designed to be commensurate with the rate of production flow. Trickle jets of water shall be enough to ensure proper cleaning of the entire carcass from inside.
  - 4.2.6.6 Containers for collecting inedible materials shall be leakproof and constructed from metal or other suitable impervious materials which are easy to clean and equipped with tightly fitted covers.
  - 4.2.6.7 In case of using inclined channels or any other method to get rid of the waste, they shall be designed so as to prevent contamination, off odours and the accumulation of waste on the sides.
- 4.3 Ante-mortem health inspection
  - 4.3.1 Poultry intended for slaughter should undergo ante-mortem health inspection by veterinarians within 24 hours of arrival at the slaughter house. Such inspection shall be repeated before slaughter if this takes more than 24 hours after the ante mortem health inspection.
  - 4.3.2 Slaughtered poultry shall be free from symptoms indicative of diseases and shall be free also from diseases communicable to humans or animals.

- 4.3.3 They shall be free from any symptoms of disease or disorders affecting their health condition thus making their meat unfit for human consumption.
- 4.4 Processing requirements
  - 4.4.1 Areas where birds are kept and eggs are collected, or used for the storage of animal feeds shall be separated from slaughtering, cleaning and packing areas.
  - 4.4.2 Cages and transportation vehicles shall be cleaned and disinfected at least once daily. The premises shall be provided with separate areas for waste dumping or with adequate storage facilities for waste.
  - 4.4.3 Unfit poultry or poultry suspected of being diseased shall be immediately segregated from the production line and shall not be kept unsegregated till the outlet end of the production line.
  - 4.4.4 Suitable precautions shall be taken to assure that all waste is cleared in such a way as not to cause hazards to public health or environment and that all necessary measures are taken to protect the product against contamination by the waste.
- 4.5 Slaughter and evisceration
  - 4.5.1 Slaughtering shall be carried out in accordance with the GSO standard mentioned in 2.7.
  - 4.5.2 Bleeding shall be completed to ensure the death of the bird and shall be carried out so properly that any blood flowing outside the slaughter area shall not cause contamination of carcasses.
  - 4.5.3 Poultry shall be thoroughly plucked immediately after slaughter.
  - 4.5.4 Immediately after plucking, evisceration shall be carried out in such a way as to avoid contamination. Each carcass shall be opened in such a way that all cavities and the viscera can be inspected.
  - 4.5.5 After inspection, the viscera which have been brought out shall be immediately separated from the carcass, and the parts unfit for human consumption removed.
  - 4.5.6 Parts of the viscera remaining in the carcass, with the exception of kidneys, shall be removed under satisfactory hygienic conditions, (turkeys excluded).
  - 4.5.7 Carcasses declared unfit for human consumption shall be segregated and feather and waste shall be hygienically cleared.
  - 4.5.8 Carcasses shall not be cut into portions or subjected to any processing, without the official veterinary inspection.
- 4.6 Post-mortem inspection
  - 4.6.1 Visual inspection of bird immediately after slaughter.
  - 4.6.2 Inspection of carcasses by palpation to ensure absence of incisions or bruises in the slaughtered bird.
  - 4.6.3 Investigation of anomalies in consistency, colour and smell, to reject if any.

- 4.6.4 Records of poultry meat entering and leaving the cutting premises shall be maintained.
- 4.6.5 If necessary, samples shall be taken to the laboratory for examination to detect the presence of harmful micro-organisms, additives or any chemical substances that may be hazardous to the public health, and the results of any such examinations shall be kept in a register, for reference whenever needed.
- 4.7 Cutting and deboning operation
- 4.7.1 Ensure that cutting and/or deboning of poultry meat shall only take place in the cutting premises.
- 4.7.2 Ensure that no poultry meat is cut or deboned at a temperature higher than 4°C.
- 4.7.3 Whether before or after cutting or deboning process, poultry meat shall not be cleaned by use of cloth or paper but shall be cleaned by water flow or by air pressed water.
- 4.8 Chilling process
- 4.8.1 Equipment used for chilling poultry meat and other edible materials shall be constructed of stainless steel or any other suitable material and shall be operated and maintained in a way as to decrease growth and multiplication of micro-organisms.
- 4.8.2 When ice is used as a means of chilling the following shall be observed:
- 4.8.2.1 Water used in the manufacture of ice shall comply with the GSO standard mentioned in 2.1.
- 4.8.2.2 The ice used in chilling shall not have been previously used in any of the processing stages.
- 4.8.2.3 Ice shall be stored and handled in a hygienic manner so as to be protected against contamination.

## 5- PACKING

- 5.1 Packing speed shall be commensurate with the rate of production flow taking into consideration to avoid accumulation of carcasses in the packing area.
- 5.2 Packing area shall be completely separated from the production area and shall be well-ventilated and lighted. The temperature inside the packing area shall not exceed 10°C.
- 5.3 The materials used for the packing of poultry shall be hygienic and adequately durable so as to protect the product from contamination and deterioration.
- 5.4 The packing materials shall not be re-used.

## 6- STORAGE

Without prejudice to the requirements of the GSO standard mentioned in 2.4, the following shall be observed:

- 6.1 Slaughterhouses shall have suitable facilities for chilled or frozen storage and shall comply with the draft GSO standard mentioned in 2.5.
- 6.2 The areas for loading and unloading poultry meat shall be roofed to avoid contamination.
- 6.3 The ambient temperature inside the carcass shall not exceed 4°C.
- 6.4 Effective measures shall be taken to get rid of insects, vermins, rodents and fungi, with necessary precautions to avoid contamination of carcasses.
- 6.5 Birds and animals shall not be allowed to enter the cold stores.
- 6.6 Only approved cleansing materials and disinfectants shall be used in food plants.

## **7- HYGIENIC REGULATIONS**

- 7.1 Visitors and personnel working in areas for keeping live birds, feeding stuffs or other similar material shall not be permitted in other sections of the premises where poultry are being processed unless adequate measures are taken to prevent contamination.
- 7.2 Poultry handlers, and other persons who come into contact with poultry in abattoirs shall be medically examined by the official health authorities prior to their employment, and each person shall carry a valid health certificate. The medical examination shall give particular attention to incisions, sores, and infectious diseases such as parasitic diseases, salmonella and respiratory and digestive system diseases. They shall be re-examined regularly to ensure their continuous fitness.

## **8- HYGIENIC CONTROL PROGRAMME**

- 8.1 A comprehensive quality control laboratory shall be provided to carry out the necessary tests concerning the product, the slaughterhouse, equipment, and utensils to ensure that they are free from pathogenic micro-organisms.
- 8.2 The staff responsible for the quality control and food inspection shall be mainly designated for this purpose provided that their duties are divorced from production and shall have experience in food industries and quality control.
- 8.3 A single individual shall be designated as responsible for cleansing, whose duties are divorced from production, together with permanent assistants well-trained in the use of cleaning tools.

## **9- HYGIENIC TRAINING FOR THE STAFF**

Training programme for the hygienic handling of poultry and cleaning methods shall be organized for the staff