

Western Australia

# **Poultry Processing Establishments Regulations 1973**

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# Poultry Processing Establishments Regulations 1973

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**NOTES**



## **Poultry Processing Establishments Regulations 1973**

**1. Citation**

These regulations may be cited as the *Poultry Processing Establishments Regulations*.

**2. Effect**

These regulations have effect in the whole of each district in the State.

**3. Interpretation**

In these regulations unless the contrary intention appears —

**“bar cut”** means the excision of the cloaca, together with a horizontal cut across the bird between the thighs;

**“carcase”** means any poultry carcase;

**“denatured”** means the carcase or portions of the carcase have been subjected to the application of crude oil, kerosene, dye or other material or procedure so as to preclude use for human consumption;

**“dressed poultry”** means poultry which has been slaughtered for human food with head, legs and viscera intact and from which the blood and feathers have been removed;

**“giblets”** means the liver from which the bile sac (gall bladder) has been removed, the heart with or without the pericardial

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sac and the gizzard from which the lining contents have been removed;

**“poultry”** means any live or slaughtered domesticated bird including chicken, turkey, duck, goose, guinea fowl, pigeon or pheasant;

**“poultry product”** means any food product consisting of edible poultry or poultry in combination with other ingredients;

**“poultry processing establishment”** means any premises where poultry which is intended for sale for human consumption is killed, dressed or processed for marketing but does not include a retail establishment where poultry is subsequently sold to the public;

**“process”, “processing”, “processed”** means any operation or combination of operations at a poultry processing establishment whereby poultry which is intended for sale for human consumption is killed, dressed, eviscerated, cut up, heat treated, canned, packed, repacked, re-processed, or changed in shape or form for marketing;

**“smooth”** when used in relation to walls, ceilings and partitions means a surface which is as smooth as cement plaster finished with a steel trowel and when used in relation to floors means a surface which is as smooth as concrete finished with a wood float.

**4. Poultry processing establishments to be inspected**

The local authority shall cause each poultry processing establishment in its area to be inspected at least once each month during periods when poultry processing operations can be observed.

**5. Poultry processing to be carried out under certain conditions**

Poultry processing operations shall be carried out under the following conditions —



- (a) sufficient room shall be provided so that no process in the poultry processing operations is carried on in crowded conditions;
- (b) live poultry shall be kept separated from all poultry processing operations except that the killing and scalding operations may be carried on in the same area if the carcasses are immediately removed to a poultry dressing room;
- (c) poultry dressing operations, including removal of feathers and venting shall be carried on in a poultry dressing room separate from all other poultry processing operations, except that killing and scalding operations may also be carried on in that room;
- (d) eviscerating operations shall be carried on in an eviscerating room separate from all other poultry processing operations, except that pinning, chilling, cutting up, grading, thawing and packing of the dressed eviscerated poultry may also be carried on in that room if the operations are so segregated that they are carried on in a sanitary manner;
- (e) further processing of eviscerated poultry such as stuffing, boning, smoking, canning or cooking shall be conducted in a room or rooms separated from all other poultry processing operations and such room or rooms shall not be used concurrently for any other purpose.

**6. General procedures to be followed**

- (1) The owner or occupier of a poultry processing establishment shall cause the following general procedures to be followed —
  - (a) poultry shall be placed in bleeding cones or otherwise suspended for bleeding and shall not be placed in barrels or on the floor for that purpose;
  - (b) scald tanks shall be supplied with an adequate continuous flow of water during periods of use;

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- (c) clean wax shall be used at all times for the wax dipping of carcasses; and
  - (d) vestigial hair and down shall be removed from poultry carcasses at the poultry processing establishment.
- (2) A person eviscerating poultry in a poultry processing establishment shall not —
- (a) pull the vent outward and excise it, thus opening the cloaca or terminal part of the intestine into the body cavity;
  - (b) incise the carcass in a manner which causes rupture or cutting of the intestines;
  - (c) use the bar cut.

**7. Procedures for evisceration of poultry**

The owner or occupier of a poultry processing establishment shall cause the following procedures to be used in the evisceration of poultry —

- (a) immediately prior to being eviscerated, the outer surface of each dressed poultry carcass shall be washed thoroughly by a spray constant flow of water;
- (b) the giblets shall be separated from the other viscera immediately after removal from the body cavity and shall be immediately cleaned, trimmed and washed under a continuous flow or spray of water;
- (c) eviscerated carcasses shall be checked for complete removal of feathers and inedible organs and bruised portions unsuitable for human consumption shall be trimmed from each carcass;
- (d) after final trimming the inner and outer surfaces of each eviscerated poultry carcass shall be washed by a spray or constant flow of water in such a manner as to clean the carcass thoroughly; and

- (e) eviscerated poultry carcasses, giblets and cut up, eviscerated poultry shall be drained to remove free ice and water prior to packaging in a retail container or package.

**8. Chilling of poultry in vats, etc.**

- (1) Where poultry carcasses are to be chilled in vats or similar containers they shall be placed in the vats immediately after the final trimming and washing processes and the water in which they are placed shall not contain more than 200 parts per million of chlorine.
- (2) The chilling medium in the vats or containers referred to in subregulation (1) of this regulation shall be maintained at 2° C or less and carcasses shall not be held in that medium for a longer period than 24 hours.
- (3) Poultry carcasses weighing less than 1.8 kg shall be chilled to 5° C or below in less than four hours.
- (4) Poultry carcasses weighing from 1.8 kg to 3.6 kg shall be chilled to 5° C or below in less than six hours.
- (5) Poultry carcasses weighing more than 3.6 kg shall be chilled to 5° C or below in less than eight hours.

**9. Air chilled poultry**

Where carcasses are to be air chilled they shall be placed in a refrigerated room with moderate air movement and a temperature of 2° C or below and the internal temperature of the carcasses shall be reduced to 5° C or less within 24 hours from the time of slaughter.

**10. Chilling of giblets**

Giblets shall be chilled to 5° C or below within one hour from the time they are removed from the inedible viscera.

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**11. Chilling of poultry by other methods**

Where poultry is chilled by a method other than the methods set out in regulations 8 or 9 of these regulations it shall be placed in the chilling facilities immediately after the final trimming and washing processes, and those chilling facilities shall maintain temperatures of 2° C or below.

**12. Temperature of coolers**

Coolers in which poultry is stored in a poultry processing establishment shall be maintained routinely at a temperature of 2° C or below.

**13. Temperature of freezers**

Freezers used for poultry in a poultry processing establishment shall be maintained at a temperature of minus 18° C or below and poultry shall be placed therein under such packaging, air circulation and stacking conditions as shall result in prompt and efficient freezing throughout.

**14. Poultry to be kept frozen or chilled**

- (1) Poultry which has been frozen or chilled at a poultry processing establishment shall be held in that frozen or chilled state —
  - (a) until it leaves the poultry processing establishment; or
  - (b) until it is further processed.
- (2) During any further processing, except where that process utilises heat, the internal temperature of such poultry shall not rise above 10° C and immediately after such processing the internal temperature of the product shall be reduced to 5° C or below unless it is in a hermetically sealed container.

**15. Edible materials to be refrigerated**

All perishable, edible materials for use in the processing of poultry products, shall be kept refrigerated at a temperature below 5° C until used.

**16. Poultry not to contain free chlorine**

Poultry shall not contain any free chlorine at the time of sale.

**17. Defrosted poultry**

Poultry and poultry products shall not be defrosted and refrozen unless the defrosting is essential to a further processing operation which substantially changes the nature of the product and which is carried out on the same day as the poultry is defrosted.

**18. Temperatures for defrosting**

- (1) When poultry is defrosted by thawing, the temperature of the air in the facility in which the defrosting takes place shall not exceed 15° C.
- (2) When poultry is submerged in water for defrosting the temperature of the water in the thawing tank shall not exceed 20° C.
- (3) When poultry is defrosted by sprays of water the temperature of the water shall not exceed 20° C.

**19. Thawing tank**

A thawing tank shall be provided with a continuous flow of water sufficient to keep the water in the tank clear.

**20. Sanitation**

The occupier of a poultry processing establishment shall cause that establishment to be maintained in a sanitary condition, free of objectionable odours and in particular —

- (a) a room or an area shall be provided where utensils and portable equipment can be cleaned;
- (b) used food containers and litter shall not be left in processing rooms;

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- (c) docks in receiving and loading bays which are used for handling live poultry shall be thoroughly cleaned at least once each working day;
- (d) floors in areas that contain or receive live poultry shall be cleaned at least once each working day;
- (e) coops or batteries used to transport live poultry shall be cleaned after each use and batteries shall be constructed to permit them to be cleaned throughout, without obstruction;
- (f) processing wastes shall be removed from floors and disposed of immediately following each individual period of processing and all floors shall be thoroughly cleaned at the end of each working day;
- (g) scalding tanks shall be completely emptied and cleaned at the end of each working day;
- (h) those sections of walls, partitions and ceilings which become soiled during poultry processing shall be thoroughly cleaned at the end of each working day; and
- (i) feather separation sieves, included in wax dipping machines shall be removed and cleaned at least once daily.

**21. Contamination**

Poultry processing operations shall be conducted in such a manner as to prevent the contamination of poultry in the establishment.

**22. Toxic materials**

- (1) Toxic materials for killing rodents and insects shall be stored, identified and used in such a manner as to preclude contamination of poultry and poultry products.
- (2) Residual insecticides shall not be used in rooms where poultry or poultry products are exposed.

**23. Enamel ware**

Enamel ware containers shall not be used for any purpose in poultry processing establishments.

**24. Poultry not to be placed on the floor**

Poultry and poultry products shall not be placed upon the floor.

**25. Poultry products to be covered near live poultry etc.**

Where poultry products are taken into rooms or areas that contain live poultry or refuse those products shall be completely covered.

**26. Waste materials**

After offal or other waste material is removed from processing, storage or sales rooms it shall not be returned to or transported through those rooms.

**27. Packaging materials**

All packaging materials used for poultry and poultry products shall be clean, free from contaminating substances and objectionable odours and of sufficient strength and durability to protect such poultry and poultry products from contamination during normal transportation and distribution.

**28. Protection of packaging materials**

All packaging materials, the surface of which will come into direct contact with poultry and poultry products, shall be purchased in clean cartons or wrappings, stored therein until used, protected from contamination during storage and use and shall not be used more than once.

**29. Packing in bulk**

Poultry and poultry products packaged in bulk or shipping containers shall be packed in one of the following methods —

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- (a) in clean containers made of impervious corrosion-resistant materials with the inner surfaces smooth and free from open seams, breaks, cracks and chips and so constructed as to provide complete closure and full protection of the contents;
- (b) in moisture-resistant containers having waxed interior surfaces or the equivalent thereof;
- (c) individually wrapped with clean moisture-resistant material then packed in clean containers; or
- (d) packed in clean containers lined with moisture-resistant material so that the material surrounds the poultry or poultry products completely, with adequate overlapping to permit unsealed closure or sealing.

**30. Ice packed poultry**

Notwithstanding regulation 29 of these regulations, the bottom and any paper lining of containers of ice packed poultry shall have perforations or other openings of sufficient size and number to permit water to drain from the containers as the ice melts.

**31. Equipment to be sanitised**

- (1) The surfaces of all equipment and utensils which come into contact with poultry shall be subjected to sanitising treatment at the end of each working day and on any other occasion required by a health surveyor.
- (2) In this regulation “**sanitising treatment**” means treatment that cleans by a bactericidal process which destroys microorganisms, including pathogens and is approved by a health surveyor.

**32. Cleaned utensils**

- (1) When utensils and portable equipment used in poultry processing have been cleaned, they shall be —
  - (a) put into immediate use;



- (b) stored in a protective solution;
  - (c) air dried; or
  - (d) stored in a self draining position on impervious, corrosionresistant racks.
- (2) Where utensils and portable equipment are stored in accordance with paragraph (d) of subregulation (1) of this regulation they shall be stored above the floor in a clean dry location that is protected from contamination and before any stored utensil is used it shall be rinsed in a spray or flow of clean water.
- (3) Utensils not in current use during processing operations shall not be stored in processing rooms.

**33. Sale of dressed poultry**

Dressed poultry as defined in these regulations may be sold to another poultry processing establishment but shall not be sold to the public.

**34. Edible materials to be wholesome**

All edible materials used in making poultry products shall be wholesome and safe for human consumption.

**35. Poultry to be covered during transport**

Poultry and poultry products shall be covered during transport and storage so as to minimise the possibility of contamination.

**36. Poultry to be labelled**

All poultry products shall, before leaving the poultry processing establishment, be labelled in a legible form showing correct identification.

**37. Ice**

- (1) Ice used in a poultry processing establishment shall be manufactured ice made from a potable water supply and shall be

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stored and handled in a manner that minimises the possibility of contamination.

- (2) Immediately before the ice is crushed, the block shall be placed on a clean pallet or platform and washed with a spray.
- (3) Ice crushing machines shall be thoroughly washed before and after each day's use.
- (4) A person shall not stand or walk on an ice pallet or platform.

**38. Yard of premises**

Any stored material in the yard of a poultry processing establishment shall be kept in an orderly manner not less than 305 mm above the ground, and the premises shall be well drained and free from pools of standing water.

**39. Dead birds**

Birds that die in coops and batteries shall be denatured immediately and disposed of in a sanitary manner.

**40. Hoses to be elevated**

Flexible water distribution lines shall be so elevated at all times as to prevent contact with the floor or the contents of tanks or other receptacles.

**41. Light bulbs**

Light bulbs and fluorescent tubes shall be protected against breakage in all processing areas.

**42. Repair and maintenance**

Poultry processing establishments shall be maintained in good repair.

**43. Construction of certain rooms**

- (1) To prevent contamination of poultry and poultry products, refuse rooms, toilets, utility rooms and rooms used for the preparation of products other than for human consumption shall be kept separate from each other and all other rooms or areas, by walls extending from the floor to the ceiling.
- (2) Poultry dressing rooms, eviscerating rooms, rooms in which eviscerated poultry is further processed and retail sales rooms shall be separated from each other either by —
  - (a) walls extending from the floor to the ceiling; or
  - (b) walls that terminate not more than 305 mm from the floor and have a mechanical method of air control that continues the separation.
- (3) Walls referred to in this regulation shall be without openings except —
  - (a) for necessary doorways that are equipped with doors; and
  - (b) for other openings necessary for the processing operations.

**44. Ceilings**

Ceilings in all rooms and areas where poultry or poultry products are processed or stored, where utensils are washed, in refuse rooms and in all other rooms or areas where floors are not kept dry, shall have washable light coloured surfaces with all joints sealed or tightly fitting.

**45. Excluding insects**

- (1) All external openings in poultry processing establishments shall be effectively screened to keep out insects with —
  - (a) wire of 16 mesh or finer; or
  - (b) a mechanical method of air control.

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- (2) Where a mechanical method of air control is used to exclude insects, tight fitting doors shall be installed and shall be kept closed when the air control device is not in operation.
- (3) The requirements of subregulations (1) and (2) of this regulation do not apply to feeding stations or other live poultry rooms when they are completely open on one or more sides.

**46. Doors and screens**

- (1) All outside doors shall be either constructed of metal or the bottom edge shall be flashed and edged with sheetmetal to a height of 152 mm.
- (2) All screens shall be tight fitting.

**47. Light intensity**

At least 538 lm-m<sup>2</sup> of light intensity shall be provided in areas where poultry or poultry products are examined for cleanliness or wholesomeness, at least 322 lm-m<sup>2</sup> of light intensity on all other working surfaces and at least 54 lm-m<sup>2</sup> on a horizontal plane 762 mm above the floor in all other areas of the establishment.

**48. Vents**

- (1) Space heaters, stoves, water heaters and any other equipment giving off noxious odours, fumes or vapours in a poultry processing establishment, shall be vented to the outside air.
- (2) All exhaust outlets from mechanical ventilating devices shall be conducted to the outside air and so placed that, in the opinion of a health surveyor they avoid creating a nuisance in adjacent areas.

**49. Water**

- (1) The water supply used in poultry processing operations shall conform to the standards for potable water set out in the *Food and Drug Regulations 1961*, made pursuant to the

*Health Act 1911* and the use of water that does not comply with this standard shall be limited to purposes approved by a health surveyor, such as fire control.

- (2) Supply lines for other than potable water in a poultry processing establishment shall be clearly identified.

**50. Hot water**

The hot water system in a poultry processing establishment shall have sufficient capacity to furnish ample water at a temperature of not less than 75 ° C during all periods of processing and cleaning up operation.

**51. Plumbing**

- (1) The plumbing system in each poultry processing establishment shall be installed in compliance with the By-laws made under the *Metropolitan Water Supply, Sewerage, and Drainage Act 1909* and the *Country Towns Sewerage Act 1948*.
- (2) Outlets and connections to fixtures and equipment shall be installed in such a manner as to prevent back flow into the water distribution system, or shall be equipped with back flow preventers.
- (3) Each fixture directly connected with a drainage system shall be equipped with a water seal trap.

**52. Equipment holding poultry not to be connected to drainage system**

- (1) Refrigerators or other items of equipment in which poultry or poultry products, utensils or portable equipment are placed, shall not be directly connected to the drainage system, each waste pipe of such items of equipment shall discharge either into an open sink with a trap or into a floor drain.
- (2) In a refrigerator room which is not equipped with a floor drain the floor shall be at least three inches above the highest level of

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each adjoining room or area and the floor shall be graded to drain to the outside.

**53. Drainage lines**

Drainage lines for poultry processing operations shall be separate from toilet sewer lines to a point beyond the poultry processing building and access to the drains for cleaning shall not be located within the poultry processing building.

**54. Solid matter in wastes**

All liquid wastes containing solid materials shall be passed through a separator or indirect waste receptor which shall effectively retain such solids prior to the discharge of the liquid waste into the drainage system.

**55. Piping to be protected**

All overhead drain lines and piping shall be so protected that leakage and condensation therefrom will not drip upon poultry, processing equipment, utensils, or floors.

**56. Wash basins**

- (1) Wash basins shall be located in such places and shall be in such number, as will, in the opinion of a health surveyor be adequate for hand washing by employees engaged in poultry processing operations.
- (2) Each wash basin shall be provided with warm water, of at least 40 ° C, but steam mixing valves shall not be used at the basin.
- (3) The control valves on wash basins used by employees during poultry processing operations shall be operated by means of foot pedals, knee pressure or any means other than by hand.
- (4) Soap or detergent shall be made available at wash basins together with a sanitary means of drying hands but a communal towel shall not be used.

- (5) A container constructed of impervious material shall be provided near wash basins for the disposal of used towels.

**57. Blood not to drain into septic tank**

Blood from poultry slaughtering shall not be drained into any septic tank used for the disposal of liquid waste in a poultry processing establishment.

**58. Waste water**

Waste water shall not be discharged or drained from the equipment in such a manner as to cause it to flow across a floor in a processing or trucking area.

**59. Grease traps etc.**

Grease catch basins, grease traps and waste disposal units shall not, without the approval of a health surveyor, be located in the processing, storage or sales areas of poultry processing establishments.

**60. Storage of solid wastes**

- (1) Solid wastes shall be transferred from catch basins to be held in impervious, easily cleanable containers, covered with tight fitting lids.
- (2) Feathers may be held in containers which have holes or perforations where suitable drainage is provided.
- (3) Where the containers are stored in single racks they shall be kept at least 305 mm above the floor and where they are stored in multiple racks they shall be at least 450 mm above the floor.
- (4) Wastes shall be removed from the poultry processing establishment at least once a day.

**61. Equipment and utensils**

- (1) Equipment and utensils in poultry processing rooms shall be constructed of impervious materials, designed and fabricated to facilitate cleaning and located so as to be readily accessible for cleaning.
- (2) Equipment and utensils in poultry processing rooms shall be kept in good repair and surfaces which contact poultry shall be non toxic, corrosion resistant, smooth, free from breaks, open seams, cracks and chips and shall not be constructed of concrete or wood.

**62. Conveyors**

Conveyors and other equipment shall be so constructed and maintained that grease, oil, or dirt from such equipment shall not contaminate poultry and poultry products.

**63. Construction of scalding tanks**

Any tank used for scalding poultry shall be so constructed as to allow water to enter continuously and to flow out through an overflow of sufficient size to prevent clogging.

**64. Cleaning of tanks**

Any tank or vat used for the chilling or thawing of poultry shall be provided with a drain flush with the lowest interior surface to facilitate cleaning and shall be so constructed that it can be used and cleaned without the necessity for employees to have to enter it.

**65. Quantity of utensils**

A sufficient number of utensils shall be provided in every poultry processing establishment to permit replacement while an article is being cleaned.



**66. Construction of bleeding cones**

Bleeding cones shall be constructed of impervious corrosion resistant material and shall be easily accessible or removable for cleaning.

**67. Construction of blood tunnels**

- (1) Blood tunnels through which birds travel on a conveyor shall be of metal or solid wall construction.
- (2) Metal tunnels shall be fitted with side and head shields easy to remove and clean and a base trough with a fall of one in twenty-four to a blood container which is easy to empty and clean.
- (3) Tunnels of solid wall construction shall have smooth impervious surfaces and shall be not less than 0.914 m wide to facilitate washing and cleaning.

**68. Construction of bleeding troughs**

Bleeding troughs shall be constructed of impervious corrosion resistant material and shall —

- (a) be sloped at least one in twenty-four;
- (b) be flushed continuously with water or drain into catch basins; and
- (c) be cleaned at least once daily.

**69. Cleaning hand instruments**

Any person using a hand operated instrument in a poultry processing establishment shall maintain it in a clean condition by frequent rinsing in a flow or spray of clean water and when the instrument becomes visibly soiled the person using it shall set it aside for cleaning and replace it with a clean instrument.

**70. Cleaning certain utensils**

- (1) Giblet trays, chilling and thawing tanks and eviscerating trays, troughs, belts and tables shall be rinsed with a flow or spray of

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water under pressure after each individual usage and then thoroughly cleaned.

- (2) Grading, sorting and packing tables and bins shall be effectively rinsed at frequent intervals during periods of usage.

**71. Sale of poultry**

A person shall not sell any processed poultry or poultry product unless it has been processed in premises registered in accordance with Section 191 of the *Health Act 1911*.

**72. Offences**

- (1) Where by these regulations an act is required to be done or forbidden to be done in relation to any poultry processing establishment, the occupier of the premises has, unless the contrary intention appears, the duty of causing to be done the act so required to be done, or of preventing from being done the act so forbidden to be done, as the case may be.
- (2) A person who contravenes a provision of these regulations commits an offence and is liable to —
- (a) a penalty which is not more than \$1 000 and not less than —
    - (i) in the case of a first offence, \$100;
    - (ii) in the case of a second offence, \$200; and
    - (iii) in the case of a third or subsequent offence, \$500; and
  - (b) if that offence is a continuing offence, a daily penalty which is not more than \$100 and not less than \$50.

*[Regulation 72 amended in Gazette 23 December 1988 p.4975.]*

**Notes**

- <sup>1.</sup> This is a compilation of the *Poultry Processing Establishments Regulations* and includes the amendments referred to in the following Table.

**Compilation table**

<b>Citation</b>	<b>Gazettal</b>	<b>Commencement</b>
<i>Poultry Processing Establishments Regulations</i>	25 May 1973 pp.1633-9 23 Dec 1988 p.4975	25 May 1973