

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN221603 5306N-1	03/06/2014	03J02	Slaughter HACCP	O	(B)(4) Monitoring Records- NY Wash, Pickers, IOBW: On February 27, 2014, the EIAO reviewed "Process Control Sheet" records from January 13, 2014 through February 13, 2014. The (B)(4) Evaluation Program states that supervision or maintenance will be informed if (B)(4) concentration is outside the target and range; and rechecks will be conducted if the (B)(4) concentration is outside the range. The range is (B)(4) ppm (B)(4) and the target is (B)(4) ppm (B)(4). The following dates had values outside of the range with no rechecks and no notification of supervision or maintenance: 2/13/14 in New York Wash; and 2/11/14 in New York Wash. The dates had (B)(4) values outside the target with no notification of supervision or maintenance: 1/14-15/14 in New York Wash and IOBW Reprocessing, 1/16-17/14 in New York Wash and IOBW; 1/18-19/14 in New York Wash, and IOBW Line 2; 1/19-20/14 in IOBW Reprocessing and IOBW 1 and 2 Line A and B; 2/4-5/14 in New York Wash and IOBW 1 and 2 Lines A and B; and 2/13/14 in New York Wash and IOBW 1 and 2 Lines A and B. The establishment failed to implement their (B)(4) Evaluation Program, which is used to support that "Pathogens (example Salmonella)" are not reasonably likely to occur in the Slaughter hazard analysis at the "NY Wash", "Inside Outside Bird Washer #1" and "Inside Outside Bird Washer #2" steps. This is a regulatory noncompliance under 9 CFR 417.5(a)(1) and Notice of Deferral Verification Plan point 7(a).
5309	P6137A	NJN291603 2406N-1	03/06/2014	01C01	Operational SSOP Record Review	O	Enterobacteriaceae: The establishment implemented the "Sanitary Operation Verification Program" to evaluate the effectiveness of operational sanitation practices by monitoring the log values of product contact surfaces with acceptable limits of $\leq (B)(4)$ logs. The program indicates, (B)(4) . The EIAO reviewed "Sanitary Operation Verification Program" records from 1/15/14-2/15/14 and determined that on the date of 2/3/14, a food contact surface in Zone 14, Site 33, had a value of (B)(4) logs, however, no corrective actions and no re-sampling for 2 consecutive days were documented. This is a regulatory noncompliance under 9 CFR 416.14 and Notice of Deferral Verification Plan point 19.

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5309	P6137A	NJN441403 4306N-1	03/06/2014	03C02	Raw Intact HACCP	O	<p>(B)(4) Parts SOP: The establishment's "Parts (B)(4) Monitoring SOP" indicates, "QC will evaluate concentration and dwell times at start of the process, hourly and/or at the end of the process. Results will be recorded on (B)(4) Salvaged Parts Monitoring Log". However, on February 24, 2014 at approximately 1430, the EIAO observed a QC employee monitoring (B)(4) concentrations for Fillet dips. The EIAO reviewed the current (B)(4) monitoring record for the Fillet dip, which had initials and time documented for dwell time, however the value for dwell time was not documented. In discussion with the QC employee, she stated that the dwell time was monitored, however it was not documented. The establishment failed to implement their "Parts (B)(4) Monitoring SOP", which is used to support that "Pathogens (example Salmonella)" are not reasonably likely to occur in the Raw Not Ground hazard analyses at the "(B)(4) Dip" steps. This is a regulatory noncompliance under 9 CFR 417.5(a)(1) and Notice of Deferral Verification Plan point # 11. CCP 3B (B)(4)</p> <p>(B)(4): On February 25, 2014 during night shift, the EIAO observed the monitoring of CCP 3B, (B)(4). The critical limit for CCP 3B is (B)(4). The EIAO observed a QC employee monitor the concentration of (B)(4) using a test strip on a cone located on the cone line. The test strip indicated that the concentration was approximately (B)(4), however, this value was not documented and no corrective actions were taken for this deviation. The QC employee then monitored a conveyor belt on the cone line and documented this value in lieu of the previous value for the cone. The establishment failed to document the actual value and failed to take corrective actions in response to a deviation. This is a regulatory noncompliance under 9 CFR 417.5(a)(3) and Notice of Deferral Verification Plan point 10(b).</p>

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5568	M20923	XUM591403 3806N-1	03/06/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	<p>At approximately 1115 hours while performing HACCP task (the record review component of procedure for fully cooked-not shelf stable process), I observed the following noncompliance: While review the records in the QC office dated 3/3/14 CCP (B)(4) (CCP-2B), QC Verification Record review check made at 2035 QC auditor documented time, initial but the acc/unacc check was missing. Establishment HACCP Plan states- Record review indicates the specific verification check was made according to the HACCP plan and that the verification check was acceptable/ unacceptable. Records were reviewed on 3/4/14 by (B)(6). There was no corrective action documented for deficiency. Also reviewing the HACCP & General Temperature Monitoring Log dated 3/5/14 the records were reviewed by (B)(6) on 3/5/14 at 1746 with initial but the acc/unacc check was missing. I notified the (B)(6) about the non-compliance. This does not meet the requirement of 9 CFR 417.5(a)(3) which states: "The establishment shall maintain: Records documenting the monitoring of CCPs and their critical limits, including the recording of the actual times, temperature, or other quantifiable values, as prescribed in the establishment's HACCP plan; the calibration of process-monitoring instruments; corrective actions, including all actions taken in response to a deviation; verification procedure and results; product code(s), product name or identity. Each of these records shall include the date the record was made". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1102035 005N-1	03/05/2014	04A06	Poultry Finished Product Standards	O	On 03/04/2014 at approximately 2336 hours while monitoring the Establishment's Reprocessing Procedures on Line ^(B) in Evisceration Area 1, I observed the following. After taking a random 10 bird sample I found 1 split tail bird with airsacculitis exudates remaining inside the cavity. I informed the leadperson and at approximately 2345 hours I took a 10 bird sample for the recheck. I found 1 bird with kidneys and 1 bird with airsacculitis exudates remaining inside the bird. I immediately took regulatory control action by stopping the line, and I informed ^{(B)(6)} of the noncompliance and showed him my findings. The line was started and all birds with split tails or missing tails were retained while corrective actions were implemented. Quality Control tagged the tank of retained birds pending rework of the product. At approximately 0001 hours I took a 10 bird sample for recheck and passed, bringing the process back into control. At approximately 0049 hours, Quality Control performed a recheck on the retained tank of birds and passed, the birds were released back to production. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 381.76(b) and 9CFR 381.84.
1325 7	P33900	NHH460203 4805N-1	03/05/2014	06D02	Other Inspection Requirements	C	On the night of production that began on February 26, 2014 at approximately 2135 hours a presentation check was performed on line 2. When the no viscera portion of the presentation check was performed 16 carcasses with no viscera were observed over a 3 minute period at a line speed of ^{(B)(4)} carcasses per minute. Mr. ^{(B)(6)} , was notified and stated the plant had not performed no viscera checks at that point in the shift. When a second no viscera check was performed, 18 carcasses with no viscera were identified. Both checks resulted in error rates greater than the ^{(B)(4)} allowed a ^{(B)(4)} carcasses per minute for the ^{(B)(4)} evisceration system. The line speed was reduced by 10% to ^{(B)(4)} carcasses per minute and at that line speed 11 carcasses with no viscera were identified. This result was within the ^{(B)(4)} error rate allowed for the ^{(B)(4)} evisceration system. After the establishment had completed corrective actions, a missing viscera check was performed at 0520 hours. The number of missing viscera at line speeds of ^{(B)(4)} and ^{(B)(4)} carcasses per minute was 7 and 12, respectively. These values were within the allowed ^{(B)(4)} error rate.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM191203 3704N-1	03/04/2014	01B02	Pre-Op SSOP Review and Observation	C	<p>At approximately 0715 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 1, Cook side of the establishment: I found few small pieces of food particles on (B)(4) conveyor belt from the previous day of production. Upon continuing my inspection Line 2, I found whole piece of chicken wing stuck on (B)(4) exit belt from the last run date 2-28-14 Friday, because yesterday on 3-3-14 they run the meatballs on line 2. I took a regulatory control action and applied USDA retain/rejected tag# B24829892. I informed and showed to (B)(6) (B)(6) and (B)(6) and (B)(6) of the non-compliance. The finding described in the non-compliance was on the food contact surface and very close to the food contact areas, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0750 hours. Plant SSOP Section1, page1, states: (B)(4) (B)(4)". 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>

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1325 7	P33900	NHH170403 5104N-1	03/04/2014	01C02	Operational SSOP Review and Observation	C	On the night shift that began on 03/03/2014 at approximately 0338 I was in the Evisceration Room at Establishment 33900 P to perform a Zero tolerance procedure on Evisceration line #2. As I started to collect the 10 carcasses needed to perform the procedure a carcass hit a water nozzle on the inside of the rinse cabinet. Water from this nozzle sprayed upward and outward, spraying the rail and the turn wheels on the shackle line. This water then fell onto the carcasses below. I had Inspector (B)(7)(C) stop the line immediately. Approximately 15 carcasses were affected, which the (B)(6) chose to condemn. I then had (B)(7)(C) re-start the line. The Preventive Measure given by Mr (B)(6) was that Maintenance personnel would tighten the nozzle to prevent it from spraying water outside the cabinet. Mr. (B)(6) was informed that a Noncompliance Record would be issued documenting the noncompliance. The requirements of Regulations 416.1 and 416.13(c) were not being met. The Establishments SSOP plan objective is, (B)(4)
5112	M18909	JDD1810032 003N-1	03/03/2014	01C02	Operational SSOP Review and Observation	O	In Evisceration this date 03/03/2014 at 0210 H PST, I observed plant employee ready to place a reprocessed bird into a (Supposed To Be Clean Stainless Steel Vat), only the vat wasn't clean, it had a dime size piece of UFM, black in color, in it. This is a violation of the Establishment's written SSOP Program and the above 9 CFR's. Mr. (B)(6) and Ms (B)(6) were shown the noncompliance and were in concurrence with it. Ms. (B)(6) paperwork did not reflect this prior to my notification.

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5308	M6137	BXL1808030 703N-1	03/03/2014	01B02	Pre-Op SSOP Review and Observation	O	On 03/03/2014 at approximately 0006 hours while performing Pre-Operational Sanitation procedures on the Tub Wash Machine, I observed the following. There was a dried residue film around the bolts located on the metal sides where the tubs enter the machine, that came off easily when I scratched it with my fingernail. I also observed fat and meat particles approximately towards the middle section of the machine that were located close to the top inside of the machine that ran from one side to the other. I applied U.S. Rejected/U.S. Retained tag #B31406475 to the machine and I informed (B)(6) of the noncompliance and showed him my findings. At approximately 0156 hours while performing a recheck on the tub wash machine, I observed the following. There was still some dried residue film around the bolts, and inside the machine were several pieces of fat between the metal links of the belt that are on the edges of the white plastic that runs along the sides of the inside of the machine. I informed (B)(6) and showed him my findings. At approximately 0324 hours after the tub wash machine had been washed and sanitized restoring sanitary conditions, I removed my tag and released the machine. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.13(c), and 416.4(b).
5308	M6137	BXL5204035 303N-1	03/03/2014	01B02	Pre-Op SSOP Review and Observation	O	On 03/02/2014 at approximately 2129 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in Plant 2, I observed the following. There is an exhaust fan directly over Scalding #3. There was a clear fluid dripping profusely from the opening directly into the scalding causing an insanitary condition. The fluid appeared to be rain water flowing from the roof. (B)(6) was shown the noncompliance. A mechanic was called and placed a sheet of plastic to direct the fluid away from the scalding. The affected section of the scalding is located adjacent to the access door to the Stunning Area. The scalding was emptied and recleaned restoring sanitary conditions by approximately 2230 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 13(c), and 9 CFR 416.14.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH280302 0528N-1	02/28/2014	06D02	Other Inspection Requirements	C	<p>On the night of production that began on February 26, 2014 at approximately 2145 hours a presentation check was performed on line 2. When the no viscera portion of the presentation check was performed 16 carcasses with no viscera were observed over a 3 minute period at a line speed of (B)(4) carcasses per minute. Mr. (B)(6), was notified and stated the plant had not performed no viscera checks at that point in the shift. When a second no viscera check was performed, 16 carcasses with no viscera were identified. Both checks resulted in error rates greater than the (B)(4) allowed at (B)(4) carcasses per minute for the (B)(4) evisceration system. The line speed was reduced by 10% to (B)(4) carcasses per minute and at that line speed 11 carcasses with no viscera were identified. This result was within the (B)(4) error rate allowed for the (B)(4) evisceration system. A presentation heck was then performed on line 1 at 2220 hours. When the no viscera check was performed 27 carcasses with no viscera were observed over a 3 minute period at a line speed of (B)(4) carcasses per minute. Mr. (B)(6), was again notified and stated the plant had not performed no viscera checks at that point in the shift. A second no viscera check resulted in 24 carcasses no viscera. The line speed was reduced by 10% to (B)(4) carcasses per minute and at that line speed 11 carcasses with no viscera were identified. This result was within the (B)(4) error rate allowed for the (B)(4) evisceration system. The establishment was unable to correct the issue on either line before the end of the night's production; therefore, both lines were checked at the beginning of the shift on February 27, 2014. The no viscera check on line 2 at (B)(4) carcasses per minute resulted in 7 carcasses with no viscera. This value is within the allowed error rate of (B)(4) so the line speed was increased to (B)(4) carcasses per minute. Four carcasses with no viscera were obtained at this line speed. No viscera checks on line 1 resulted in 8 and 10 carcasses with no viscera at line speeds of (B)(4) and (B)(4) carcasses per minute, respectively. These results were within the (B)(4) error rate allowed for the (B)(4) evisceration system at the line speeds stated. The requirements of 9 CFR 381.76(a) and 381.76(b) were not met.</p>

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5112	M18909	JDD3622025 727N-1	02/27/2014	01D01	SPS Verification	C	On 02/27/2014 at approximately 1957 hours I observed the following noncompliance to 9 CFR 416.1, 9CFR 416.2(d) and 9 CFR 416.4(d) in the Weigh and Price Room. While doing my verification checks in the Weigh and Price room I observed water dripping from the ceiling next to refrigeration unit in the Weigh and Price Room onto a pallet of sealed cases of Turkey Breast Roast. I immediately took regulatory control action by applying U.S. Retain Tag # B43241090 to the pallet and informing (B)(6) of my observation and noncompliance. Mr. (B)(6) took immediate corrective action in my presence by removing the pallet from underneath the dripping water and informing maintenance. Mr. (B)(6) removed the cases of effected product and reworked the product inside. The dripping was on the outside of the sealed case's so no product was effected by the dripping. Regulatory control was relinquished at approximately 2020 hours after sanitary conditions were restored.
5308	M6137	BXL4707024 127N-1	02/27/2014	01B02	Pre-Op SSOP Review and Observation	O	On 02/27/2014 at approximately 0010 hours while monitoring the Establishments' Pre-Operational Sanitation procedures in Packaging, I observed the following. There were patches of semi-dried fat and tissue measuring to approximately 3/4" by 3" by 1/16" on the small cutting wheels on all three breast processors checked. The cutting wheels are used to make the final cut on the front halves before the breast halves and back bone are dropped onto the product belts. There were also two large pieces of tissue to approximately 3" between the chain and the upper nylon support bracket on processor #9. I contacted (B)(6) and showed him my findings. Breast processors 8-10 were recleaned and returned to service by approximately 0020 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) and 9 CFR 416.13(c).
5308	M6137	BXL5203024 027N-1	02/27/2014	01C02	Operational SSOP Review and Observation	O	On 02/26/2014 at approximately 2307 hours while monitoring Operational Sanitation in the Plant 2 Paw Room, I observed the following. Water was dripping from an air vent above the grey plastic bin that is used to collect the paws. A piece of plastic had been put up under the air vent and the water that was dripping from the air vent was collecting in the plastic and then dripping directly into the bin of paws that was approximately 3/4 full. I immediately tagged the bin of paws with U.S. Rejected/U.S. Retained tag #B31406626, and I informed (B)(6) of the noncompliance. The bin of paws were taken to the PC Plant where I removed the tag at approximately 2320 hours, and the paws were condemned. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.13(c), 9CFR 416.2(b)(1), 9CFR 416.2(b)(2), 9CFR 416.4(a), and 9CFR 416.4(d).

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5310	M6137B	FFA0600021 027N-1	02/27/2014	01B02	Pre-Op SSOP Review and Observation	O	<p>On 2-26-14 at approximately 01:30 hrs while performing a preoperational inspection, after the establishment's Quality Control personnel finished with their inspection I observed the following deficiencies in the Raw side production area (Zone A); the rework table with product left from the day before on the side rims around the table and underneath, including the framework. Product was also found on the small blender's dumper/crossbar (product contact), and roller guides for raising and lowering dumper. Excessive product left on the lid of the large blender, hoses, and framework; the catwalks of this machine. These are in noncompliance to the Establishments SSOP's Regulatory requirements of 9 CFR 416.13(2) and 416.14(2). As stated in your SSOP, section 1/Pre-operational Sanitation, (B)(4)</p> <p>(B)(4)</p> <p>ith (B)(6) accompanying me during my inspection, he was taking immediate corrective actions on all of these items mentioned and also notified of this N.R. This noncompliance serves as written notification that failure to comply with regulatory requirements listed could result in additional regulatory or administrative actions.</p>
1325 7	P33900	NHH040402 0727N-1	02/27/2014	04A06	Poultry Finished Product Standards	C	<p>On the night shift that began on 02/26/2014 at approximately 235 Hours, I was in the Evisceration room at Establishment 33900 P; I was in the area to give relief breaks to the line inspectors. At the reprocessing cut-up station I observed an employee pick up six carcasses that was marked with a long straight cut on the back of the carcass. This cut then had a small cut across the long cut close to the tail of the carcass. The plant employees had reprocessed these carcasses by removing part of the breast that had been mutilated by the picker fingers in the picking room of the establishment. This employee then took the carcasses to the Inflammatory Process area and put them into the (B)(4). The Establishment has a cut-up reprocessing procedure and an Inflammatory process procedure. Neither of these procedures were fully followed. Regulatory Control Action was taken by applying USDA Reject tag number B38075852 to the (B)(4). The requirements of Regulation 381.91(c)(2) were not being met.</p>

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1325 7	P33900	NHH550302 4527N-1	02/27/2014	01C02	Operational SSOP Review and Observation	C	<p>On the morning of February 26, 2014 at approximately 0540 hours while touring room 1 Further Processing the following noncompliance was observed.&nbsp; Approximately one-third tote of down-grade wings was observed under the catwalk for the breast processors.&nbsp; At the time, plant employees were standing on the catwalk and water was dripping from the catwalk into the tote contaminating the product.&nbsp; Mr. (B)(6) immediately removed the product and condemned it and sent the tote to be washed.&nbsp; To prevent recurrence, Mr. (B)(6) stated the responsible employee would be retrained.&nbsp; Mr. (B)(6) was informed the noncompliance would be documented on a noncompliance record.&nbsp; The establishment's SSOP plan states (B)(4)</p> <p>(B)(4) The requirements of 9 CFR 416.1 and 416.13(c) were not met.&nbsp; For a similar noncompliance refer to NR NHH0101014504N/1 dated January 4, 2014.&nbsp; The preventive measure for this noncompliance was (B)(4)</p> <p>(B)(4) These measures may have been implemented incorrectly or may have been ineffective at preventing recurrence.&nbsp; </p>
1326 1	M33901	HAY400202 1827N-1	02/27/2014	01D01	SPS Verification	C	<p>On the calendar date of February 27, 2014 at approximately 0042 hours while performing the Operational SSOP Review and Observation task, the following facility noncompliance was observed in the RTE Clean Room: Part 2 of the establishment's SSOP's under "Facilities" states that (B)(4)</p> <p>(B)(4), CS(B)(7)(C), observed multiple beads of condensation on the underside of the white pipe adjacent to the oven conveyor. Beaded condensation was also located on the underside of the stainless conduits above the oven conveyor.&nbsp; At the time of the findings, exposed grilled chicken breast were being processed and conveyed from the oven&nbsp; into the freezer. Please be advised that no product contamination was observed, as the condensation was non-dripping. (B)(6) was shown the noncompliance and she confirmed the findings. Production was stopped and corrective actions were immediately initiated. Ms.(B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on February 26, 2014; please reference NR # HAY2413025426N-1. The establishment's response to NR # HAY2413025426N-1 is pending.</p>

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5112	M18909	JDD5606024 726N-1	02/26/2014	01B02	Pre-Op SSOP Review and Observation	O	EVISCERATION: 1) UFM in the Gizzard Defatter, 2) UFM in I/O Wash Line Two, 3) Inedible Hooks with UFM on them and RED ID TAPE loose and insanitary condition, 4) UFM on Framework of the Quill Puller. Boning: 1) Multiple residues on the Tendon/Strap Puller, 2) Product Residue in Right Drive Cog on Overhead Belt feeding hanging, 3) Production residue on Wall/Ceiling left side of Contherms. 4) Sprinkler Shrouds are rust, loose paint ceiling by the MAIN BONING WASH STATIONS, 5) Product residue on Belts Feeding MDP and Drum machines, 6) Brown strips on bottom of Breast Sorter, one is badly stained and pieces have chipped out of it, the other has residue on it, RAW FAB: Discussed with Mr. (B)(6), the conditions of the CASING BOXES. This is violation of the above 9 CFR's and the Establishment's written SSOP Program. This is Linked to NR 020-2014, Dated 02-24-2014, JDD1608021224N/1 and its associated JDD number.

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6036	P6164A	OIJ4520025 726N-1	02/26/2014	03J04	Poultry Zero Tolerance Verification	O	<p>On February 26, 2014 at 1555 I, CS (B)(7)(C) observed visible fecal material on one bird at the chiller exit area while performing a Post chill FPS test. PHV (B)(7)(C) verified my finding. The fecal material was found on the partial tail and on the cut surface area of the pelvic bone next to the partial tail. The dark brown creamy fecal material with ureate covered half of the partial tail and the entire cut surface of pelvic area. A cloaca with intestine approximately 1 1/2" long was attached to the partial tail. All birds exiting the chill system were toted off and retained for rework. QC performed Postchill fecal checks resulting in no fecal found. Birds exiting the chill system were allowed to return to the normal process flow. A total of five totes were retained, reworked and reinspected by QC. Additional checks were performed in the Packaging Dept on all lines receiving product from the chiller. No fecal was found. I verbally notified (B)(6) and (B)(6) that a NR would be issued. The verbal response given was that the failure was due to employees failed to remove attached cloaca and intestine from the bird prior to entering the chiller. All Evisceration Department employees on duty at the time of the failure were counseled individually by the Evis Supervisor of the importance to remove all cloacae and intestines from the birds or hang them on the reprocess line for rework. The verbal preventative measure given was that all Inspector helpers will be retrained on the importance of removing the cloacae and intestines from the bird or remove the bird to the reprocess line. On December 26, 2013 NR # OIJ4509121326N (#86) was written for fecal found while performing a prechill Poultry Zero Tolerance Verification test. The cause was determined to be a malfunctioning spray nozzle in the New York bird wash. The written preventative measure given was that Maintenance will check the NY Wash at breaks and lunch. On December 4, 2013 NR # OIJ0908123505N (#84) was written for fecal found while performing a prechill Poultry Zero Tolerance Verification test. The cause was determined to be a malfunctioning spray nozzle in the New York bird wash. The written preventative measure given was that Production will check the water nozzles every half hour until 12/13/13. The preventative measures given have been ineffective in preventing further occurrence of visible fecal being found in the chiller system. The establishment Awareness meeting notes show the last time fecal noncompliances were discussed was on December 26, 2013. This NR is linked to NR # OIJ4509121326N (#86) and NR # OIJ0908123505N (#84) for the same root cause of not preventing visible fecal material from entering the chiller system.</p>

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1326 1	M33901	HAY241302 5426N-1	02/26/2014	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of February 26, 2014 (Wednesday) at approximately 0720 hours, I received a visit from Dr. (B)(7)(C), Dr. (B)(7)(C) and Dr. (B)(7)(C) to conduct a tour through the establishment. This tour was conducted during scheduled operations although product was not being processed at the time. As we walked through the processing areas the following noncompliances were observed: (1) Raw processing side of lines #1 and #2, a white shovel that is used for edible product was hanging on the side of the large marinating tumbler for line #1 and was observed to have two tissue/fat particles on the inside surface. The particles had a brown color and ranged between 1/16" and 2/16" in size. U.S Rejected tag B38464356 was applied to the white shovel. Also observed was a long trail of a white product ingredient that had been spilled onto the floor where the ingredients are set up at the mixing tanks. The spilled ingredient covered an area approximately 6' long. (2) Raw processing side #3 and #4, three stacks of white barrels (four barrels in each stack) labeled for edible product were observed with the presence of fat particles on the outside and inside surfaces. The barrels were staged on a stainless steel table and were turned down on the table. The fat particles had a black color and ranged between 1/16" to 2/16" in size. Also observed on the white barrels were rough edges all around the top surfaces. U.S. Rejected tags B38464357, B38464358 and B38464359 were applied to white barrels. A stainless steel (B)(4) was observed to have the presence of fat particles/tissue on the inside surface. The particles/tissue ranged approximately 2/16" in size. U.S. Rejected B38464360 was applied to the (B)(4) Mr. (B)(6) was shown the conditions and informed that there were SSOP noncompliances. Mr. (B)(6) also informed Mr. (B)(6) of the SSOP noncompliances. (3) In the middle cooler, a drip pan underneath a cooling unit near the entrance to the MSC department had beaded condensation present. Beaded condensation was also present on the ceiling of the hallway near the MSC department. No product was on the production lines during this time. All insanitary equipment was immediately removed from the raw processing areas and taken to the equipment wash room. As a preventative measure, the S3 Sanitation Cleaning assistant site manager, Mr. (B)(6), was informed of conditions and followed up on the cleaning of equipment. (No product was contaminated). The establishment's Standard Operating Procedures for Sanitation (Part 2; section 1 states: (B)(4)". Equipment was not maintained in a sanitary manner and ineffective SOP monitoring failed to prevent equipment contamination. The Regulatory requirements for 9CFR 416.13(c), 416.1 and 416.4(d) were not met.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN501802 1525N-1	02/25/2014	01D01	SPS Verification	O	On February 25, 2014 while performing my schedule SPS Procedure in Raw Side and Cook Side Coolers I observed noncompliance with SPS regulatory requirement(s) 416.4(b)(1), 416.4(b), 416.2(b)(2). Raw Side Cooler Number Two: Inside Cooler #2, I observed a section of the floor that was damaged. Two tanks of product was stored on top of the damaged floor. Several loose large and small piece of the floor was scatter in different directions. U.S. Reject Tag NO. B38937062 was applied to this section of the cooler (product traffic area). Mr. (B)(6), was informed and showed the noncompliance. Raw Side Cooler Number One: Inside Cooler #1, I observed that behind the Ice Machine the ceiling has a couple of areas that has gaps and has black UFM along the gaps. I observed that the Product Thawing Area has several rusty beams and rails (product staging area). Mr. (B)(6), was informed and showed the noncompliance. Cook Side Cooler #2: I observed that the doorway as you enter into Cooler #2, has rust and chip paint also at the bottom of the doorway I observed a hole with broken pieces of concrete. I observed rust along the rail where the product is staged prior to entering Cooler #2. I observed rust on the small pole before enter the hallway. I observed prior to enter the handwash area for the slice pack department the overhead trim on the door is loose and hanging down exposing rust (product traffic areas). Mr. (B)(6) was informed and showed the noncompliance. This NR is linked to NR#LQN4218025504N/1 dated 2/4/14, for a similar noncompliance. This NR serves as written notification that failure to comply with regulatory requirement(s) may result in additional or administrative actions as described in 9 CFR 500.4.
5308	M6137	BXL1813024 725N-1	02/25/2014	04C05	Poultry Good Commercial Practices	O	At approximately 0845 hours while monitoring the Establishments' Good Commercial Practices procedures, I observed the following noncompliance. When I walked into the Line #2 Live Hang area I observed a grey barrel marked Inedible on a dolly that it is used to transport DOA's from the Live Hang area to the USDA Condemn tank that is now kept outside. When I looked inside the barrel it was approximately 3/4 full of DOA's and I observed one bird still breathing on the top layer of DOA's in the barrel. I turned on my flashlight to get a closer look at the bird and it lifted up it's head, was blinking it's eyes and was moving it's wings. I was concerned about additional DOA's being placed on top of the live bird, as the bird could suffocate. I immediately informed (B)(6) of the noncompliance. The Company elected to humanely euthanize the bird. The Establishments SSOP's state that grey barrels are used for Inedible product. My findings indicate a noncompliance with 9 CFR 381.65(b).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN510902 4625N-1	02/25/2014	04C05	Poultry Good Commercial Practices	O	At approximately 0700 on February 25, 2014 during the night shift at Est. P 6137A, I observed the following non compliance: Two carcasses, which clearly showed signs of having died by means other than slaughter, were found by the line inspector and held for the veterinarian. The carcasses were congested on one side, and one showed an additional 3" line of hemorrhage of the keel. The viscera of both carcasses were congested and livers were friable. This indicates an incomplete bleed, most often caused by dead or dying birds being hung on the line. Mr. (B)(6) was informed and also inspected the carcasses. Carcasses were subsequently condemned, and I informed Mr. (B)(6) that an NR would be issued. Poultry must be slaughtered in accordance with good commercial practices in a manner that will result in thorough bleeding of the carcasses (9 CFR 381.65(b)) and birds plainly showing on ante mortem inspection any disease or condition... would cause condemnation of their carcasses on post mortem inspection, shall be condemned. Birds which on ante mortem inspection are condemned shall not be dressed, nor shall they be conveyed into any department of the official establishment where poultry products are prepared or held. Poultry which has been condemned on ante mortem inspection and has been killed or died otherwise shall under the supervision of an inspector of the Inspection Service, be disposed of as provided in § 381.95. (9 CFR 381.71(a)).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM251202 4025N-1	02/25/2014	01B02	Pre-Op SSOP Review and Observation	C	At approximately 620 hours, while performing a PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 1, Raw side of the establishment: I found piece of chicken approximately 1 ½ inch long stuck in chicken Flattener machine, from the previous day of production. Upon continuing my inspection: Line 2, I found food particles on one of the conveyor belt, also from the previous day of production. All finding described in the non-compliance were on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. I took a regulatory control action and applied USDA retain/rejected tag# B24829887. I informed (B)(6) and (B)(6) of the non-compliance. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0655 hours. Plant SSOP Section1, page1, states: (B)(4). 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.
4630	M7322	AOA330502 0424N-1	02/24/2014	01B02	Pre-Op SSOP Review and Observation	O	At approximately 0415 hours while performing Pre-operational Sanitation Standard Operation Inspection in the establishment's Raw Processing Area Freezer there were "2 Season Ingredient Mixing Bins" stored with a plate of whitish cloudy looking ice (approximately 1 ½ inch thick and 2 ½ square feet wide) in the inside bottom area of the bins. The Season Ingredient Mixing Bins have been observed in use to contain the season ingredients that are use in the formulation of the edible frank product. The condition of the Season Ingredient Mixing Bins did not meet the minimum requirements of 9 CFR 416.13(c), 416.4(a), 416.2(d), and 416.1. USDA retain tag #B40007620 was applied. (B)(6) and (B)(6) was notified. The area was released at approximately 0426 hours when the corrective actions were verified by FSIS. -This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1608021 224N-1	02/24/2014	01B02	Pre-Op SSOP Review and Observation	O	<p>In Evisceration I observed the following:1)The Gizzard Defatting Machine has another new crack in it one inch long in the back. This was shown to and concurred upon by Mr. (B)(6) and Mr. (B)(6) who sets the machine up, 2) I/O Wash Line Two, Red Rubber Hose fraying rubber off, Mr. (B)(6) notified of this issue, 3)Overhead screen in ceiling in the Picking Room has feathers in it, 4) Both Knife Sanitizers in the OSTEOP ROOM were not cleaned, they are bolted down and can't be easily dumped for cleaning, 5)Nails in ceiling are rusting though the paint over, 6) Overhead Industrial Air Moving Unit is getting rusty, 7) Ammonia Lines feeding GIB Chiller are rusty. Ms. (B)(6) was advised of these issues and they were not reflected in her paperwork prior to my notification of the same Boning: 1)Overheads holding shackles at wing trim has UFM on it, 2) Belt for WishBone line is peeling it's surface and was removed from service. 3)End chute off Breast Trim Sorting Belt is cracked again, a one inch crack on the interior of both sides of the Chute. Mr. (B)(6) was shown the Issue as was Mr. (B)(6) 4) Four Stainless Steel Vats with Poultry residue in them. This is a violation of the above 9 CFR's and the Establishment's written program. This NR is Linked to the following NR 15-2014, Dated 02/18/2014, JDD3010025118N/1 and associated linkage.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN550102 0124N-1	02/24/2014	03J04	Poultry Zero Tolerance Verification	O	At 2334 hrs I performed a Poultry Fecal Zero Tolerance Verification Task at the FPS station, a point in the process after the last intervention before carcasses enter the chilling system. I noted the following non compliance: On slaughter line A, I randomly selected 10 carcasses for visual observation. I noted that the seventh of the ten carcasses exhibited a smear, approximately a 1/2 inch by one inch on the leaf fat inside the left side of the carcass that was yellow/brown in color, pasty in consistency. This material is consistent with the characteristics of fecal material. I stopped the line, informed and showed the finding to (B)(6) and (B)(6). I then released control of the line so the establishment could initiate their corrective actions, including a recheck and marking the chiller with a red netted carcass. Further corrective actions included increasing the chiller water by 1/4 gallon per bird. Three post chill checks performed ten minutes apart indicated that there were no further findings of fecal material. The red netted carcass exited the chiller at 0109 hrs. All corrective actions were documented by the establishment in accordance with the establishment's corrective action for a CCP 3B(B)(4)) failure indicating that the CCP was under control.The finding of fecal material on or in a carcass at this point of the production line constitutes a non compliance according to 9 CFR 381.65(e) which states: "Poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank".
1325 7	P33900	NHH401602 3124N-1	02/24/2014	01D01	SPS Verification	C	At 1400 hours while touring the box storage area I also checked the outside premises just below the room. I observed that the inedible product dumpster near dock was over half filled with product that had not been denatured. After returning downstairs to determine why denaturant was not being applied and I was told that the denaturant dispensing equipment was inoperable. CFR 381.95 states that all condemned parts of carcasses, or other condemned poultry products, except those condemned for biological residues shall be disposed of by either of the approved method listed therein. Chemical denaturing in liberal amounts, as elected by the plant, was not being applied at all; therefore this requirement was not met.Management was notified and the dumping area was rejected until denaturant was applied.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH470002 3224N-1	02/24/2014	01C02	Operational SSOP Review and Observation	C	<p>On the night shift that began on 02/23/2014 at approximately 2140 I was in the Evisceration Room at Establishment 33900&nbsp;P to perform a finished product standards procedure on Evisceration line #2.&nbsp;As I walked away from the station on my way back to the USDA office, I saw a band from the inside of the inside/outside bird washer that had come loose from the bracket that holds it in place.&nbsp;A maintenance man was instructed to replace the band on the bracket and as he attempted to accomplish this, the sleeve of his shirt came in contact with the carcasses exiting the unit.&nbsp;&nbsp;Approximately 30 carcasses were affected.&nbsp;&nbsp;&nbsp;Regulatory Control Action was taken by stopping the line, removing the affected carcasses for reconditioning. &nbsp;I then released the line to production. &nbsp;The Preventive Measure given by Mr. (B)(6) was that the Maintenance personell involved would be retrained in sanitary operations during production. &nbsp;Mr.(B)(6) was informed that a Noncompliance Record would be issued documenting the noncompliance. &nbsp;The requirements of Regulations 416.1 and 416.13(c) were not being met. &nbsp;The Establishments SSOP plan objective is, (B)(4)</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA050902 2722N-1	02/22/2014	01D01	SPS Verification	O	<p>On Feb. 20 2014 while performing a Sanitation Standard Operation Procedure Inspection in the establishment cook processing areas, FSIS FLS/Dr.(B)(7)(C) and I observed the following deficiencies: 1. At approximately 1308 hours at the #1 retail batter tank area of the establishment's batter room, we observed a plastic bag that was partially taped to the ceiling panel. The bag contained approx. 6-8 ounces of clear liquid that appeared to be water. The bag was swiftly moving back and forth in response to the air from an air unit. We observed some clear liquid from the ceiling and from the swiftly moving plastic bag, dripping down (to numerous to count approx. 25-30 visible drops) on the cardboard spacer that were partially covering a pallet of approximately 9 bags of open dry batter product. Small portions of 3 bags of the open dry batter product were not covered by the cardboard spacer but close investigation reveal that there were no product contamination or adulteration. Official control action was taken. USDA reject tag #B40017692 was applied to the area and (B)(6), and (B)(6) was notified. The area was released at approx. 1328 hours when corrective measures were observed.&nbsp;- A similar noncompliance was observed on 12/06/13 and documented on NR#AOA3014121006N/1. The preventive measure (further planned action) provided by the establishment that states, "The maintenance department inspected the attic area over the fryer room.&nbsp;The attic area was found to have a water leak from the rain.&nbsp;A panel from the roof had separated at the seam, creating a gap for the rain to enter the attic area and leak through, to the production area.&nbsp;The panel in the roof was resealed and the water was removed from the attic area", appears to be ineffective in preventing this noncompliance. -This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s). -Continued failure to meet regulatory requirements can lead to enforcement actions described in 9 CFR 500.4.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA580902 3322N-1	02/22/2014	01C02	Operational SSOP Review and Observation	C	On Feb. 20 2014 while performing a Sanitation Standard Operation Procedure Inspection in the establishment cook processing areas, FSIS FLS/Dr.(B)(7)(C) and I observed the following noncompliance: 1. At approximately 1315 hours while observing the bulk line fryer areas we observed the frank wash sinks and noticed that the product contact surfaces of the frank wash sinks had a heavy build up of a white, dry, lumpy and crusty looking substance that appeared to be an accumulation of previously wet batter that had dried up. The fryer #2 frank wash sink did not have any written information to declare the intended use (e.g. Frank Wash, Hand Wash, Equipment Wash). The frank wash sinks are used to rewash edible frank product that could be place back into the ready to eat corndog production process. (B)(6) and (B)(6) were notified. No retain tag was applied because immediate corrective measure were taken by the establishment. -This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).
1326 1	M33901	HAY330202 0725N-1	02/22/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	On the calendar date of February 22, 2014 at approximately 2257 hours while performing the Fully Cook -Not Shelf Stable HACCP task, the following noncompliance was observed: On, Thursday February 20, 2014 at approximately 0114 hours I, CSI (B)(7)(C), reviewed the CCP-4 (B)(4) for the date of February 19- February 20, 2014 while inside the RTE clean room. At the time, the log showed that the temperature of Orange Chicken was monitored at "9:15 pm" and that a direct observation of the monitoring was recorded at "9:16pm". "9:17pm" was the time recorded in the record review section of the record. On today's date, I reviewed the log along with the written corrective actions that were performed after a deviation from the critical limit occurred (please reference NR # HAY0118020620N/1) at CCP-4. The log now shows a line marked through the time of "9:16 pm" (initials included) in the direct observation section of the record and the time of "9:15 pm" recorded underneath the original time. No determination can be made as to when the entry of "9:15 pm" was recorded in the direct observation section of the record, as neither the date nor the time was recorded next to the entry. In addition, "acceptable" was recorded in the results column during the Records Review verification at 9:17 pm on 2/19/14 (B)(6) was shown the noncompliance and informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0813025 621N-1	02/21/2014	01C02	Operational SSOP Review and Observation	C	On 02/21/2014 at approximately 1012 hours while performing my inspection duties in the Tray Pack room I observed a stainless steel tank containing approximately 1694 lbs of Turkey Split Half Breast with Scap being brought in from cooler # 3 to be packaged, I observed numerous black flakes of UFM on the product. I immediately took regulatory control action by applying U.S. Retain tag # B43241093 to the tank of Split Breast and informing (B)(6) of my observation and the noncompliance. Upon further inspection in cooler # 3 at approximately 1018 hours, I observed a stainless steel tank containing approximately 1676 lbs of Turkey Necks also with black flakes of UFM on top of the ice covering the necks. Regulatory control action was also enforced on the tank of necks by applying U.S. Retain tag # B43241094 to the tank of necks. Mr. (B)(6) was also informed of the UFM on the tank of necks. Mr. (B)(6) took immediate corrective action in my presence by having the top layers of the product in both tanks reconditioned and washed with (B)(4) ppm (B)(4) water. Regulatory control was relinquished and product released at approximately 1130 hours after the completion of all corrective actions. This is a noncompliance of 9 CFR 416.1 and 9 cfr 416.4(d).
5112	M18909	JDD1307021 721N-1	02/21/2014	01D03	Poultry Sanitary Dressing	O	In last Exit meeting dated 02/14/2014, it was brought to the attention of all parties in the meeting that the Establishment is not taking the rusty conditions in the Rosier Area seriously and no corrective action has taken place to prevent rust from getting in or on the unit. And on this date 02/14/2014, Mr. (B)(6) requested to Mr. (B)(6) follow up and take care of temporary fixes. Today 02/21/2014 at 0915 H PST I went to check if any temporary fixes had been instituted on rusty conditions. There was interventions to be observed and rust observed on the the unit. Mr. (B)(6) and Ms. (B)(6) shown the issues. Mr. (B)(6) and Mr. (B)(6) were verbally on the phone. This is a violation of the above 9 CFR's and is LINKED to NR 014/2014, Dated 02/14/2014, JDD2017023014N/1 and JDD1613020406N/1 dated 02/06/2014.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0719020 921N-1	02/21/2014	03J02	Slaughter HACCP	O	While performing Pre-Chill Finished Product Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 1245 hours, I randomly removed a 10 bird sample from Line 1 in Evisceration Area #1. I found one out of the birds with visible fecal contamination inside the bird at the right side under the leaf fat area. The fecal material was dark green in color, pasty in texture and measured approximately 1/4" diameter in size. This exceeded the limit of Zero Tolerance for the process to be in control. I informed (B)(6), (B)(6) and (B)(6) of the noncompliance. Dr. (B)(7)(C) verified the fecal finding. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1315 hours and it passed. This is a violation of the critical limits of CCP-2B Zero Contamination of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL4409024 620N-1	02/20/2014	01C02	Operational SSOP Review and Observation	C	On 02/18/2014 at approximately 1328 hours, while performing direct observation of the Second Processing Rinse at lunch break at the Rehang 2 Area, I observed the following. The kick outs and sorting belts had been rinsed and an employee had starting applying sanitizer (Quat) to that area. I observed Quality Control check the (B)(4) concentration at approximately 1332 hours. The SSOP Plan states in part under procedure, that (B)(4). The employee that was applying the (B)(4) sanitizer had already begun sanitizing the area when Quality Control measured the concentration of the (B)(4). I informed (B)(6) of the noncompliance. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.13(b) and 9CFR 416.13(c).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5519022 020N-1	02/20/2014	01C02	Operational SSOP Review and Observation	O	<p>At approximately 1315 hours, while monitoring the mid-shift rinse procedure at the (B)(4) Room, I observed production employees were rinsing the area with potable water. At approximately 1350 hours while they were rinsing the floor&nbsp;they over sprayed two stacks of clean product brown tubs, the brown tubs were located next to the sink on the back of the cone lines. I immediately tag the tubs with U.S. Retained/Rejected Tag # B31 406455 and B31 406436 and informed (B)(6) and (B)(6) of the noncompliance. (B)(6) sent the tubs to the tub wash room, I then removed my tags. At approximately 1405 hours, I observed when Quality Control finished her checks in the (B)(4) Room and sanitation personnel were also finished with the rinsed and the application of the sanitizer (B)(4). The belt that it is over the chute by the Cone Line (B)(4) was not rinsed and sanitized with (B)(4)). The belt that transfers the halves to the cones (line 1 to line (B)(4)) was not rinsed and sanitized with (B)(4) either. I informed (B)(6) of the noncompliance. The SSOP Plan states in part&nbsp;under procedure (B)(4) . At approximately 1420 hours the belts were rinsed and sanitized, then the&nbsp;Area was released. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.13 (b) and 9CFR 416.13 (c).</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM561202 5220N-1	02/20/2014	01B02	Pre-Op SSOP Review and Observation	C	<p>At approximately 0650 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 1, Cook side of the establishment: I found piece of chicken stuck on blue incline belt from the previous day of production. Upon continuing my inspection Line 1, I observed lots of bulid up underneath frame and the pipes around the C-49 blue conveyor belt also from previous day of production. I took a regulatory control action and applied USDA retain/rejected tag# B24829882. I informed sanitation (B)(6) and (B)(6) and (B)(6) of the non-compliance. The finding described in the non-compliance was on the food contact surface and very close to the food contact areas, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0730 hours. Plant SSOP Section1, page1, states: (B)(4)</p> <p>. 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". 9CFR 416.4 (b) states: "Non food-contact surfaces of facilities, equipment, and utensils used in the operation of establishment must be cleaned and sanitized as frequently as necessary to prevent the creation and the adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY011802 0620N-1	02/20/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	On the calendar date of February 20, 2014 at approximately 0114 hours while performing the review and observation component of the Fully Cooked -Not Shelf Stable HACCP task, the following noncompliance was observed: Cooling finished product to <31.3F is the critical limit prescribed at CCP 4 -after the freezer & metal detector step- in the establishment's HACCP plan. I, CSI (B)(7)(C), measured the temperature of Orange Chicken at CCP 4 by inserting the probe of the thermometer (calibrated and provided by the establishment) inside 2 pieces of product. After equilibrating, the thermometer read 34.4F. I proceeded to take additional temperatures from different pieces of product from the bag and obtained temperatures of 33.8F, and 34.7F, respectively. At this time, I notified Lernetha (B)(6), QA Technician, of my results and requested that she also monitor the temperature of the product from a different bag. Ms. (B)(6) monitored the temperature of the product at CCP 4 (from a different bag) in my presence, and once the thermometer equilibrated, the results read 33.9F. I reviewed the CCP 4 HACCP Record and noted that the last acceptable temperature was recorded at 1212 hours. Production was stopped, and all product since the last acceptable check (8 combos and 4 pallets of packaged and labeled product) were retained with U.S. RETAINED tag # B40172385. (B)(6), was notified of the noncompliance and informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. .

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2505024 119N-1	02/19/2014	01C02	Operational SSOP Review and Observation	O	On 02/19/2014 at approximately 0100 hours while monitoring Post-Chill Finished Product Standards from product exiting Chiller #3, I observed the following. After taking a standard 10 bird random sample, I observed two birds with medium gray flakes of UFM(Unidentified Foreign Material) that appeared to be paint. I contacted (B)(6). The birds were already being hung going to the Weight/Check line. One of the first birds dropped at the first collection tank on the Weight/Check line had a similar gray flake measuring approximately 1/8" by 1/8" on the left side exterior of the carcass near the abdominal opening. A partial tank of the birds collecting at the Check/Weight location was retained under QC hold for reinspection. I contacted (B)(6), showed him the flakes and informed him of the noncompliance. The flakes on the carcasses measured approximately 1/8"by 1/8" located on the outside of the carcass on the left side near the abdominal opening, approximately 1/8" by 1/8" located on the inside on the left leaf fat, and approximately 1/4" by 3/8" on the exterior of the carcass in the depression left by the oil gland removal. The UFM crumbled easily upon contact. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).
5308	M6137	BXL4117022 719N-1	02/19/2014	03J02	Slaughter HACCP	O	While performing Pre-Chill Finished Product Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4).At approximately 1053 hours, I randomly removed a 10 bird sample from Line 1 in Evisceration Area #1, I found one out of the ten birds with visible fecal contamination inside the bird at the right side under the leaf fat area. The fecal material was dark green in color and pasty in texture, measured approximately 3/16" diameter in size. This exceed the limit of Zero Tolerance for the process to be in control. I informed (B)(6), (B)(6) and (B)(6) of the noncompliance. Dr. Reza Hejazi verified the fecal finding. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1116 hours and it passed.This is a violation of the critical limits of CCP-2 (B)(4) the Plant's HACCP Plan for Slaughter.
5112	M18909	JDD0610021 318N-1	02/18/2014	01D01	SPS Verification	C	At 0125 H PST 02/18/2014 I observed a Female Employee unroll a Tank Liner (USED FOR PRODUCT SURFACES) from the Master Roll, and contaminate it upon the Evisceration Floor. She was not aware that her action contaminated the Liner. Mr. (B)(6) and (B)(6) was notified of the Situation and of the intent of documentation. This a violation of the above 9 CFR's. This is linked to NR 010-2014, Dated 01/24/2014, JDD2010010724N/1 and JDD1208013317N/1

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3010025 118N-1	02/18/2014	01802	Pre-Op SSOP Review and Observation	O	<p>At 2245 H PST, 02/17/2013 while performing PRE-OP on CHILLERS A&B the following was noted: 1) Ceiling has numerous nails in it that were painted over, nails rusted flaked off paint and now the rusty nails readily show up, also some rusty electrical conduit was observed. In Evisceration in general was observed Electrical Boxes that are extremely rusty. These issues showed to and or discussed with Mr. (B)(6) and Ms. (B)(6) was advised and her paperwork updated with my information. This also violates 9 CFR: &nbsp;This is also a violation of this&nbsp;9 CFR::§416.4&nbsp;&nbsp;&nbsp;Sanitary&nbsp;Operations. (a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.The following noted as follows BONING ROOM:: 1) Over head rails for Carcass' by the Ice/Carcass Separator has black UFM on it; 2) On the back side of the Contherms, the lift controls are extremely rusty; 3) The chute&nbsp;at the end&nbsp;of the Breast Sorter Belt has a 3 inch crack on the product side of the chute; 4) Black UFM on long belt feeding MDP; 5)&nbsp;Seven Stainless Steel vats observed with poultry residue in them; 6) Off conditioned wings in Cooler 5, had (B)(6) to tag the product; 7) Lines 1 & 2 Tray Pack shrink tunnels had UFM; Tape used to hold cutting board material Line One; Cooler Ten had blue tub with UFM in it and white tub setting upon a&nbsp;box and a lable stuck in the interior of this edible use container; 8) On Saddle Machine 2 on hose observed with UFM on it; 9)Fiberglass repairs on wall by SHOVEL HANGERS is broke and peeling paint. This all showed to and concurred upon by Mr. (B)(6) and&nbsp;Mr (B)(6) no of these items were in his paperwork prior to&nbsp;my notification of the same. This is a violation of the above 9CFR's and the Establishments written SSOP program. This is Linked to the following NR 017-2014, Dated 02/10/2014, JDD5623023310N/1 and associated numbers JDD1405025803N/1+5</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0218022 118N-1	02/18/2014	03J02	Slaughter HACCP	O	<p>The establishment's Inside Outside Bird Wash program states, "(B)(4)"</p> <p>" However, on multiple occasions the establishment did not document some of the parameters. For example, on December 30, 2013 at 1259 hours, and December 26, 2013 at 1539 hours, the Timing, Alignment, and One-Leggers checks were not documented. On December 12, 2013 at 1455 hours, and December 26, 2013 at 0835 hours, the sprayer, shower heads and pumps operating check was not documented. On December 24, 2013, at 0430 hours, and December 29, 2013, at 2339 hours, no pressure was documented.&nbsp; On December 13, 2013, at 0629 hours, the records show that for the PSI "Error – wrong entry" was documented, but no other entry was made with the correct PSI. The establishment is not implementing CP 4 – Inside Outside Bird Wash Monitoring program as written. This is a regulatory noncompliance under Title 9 CFR 417.5(a)(1).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0218022 118N-2	02/18/2014	03J02	Slaughter HACCP	O	<p>The establishment's CP 5 – Chlorine, pH and Peracetic Acid Monitoring program states, "Peracetic Acid QA will collect samples at the frequency below when utilizing (B)(4) in the following applications: Picker Rails Operating Limits (B)(4) ppm... b. Verification of Peracetic Acid Concentration; i. Giblet Chiller, Carcass Chiller, Paw Chiller 1. Rinse vial three times with sample solution 2. Fill vial with 30 mL of sample water; 3. Add 20 drops of Sulfuric Acid 1:1 (water color should remain clear) 4. Add 3 drops of Ferroin Indicator (water color will turn pale orange); 5. Add 3 drops of Potassium Iodide (water color will turn orange/rust) 6. Add Sodium Thiosulfate 0.1N, one drop at a time, counting the number of drops until water turns pale orange. 7. Calculate the ppm of Peracetic acid by multiplying the number of drops by 5... Reconditioning Hose – Carcass Re-Hang Post Chill (operating limits) (B)(4) ppm (pH limits) 5.5 – 6.5...iii. pH Measurement (prior to testing for chlorine) 1. Press the power button to turn on the meter. Meter screen should default to pH measurement mode, if not press mode (enter) to display pH for pH measurement mode. 2. Thoroughly rinse the electrode with distilled water and place in the sample. 3. The meter will default to AUTO mode. Press measure (esc) and wait until READY appears and the "pH" stops blinking. 4. Remove the electrode from the sample and rinse with distilled water. To read additional samples, repeat steps 2.b-2.d. 5. When finished measuring, place electrode in storage solution...; c. Corrective Actions i. Immediately notify maintenance/production. ii. Perform a re-check once notified by maintenance that adjustment has been made. iii. If re-check concentration is not within operating limits, repeat step 2.c.i."</p> <p>However, during the on-site visit, the EIAO observed that the Picker Rails were below (B)(4) ppm of (B)(4) and no corrective actions were taken. According to management, the limits had been lowered to (B)(4) ppm but the program did not reflect this. In addition, the EIAO observed that Stannous sulfate was added to the Giblet Chiller, the Carcass Chiller, and the Paw Chiller. The procedure does not indicate that Stannous sulfate is to be added to the titration. The EIAO observed that during the titrations the vials were not rinsed with the sample three times and that the pH probe was not rinsed with distilled water in-between samples, as indicated in the written program. On January 28, 2013, the EIAO observed that at 1229 hours, the concentration of the reconditioning sample was (B)(4) ppm and the pH was 6.0. At 1301 hours, a recheck sample was collected and the concentration was (B)(4) ppm, the EIAO asked the employee if she would take the pH of the sample. The pH of the recheck was 8.67. On February 3, 2014, the EIAO reviewed the CP 5 records and noted that the pH of 8.67 was not documented and no recheck was collected. The pH was within acceptable range at the next routine check conducted at 1421 with a pH of 5.6 and a chlorine concentration of 27. The establishment cannot support that the Chlorine, pH and Peracetic Acid Monitoring program is</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							being implemented as written. This is a regulatory noncompliance under 9 CFR 417.5(a)(1).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1214023 318N-1	02/18/2014	04A06	Poultry Finished Product Standards	C	On 02/18/2014 at approximately 1046 hours while performing a Pre-Chill Finished Product Standards Task in the Evisceration Area on Line (B)(4), I observed the following. After taking a standard random 10 bird sample, I accumulated 35 nonconformance points. I informed (B)(6) and Quality Control performed a recheck. At approximately 1051 hours, the recheck failed with 36 nonconformance points. At this point the process is judged to be out of control. I informed (B)(6) of the noncompliance. Quality Control performed a Post-Chill check at approximately 1102 and passed. At approximately 1108 hours, Quality Control performed a Pre-Chill check and passed, bringing the process back in control. Quality Control performed Post-Chill checks approximately every 30 minutes until the product under process control arrived. My findings indicate a noncompliance with 9CFR 381.76(b).
5308	M6137	BXL1518024 718N-1	02/18/2014	03C02	Raw Intact HACCP	O	The establishment's records indicate that on multiple occasions the establishment is not collecting samples as indicated in the program. For example on December 6, 2013, December 18, 2013, no breast samples were collected during the AM shift. On December 23 and 27, 2013, and January 6 and 25, 2013, no breast samples were collected during the PM shift. In addition, on December 4, 2013, and January 4, 2014, the establishment collected two breast samples instead of an extra leg sample as indicated in the program. The establishment is not implementing their program as written. These are regulatory noncompliances under Title 9 CFR 417.4(a)(1) and 417.5(a)(2).
5308	M6137	BXL2707023 118N-1	02/18/2014	01C02	Operational SSOP Review and Observation	O	On 02/18/2014 at approximately 0315 hours while monitoring Operational Sanitation in Plant 2, I observed the following. ABF (Anti-Biotic Free) birds were entering Chiller #4 after being treated with Cetylpyridinium Chloride, (B)(4) antimicrobial. The antimicrobial treatment is rinsed off in the chiller adding an unknown amount of (B)(4) to the chiller water. Packaging was still packing 'Organics' from before lunch and birds were still exiting Chiller 4. 'Organics' were being exposed to the Cetylpyridinium Chloride, which is not an authorized antimicrobial for product labeled 'Organic'. I contacted (B)(6) and stated that 'Organics' were still being processed. I informed him of the (B)(4) treated birds entering Chiller #4. The birds on the rehang belt and birds exiting chiller #4 until approximately 0326 hours were down graded from 'Organics' to ABF by production. I informed (B)(6) of the noncompliance. My findings indicated a noncompliance with 9 CFR 416.4(d).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3908025 618N-1	02/18/2014	01C02	Operational SSOP Review and Observation	O	At approximately 0040 hours while monitoring Pre-Chill Finished Products Standards in Plant #1 on Line #1, I observed the following noncompliance. After taking a random 10 bird sample, when I opened up the neck area to inspect it I observed a shiny piece of metal approximately 5mm x 1mm on the fat on the left side of the neck area under the skin. I informed (B)(6) of the noncompliance. According to PDD, FSIS considers metal of any size on a carcass to be an unacceptable contaminant that should be addressed by the Establishments' Hazard Analysis. The issue of metal contamination has been discussed at previous weekly meetings with the Establishment. My findings indicate a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).
1325 7	P33900	NHH350202 1018N-1	02/18/2014	01D01	SPS Verification	C	On the night of production which began on 02/17/2014 in est. 33900 P, Inspection found the Main Hallway between the QA/HACCP Office and the Drydock in an unsanitary condition. A dried patch of dirty water at least 6 feet in length and 1 foot in width was present and Power Jacks which are used in the Further Processing Department to move Raw Edible Product were being driven through it and into the Further Processing Area where Floor Salvage is conducted. Inspection took Regulatory Control Action by taping off the Area and placing Us Reject Tags #B38075672 at 0039 Hours and #B38075667 at 0041 respectively. Sanitary conditions were restored to the Hallway at 0122 Hours at which the two tags were removed. The requirements of 9CFR 416.1, 416.2(b)(1) and 416.2(b)(2) were not being met and Night-shift Plant Superintendent Mr. (B)(6) was advised that a Non-compliance record would be generated. Refer to NR #NHH0503105231N/1 dated 10/30/2013 for a similar noncompliance.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY040802 3718N-1	02/18/2014	01B02	Pre-Op SSOP Review and Observation	C	<p>On calendar date February 18, 2014 (Tuesday) at approximately 0655 hours while performing Pre-Op SSOP Review and Observation task in the IF Department (zone 10), the following noncompliance was observed: I, (B)(6), observed a brown, dusty residue all along the top surface of 2 two overhead Verifeeder pipes. These pipes are insulated with a white covering and are used to pump cold water to the (B)(4) Tanks on Line (B). These pipes are approximately 35' in length. I also observed that the overhead ammonia pipes had a similar brown, dusty residue present on the top surfaces. I showed Mr. (B)(6) (B)(6) and Ms. (B)(6) of the conditions and informed them that there was Sanitation Performance Standards noncompliance. The establishment's SSOP, states that (B)(4)</p> <p>" According to the S3 Sanitation Cleaning company schedule, the overhead equipment will be cleaned on a weekly basis. The establishment failed to meet the requirements for 9CFR 416.4(b) and 416.1.</p>
5308	M6137	BXL1116023 715N-1	02/15/2014	04A06	Poultry Finished Product Standards	O	<p>At approximately 1301 hours, I randomly removed a 10 bird sample from Line (B) A in Evisceration Area #2 for Pre-Chill Finished Product Standard Check, I documented 39 points in the Processing Nonconformances from the 10 bird sample. This exceed the subgroup absolute limit of (B)(6) points for the Processing Nonconformances to be in control. I informed Quality Control of the failure and at approximately 1310 hours she performed a recheck. Quality Control documented 27 points on the Processing Nonconformances, this exceed the limit of the (B)(6) points allowed for the recheck, at this point the process is considered out of control. I informed (B)(6) of the noncompliance. Corrective actions were implemented. Quality Control performed rechecks at Pre-Chill and Post-Chill. At approximately 1505 hours the process was back in control. This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b).</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5806023 815N-1	02/14/2014	01C02	Operational SSOP Review and Observation	O	<p>At approximately 1805 to 1855 hours on February 14, 2014, while monitoring the establishment’s Operational Sanitation Standards in the Packaging, (B)(4) Room, and Rehang areas, I observed the following deficiencies: (B)(4) Room & Packaging Department Areas:</p> <p>a) Establishment’s employee hygiene cleanliness issues with correct method of sanitizing personal equipment (gloves, aprons, boots) and direct handling of unsanitized contaminated areas prior to direct product contact. Establishments personnel are cleaning their personal equipment (boots, aprons, gloves) from dirty to clean (boots to apron and gloves) without resanitizing their gloves prior to going back to their production duty lines and handling product.</p> <p>b) Personnel are also handling unsanitized areas (wheeled dollies which hold stacked racks of product); (the actual wheel portion which is in direct contact with the filth of contaminated areas of the establishment) with their green gloves and not resanitizing their gloves prior to handling unsealed bulk product. Direct cross contamination issues creating a failure of preventing adulterated product being processed. All above discrepancies were creating adulterated food safety noncompliance. I informed (B)(6); (B)(6); and (B)(6) of the noncompliance. Corrective actions were implemented immediately. All personnel involved was stopped from working with product; resanitized their equipment; and product involved was condemned per establishment. All affected areas were restored to correct sanitary conditions by 1855 hours. My findings indicate a non compliance with the regulatory regulations 9 CFR 416.1; 416.13(c); 416.4(d); and 416.5(a).</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ3517025 714N-1	02/14/2014	04A06	Poultry Finished Product Standards	O	On February 14, 2014 I, CSI (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for trim nonconformances is 10 points. My test at 1444 resulted in 27 points. At approximately 1504 a retest was performed by (B)(6) using a tighten criteria of 12 points which failed with 17 points. I verbally notified (B)(6) of the noncompliance and that I would be issuing a NR. The plant implemented the required procedures for FPS failure. Two passing Prechill tests were achieved at 1531. No failing tests at Postchill are documented. The Prechill nonconformances I observed at 1444 were: 3 bruises > 1" (6 pts), 8 scabs/IP & 1/2" (16 pts), and 1 IP > 1/2" (5 pts). On January 17, 2014, NR # OIJ4601011718N (#2) was issued for processing noncompliance which is the second part of FPS Prechill requirements. The written response given that Maintenance made adjustments to bring the process under control was not effective to prevent recurrence of Prechill FPS noncompliance. This noncompliance is linked to NR # OIJ4601011718N (#2) for the same root cause of Prechill FPS noncompliance. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the January 23, 2014 meeting.
5308	M6137	BXL0816025 913N-1	02/13/2014	01C02	Operational SSOP Review and Observation	O	On February 6th
5308	M6137	BXL3222022 413N-1	02/13/2014	01B02	Pre-Op SSOP Review and Observation	C	On 02/12/2014 at approximately 2200 hours while monitoring the establishments' Pre-Operational Sanitation procedures in Plant #2, I observed the following. There was heavy beaded condensation above Chiller #3 middle section near the giblet chillers. The condensation was on the PVC, metal and vinyl covered pipes, and concrete ceiling surfaces directly above the chiller. The ceiling and piping are treated as non-product contact surfaces. I informed (B)(6) of the noncompliance. I moved to the center walkway between the chillers to monitor the drying of the affected surfaces and observed the same beaded condensation condition on the pipes and ceiling surfaces over large areas above both Chillers 3 & 4. The condensation was removed restoring sanitary conditions by approximately 2210 hours. My findings indicated a noncompliance with 9 CFR 416.1, 416.2(d), 9 CFR 416.4(d), 9 CFR 416.13(c) and 9 CFR 416.14.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM412202 4713N-1	02/13/2014	01D01	SPS Verification	C	On 02/13/2014, at approximately 2000 hours, while performing a directed Sanitation Performance Standards (SPS) inspection task in response to a deficiency on the Cook Area Line (B)(6) Oven Room, I observed the following noncompliance: beaded and dripping condensation coming from a hanging gray electrical wire and electrical box to a panel cover sensor above the belt wash to the oven creating insanitary conditions, a noncompliance per 9 CFR 416.1 and 416.2(d). The condensation was dripping in close proximity to the oven belt. Also, the screw brackets to the electrical box were pitted and worn. I took regulatory control by rejecting the area with US Tag # 24829911. I showed and informed Mr. (B)(6) (B)(6) of the forthcoming noncompliance. Corrective actions were immediate performed by production restoring sanitary conditions, I relinquished the US Tag at 2010 hours. The requirements of Title 9 CFR 416.1 and 416.2(d) were not met.
5308	M6137	BXL2814025 712N-1	02/12/2014	03J02	Slaughter HACCP	O	On 02/12/2013, at approximately 0840 hours, I observed how the Establishment's employee performed the Salvage Parts Treatment Procedure on the evisceration parts in Plant #2. The procedure was acceptable. At approximately 0844 hours, I observed Quality Control performed CCP-1B (b) (4) (B)(4). At approximately 0930 hours, I went to and reviewed the records for (B)(4) Monitoring Log Plant #2" for Evis Parts. I noticed that the (B)(4) concentration was (B)(4) ppm) at 0812 hours, (B)(4) ppm) at 0843 hours and at 0904 hours the recheck passed with (B)(4) ppm). On the Product Hold and Release Form it was written Hold Tag # 58393, hoses retained released when (B)(4) in compliance. The hose of (B)(4) was retained at 0817 hours and released at 0904 hours. The Salvage Parts procedure was performed with concentration of (B)(4) ppm of (B)(4) HACCP Plan -Slaughter Plant 2- under step #36 states in part: Parts Salvage (B) Pathogens, i.e. Salmonella. Is the Hazard significant? No. Justification for decision (B)(4) (B)(4) (B)(4) Supplements 2,7,17,18,56. HACCP Supplement #56, Salvage Parts Treatment: CP-19 under procedure #2 states in part (B)(4) (B)(4) (B)(4) water (B)(4) ppm and (B)(4) concentration (B)(4) ppm" (B)(6) (B)(6) was informed of the noncompliance.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1013023 711N-1	02/11/2014	03J02	Slaughter HACCP	O	While performing Pre-Chill Finished Product Standards Task, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 0852 hours, I randomly removed a 10 bird sample from Evisceration Area #2, Line █, I found one out of the ten birds with visible fecal contamination inside of the bird between the tail and the kidneys, the bird had side cut tail. The Establishment marking system used the side cut tail to identify possible fecal contamination from the (B)(4). The fecal material was dark green in color and pasty in texture measured approximately 1/4" long by 3/8" wide in size. This exceed the limit of Zero Tolerance for the Process to be in control. I informed (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0920 hours and it passed. This is a violation of the critical limits of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.
5309	P6137A	NJN101802 3811N-1	02/11/2014	03J04	Poultry Zero Tolerance Verification	C	At approximately 1422 hours, while performing PHIS finished product standards task in the evisceration department on the reprocessing off-line, prior to the birds entering the chiller, I observed one carcass, out of the ten (10) carcasses random sample, contaminated with visible fecal material. The fecal material was approximately half inch long and quarter of inch wide, brown in color, pasty in consistency, and located on a broken back bone close to the tail of the carcass. I took regulatory control action by stopping the reprocessing line and applied a US retain tag, # B43303968, on the affected carcass. The finding was shown to Mr. (B)(6) █, and (B)(6) █. SPHV, Dr. (B)(7)(C) █, confirmed that my finding was indeed fecal material. The reprocessing line and the affected carcasses were released to the establishment, allowing QC representative to perform a re-check and the plant procedures for fecal failure. The findings of fecal material on a carcass passed the final wash cabinet en-route to the chilling system represents a zero tolerance failure, as outlined in the establishment's HACCP and in accordance with the regulations 9 CFR 381.65(e) which states: "poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank." 9 CFR 417.2(c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits." A PHIS slaughter HACCP task was performed to verify that all corrective and preventative measures were completed. The plant took action to control CCP1B and turned up the chiller overflow to 1/4 of gallon per bird, marked the chiller to identify the end of the affected lot, and post chill checks were performed until the mark came out of the chiller.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN481102 2812N-1	02/11/2014	04A06	Poultry Finished Product Standards	C	While performing a finished product standards check on the reprocessing line, at approximately 1422 hours, prior to the birds entering the chiller, I observed the following noncompliance. In a sample of ten carcasses, there were five carcasses with split tail, which identifies that vacuuming is required to remove all affected tissues including the kidneys. One carcass had yellow gelatinous tissue on one side of the rib cage and a bruised wing, and another carcass had large amounts of yellow flacks and gelatinous tissue on the flap area as well as a bruised mutilated thigh. In addition, I found two other carcasses with cellulitis on the breast muscle and the stomach still inside the carcasses. Another three carcasses had partial crops; one of them had inješta on the crop area and the stomach inside the carcass. I immediately took regulatory control action by stopping the re-processing line and showed Mr. (B)(6), my findings and informed him of the forthcoming noncompliance. The presence of all these deviations and affected tissues in ten carcasses indicates that the re-processing line was not under control. The plant failed to effectively apply their procedures and comply with the federal regulations 9 CFR 381.84, 381.86, 381.89.
5112	M18909	JDD5623023 310N-1	02/10/2014	01B02	Pre-Op SSOP Review and Observation	O	On 02/10/2014 in Evisceration I observed the Gizzard Defatter Machine, interior product contact area to have a three inch crack. Mr. (B)(6) and Mr. (B)(6), in charge of setting up the Machine. Was to be welded prior to start up. Picking room had numerous feathers on overheads. Ms. (B)(6) was also advised of the issues. In (b)(4) room the floor is breaking up. Ms. (B)(6) and Mr. (B)(6) was advised This is a violation of the above CFR's and the Establishment's written program. This is linked to 012-2014, Dated 02/03/2014, JDD1405025803N/1 and Five other associated JDD Numbers.
5308	M6137	BXL1618025 410N-1	02/10/2014	01D01	SPS Verification	O	While walking through Plant #2 between evisceration lines at approximately 1500 hours, I observed numerous beads of condensation formed on the ceiling above the automatic drawers machines for Line (b)(6) and Line (b)(6). The condensation also was along the ceiling from the entrance of the condemned room through station #10, Line (b)(6). I informed (B)(6) and (B)(6) of the noncompliance. (B)(6) immediately started wiping down the condensation. I walked through the body opener area and observed more condensation above the back up body opener Area for the (b)(4) lines and the drip pan, also in the paw room was condensation on the ceiling. Establishment personnel wiped down the condensation. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2 (d).

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3320020 610N-1	02/10/2014	03J04	Poultry Zero Tolerance Verification	O	On 02/10/2014 at approximately 1040 hours, while performing a Zero Tolerance Task on Line #1 in Evisceration, I observed the following. After talking a random 10 bird sample, I found 2 birds with visible fecal cotamination. The fecal on the first bird was located inside on the left under the leaf fat. The fecal material measured approximately 3/16" in size, olive green in color and slightly watery in texture. The fecal on the second bird was located inside on the right under the leaf fat. The fecal material measured approximately 5/16" in size, olive green in color and pasty in texture. This exceeds the limit of Zero Tolerance for the process to be in control. I informed (B)(6) after I had found the first bird with fecal, of the noncompliance and the protocol for fecal failure was implemented. Quality Control performed the recheck at approximately 1055 hours and passed, bringing the process back into control. Quality Control performed post chill checks on the suspect lot, and all checks passed. My findings indicate a noncompliance with 9CFR 381.65(e) and 9CFR 417.(c)(4).
5308	M6137	BXL4520020 610N-1	02/10/2014	01C02	Operational SSOP Review and Observation	O	On 02/10/2014 at approximately 1315 hours, Line #1 in Plant 1 was stopped and there were no birds on the line. Maintenance was working on the plastic that was covering the leaks in the ceiling observed by plant personnel. I was informed by one of the USDA Inspectors that there was water dripping from the ceiling in another location. I shone my flashlight at the ceiling located towards the front and to the right side of the Inspectors Station #3. I observed the droplets of water that was falling from the ceiling and I informed (B)(6). Another USDA Inspector that was on Station #4, informed me that drops of water were falling on her at the Inspectors Station. I again shone my flashlight up at the ceiling and I observed that water was dripping from 2 bolts that were in the ceiling to the right side and towards the front of the station. I informed (B)(6) and I placed a U.S. Rejected/Retained tag #B31406631 on Line #1. I informed (B)(6) of the noncompliance. Maintenance placed plastic under the leaks and the line was washed restoring sanitary conditions. I removed the tag and released the line at approximately 1341 hours. The previous corrective actions were insufficient to prevent the reoccurrence. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.13(c), 9CFR 416.2(b)(1), 9CFR 416.2(b)(2), 9CFR 416.4(a), and 9CFR 416.4(d).

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4919021 410N-1	02/10/2014	01B02	Pre-Op SSOP Review and Observation	O	<p>On 02/10/2014 at approximately 0740 hours while monitoring Pre-Operational Sanitation Procedures in Plant 1, I observed the following. On the Inspectors station #2, I shone my flashlight up at the ceiling and saw beaded water on a seam running along the ceiling. I informed (B)(6) and an employee came with a sponge mop and wiped the water off the ceiling. Upon further inspection I saw that there was more water, along the same seam on the ceiling in the middle of Line 1 and Line 2 that was dripping directly above the product area. While maintenance was taking corrective action by putting up plastic under the leaks in the ceiling, I continued with the pre-op in the evisceration department. At Chiller #2 I observed beaded condensation on a pipe directly over the chiller at approximately the middle section. I informed (B)(6), and a sanitation employee wiped off the pipe. I informed (B)(6) of the noncompliance. I tagged both Line 1 and Line 2 with U.S. Rejected/Retained tags #B31406636 and #31406641. After maintenance had finished putting up plastic and after the lines were washed restoring sanitary conditions, SCS (B)(7)(C) removed the tags and released the area at approximately 0910 hours. At approximately 0900 hours while performing Pre-Operational Sanitation Procedures in Packaging, I observed the following. A drip pan directly over Line 1 was covered with heavy beaded condensation. I informed (B)(6), and a sanitation employee wiped off the drip pan. I continued to Line 2 and I observed a drip pan directly over the line was also covered with heavy condensation. As I observed the employee wiping off the drip pan, drops of condensation fell onto the product belt. I informed (B)(6) and the belt was washed and sanitized restoring sanitary conditions. I informed (B)(6) and (B)(6) of the noncompliance. The previous corrective actions were insufficient to prevent the reoccurrence. My findings indicate a noncompliance with 9CFR 416.1, 9CFR 416.13(c), 9CFR 416.2(b)(1), 9CFR 416.2(b)(2), 9CFR 416.4(a), and 9CFR 416.4(b)</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN272102 5110N-1	02/10/2014	01C02	Operational SSOP Review and Observation	C	<p>On February 10, 2014 while walking through the Packaging department I, CSI (B)(7)(C) observed the following noncompliance. The drip pan directly above the (B)(4) product exit rollers was overflowing due to a clogged drain. The water was falling from the drip pan at a rapid and steady rate. The (B)(4) releases front halves of chickens by weight into a brown tub and an employee puts a clean lid on the tub as it exits the machine. I observed one tub with front halves in it exit the (B)(4) and water from the drip pan fell on to the product inside the brown tub. At approximately 1841 hours I took a regulatory action by tagging the affected product in the tub and informed (B)(6) of the forthcoming noncompliance. (B)(6) stopped production and restored sanitary conditions by unclogging the drip pan and removing all water from the overhead drip pan, as well as sanitizing the exit rollers. The affected product was reworked by the establishment and reinspected and released at approximately 1910 hours. These findings represent a noncompliance with the regulatory requirement of 9CFR 416.4(d) which states: Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments.</p>
5308	M6137	BXL0210023 507N-1	02/07/2014	03J02	Slaughter HACCP	C	<p>On 02/05/2014 at approximately 0946 hours while observing Quality Control performing a CP-1 Vent and Body Opening check in Plant 2, I observed the following. Line (B)(4) check was performed and documented, Line (B)(4) was documented as "No Product Available" even though there were birds on the line and the line was running, and Line (B)(4) check was performed and documented. This is a noncompliance with not verifying the operation of the (B)(4) and body opener on each line. The establishments' HACCP Plan-Slaughter Plant 2-Vent/Body Opener Step 12, under Potential Hazards Introduced, Controlled, or Reduced at this step, Is the hazard significant? No. Under 'Justification for Decision' it states in part, (B)(4) ". This is a noncompliance with 9CFR 417.5(a)(1). I informed (B)(6) of the noncompliance.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0610025 407N-1	02/07/2014	01D01	SPS Verification	O	While going to performed Post-Chill Finished Product Standards Task, at approximately 0948 hours, I observed numerous beads of condensation formed on the ceiling above the dumper for Chiller #1 (B)(4) cabinet, the drip pan for the (B)(4) cabinet and the water rinse cabinet. These last areas are product contact surfaces, the dumper in front of Chiller #1 transfers the birds from stainless steel tanks to the rehang conveyors belts. I immediately informed (B)(6) of the noncompliance. He took immediate corrective action by wiping down the condensation. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2(d).
5308	M6137	BXL5102025 407N-1	02/07/2014	01B02	Pre-Op SSOP Review and Observation	C	On 02/06/2014 at approximately 2222 hours while monitoring Pre-Operational Sanitation procedures in Plant 1, I observed the following. There was a heavy layer of brown rust on the top chain driven sprocket for the Oil Gland Cutter for line 1. The rust coating had migrated down the shaft from the upper sprocket and was pooling on the lower sprocket that does the oil gland removal. Mechanics were called and the upper rusted chain was replaced on both lines with a stainless steel chain. After grinding and buffing was completed (B)(6) was called to remove the numerous specks and metal shards to approximately 1" left on the oil gland cutter, PMT machine and rehang belts. The items were rewashed restoring sanitary conditions by approximately 0115 hours. At approximately 2228 hours there was heavy beaded condensation on the ceiling above the Heart and Lung Remover on line 2. The condensation covered the ceiling from the wall on the line 2 side near station 8 to inspection station #4 on line 1, and from inspection station 8 to the line 2 Cropper. The condensation that was mopped with sponge mops and blown down with air. The use of air on the ceiling caused the entire area to be contaminated with specks and pieces of black and brown UFM (Unidentified Foreign Material) to approximately 1/2". Stations 4 & 8, Line 2 Liver Harvesting and the Giblet sorting belt were all rewashed to restore sanitary conditions by approximately 2300 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(a) & (b) and 9 CFR 416.13(c).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5404021 607N-1	02/07/2014	01B02	Pre-Op SSOP Review and Observation	O	At approximately 2414 hours on February 7, 2014, while monitoring the establishments Pre-Operational Sanitation Standards in the Packaging Department area, the (B)(4) Room, I observed the following deficiency: a) Wishbone Conveyor - grey and white support bars (entire length) - greyish to black coloring from mold growth on excessive yellowish product and thick slimy, textured fat buildup left under rim of support and on the guide bars. Black pipe running parallel to the conveyor had a buildup of sticky yellowish fat/residue full length of pipe area. b) Back Conveyor - stainless steel bar and white guide bar - full length of conveyor - excessive buildup of yellowish product and thickish slimy textured fat left under rims, guide bars, and the conveyor belting. All above discrepancies were creating food safety noncompliances. I informed (B)(6); (B)(6); and (B)(6) of the non compliances. Areas recleaned, sanitized and released at 2435 hours. My findings indicate a non compliance with the regulatory regulations 9 CFR 416.1, 9 CFR 416.13(a), 9 CFR 416.4(a) and (b).
5568	M20923	XUM001402 5707N-1	02/07/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	At approximately 1125 hours while performing HACCP task (the record review component of procedure for fully cooked-not shelf stable process), I observed the following noncompliance: While review the records in the QC office dated 2/6/14 Line 1 (b)(4) CCP-2B product Grilled chicken strips the check made at 21:57 temperature # 5 recorded (B)(4). Establishment HACCP Plan states- (B)(4) Records were reviewed on 2/7/14 at 7:29 am by (B)(6). There was no corrective action and deviation documented at temperature deficiency. I notified the (B)(6) about the non-compliance. This does not meet the requirement of 9 CFR 417.5(a)(3) which states: "The establishment shall maintain: Records documenting the monitoring of CCPs and their critical limits, including the recording of the actual times, temperature, or other quantifiable values, as prescribed in the establishment's HACCP plan; the calibration of process-monitoring instruments; corrective actions, including all actions taken in response to a deviation; verification procedure and results; product code(s), product name or identity. Each of these records shall include the date the record was made". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA462102 1206N-1	02/06/2014	01C02	Operational SSOP Review and Observation	C	At 2120 hours regulatory control action was taken when the following non compliances were observed as while performing an observation and review of the establishments operational sanitation and santiary performance standards within the packaging department of Foster Farms in Demopolis Alabama. I observed water dripping from the end of a valve on a 3/4 inch water pipe along north east wall of the department, as the dripping was splatter off a concrete side extension of the wall and in the same vacinity next to employees packaging corn dogs along the conveyor line. No product was affected yet an insanitary condition was more than likely than not at all. Upon further observation I observed product boxes, plastic, gloves, wood sticks (used for the corn dogs), standing water, water in pans over flowing with grease and oil on the department floor. In addition, product over flow on the conveyor belt had corn dogs flowing onto the catch pans when packaging was backing up. Plant employees immediately removed in excess of 50 pounds of corn dogs to be discarded. Multiple trash recepticles and trash gondolas were over flowing. After corrective actions were taken and all sanitary requirements were met, the area was released officially back to the establishment for control of operations
5112	M18909	JDD1613020 406N-1	02/06/2014	01D01	SPS Verification	C	On 02/06/14 at approximately 0940 hours while performing my presentation check in evisceration I observed the following noncompliance to 9 CFR 416.1 and 9 CFR 417.2(d). I observed heavy beaded condensation on the main overhead water pipe crossing over Line 1 and Line 2 evisceration lines. I immediately informed (B)(6) of my observation and noncompliance. Mr. (B)(6) immediately took corrective action by having the condensation wiped off to restore sanitary conditions. No product was involved.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA2816024 910N-1	02/06/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	<p>During a routine patrol of the Cook Pack Department, I observed noncompliance with HACCP regulatory requirements 417.2(a)(1), 417.2(a)(2) and 417.4(a). On February 6, 2014 at approximately 1420 hrs. in the New Corndog Fryer Room I observed as 3 employees removed casing from cooked (RTE) franks that were located on the top of one stainless steel table. This table was located adjacent to one wall and in close proximity of Fryer #5. The Corndog Supervisor, Ms. (B)(6), was notified and asked if it was customary for this RTE frank product to be 'reworked' at this particular location. (B)(6) stated that she was unsure. (B)(6) accompanied me as I proceeded to the QA office in order to review the establishment's written 'Deli Plant Frank HACCP Fully Cooked - Not Shelf Stable Program'. Documentation in the Flow Chart demonstrated that the 'Rework' process step is only performed in the Raw Product Processing Department and is then incorporated into the 'Batching' process step. Documentation in the Hazard Analysis identified one biological food safety hazard, Listeria monocytogenes, as reasonably likely to occur at the 'Rework' process step. However, justification defined the probability of this biological food safety hazard occurring as 'low risk' as the process is designed through programs of product inspection and temperature control to reduce risk associated with the hazard. While reviewing the HACCP Program, Superintendent, Mr. (B)(6) joined us who was notified of IPP's concern with food safety for the RTE product taken out of the defined frank processing product flow. We returned to the New Corndog Fryer Room where the 3 employees were still in the process of removing the casing from the exposed RTE franks. Mr. (B)(6) confirmed that the RTE product was, in fact, undergoing the "Rework" process at this alternate location in the post lethality environment. I asked Mr. (B)(6) to take random internal product temperatures of the franks on the table top as well as in the one edible product barrel that the 'Rework' product was being transferred to. The average RTE product temperature was (B)(4) F. As the 'Rework' process step was being performed in an alternate location and one that was not included in the Flow Chart of the above cited written HACCP Program is noncompliance with 417.2(a)(2). Also, a hazard analysis had not been performed for the alternate 'Rework' process step which is noncompliance with 417.2(a)(1) and 417.4(a). Official regulatory control action was taken and U.S. Retain Tag No. B31408287 was collectively used to retain the RTE post lethality exposed frank product located on the table top and in the edible product barrel. Mr. (B)(6) elected to condemn the U.S. Retained product and proceeded to transfer this product from the two sites into one condemn barrel (81 lbs). Upon appropriate product disposition official regulatory control action was relinquished and the above cited U.S. Retain Tag was removed (1445</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							hrs).This document serves as written notification that failure to comply with the regulatory requirements in 9 CFR Part 417 could result in adulteration of product and could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ2115025 607N-1	02/06/2014	01C02	Operational SSOP Review and Observation	C	<p>On February 6th 2014 at approximately 0826 hours I entered the packaging floor coming from the chiller area and as I passed rotisserie at the area of the thigh and leg belt lines along the outer perimeter I stumbled upon a scene where two tan totes of whole birds had fallen and spilled onto the floor and establishment employees were picking whole birds off of the floor and placing them back into the tan totes of which they originally spilled out. Whole potentially insanitary birds from the floor were being comingled with whole clean birds that did not spill out of the tan totes. In the immediate area where whole birds spilled onto the floor there was a grated floor trough style drain system, a pallet jack and a large black wheeled refuse container. It is reasonable to assume that establishment employees involved did not have a working understanding of the establishment's floor salvage program since comingling of sanitary product with insanitary product is unacceptable. It is further reasonable to assume that whole birds may have been rendered permanently insanitary and not eligible for the floor salvage program after coming in contact with an employee boot, the grate covering the trough style drain, the pallet jack or the refuse bin. I identified (B)(6) and asked her where those birds were being taken. She informed me they were going to a rinsing table in the chiller area to undergo floor salvage reprocessing. I immediately walked back to the chiller area and observed multiple tan totes with whole birds. The tan totes were not labeled with orange establishment hold tags. There was no way to visually distinguish the birds that had fallen onto the floor and been comingled with clean birds from another tan tote in the immediate vicinity containing whole birds which may or may not have been involved in the incident. I took a regulatory control action and I informed (B)(6) that I was retaining all the tan totes with whole birds in the chiller area near the reprocessing table until I could unequivocally determine their wholesomeness. (B)(6) became involved and I explained what I had observed and my concern that there was unaccounted and unidentifiable potentially permanently insanitary product present and comingling had occurred. He checked and counted birds in the red condemn barrel just to the side of the reprocessing table in the chiller area and the number of birds could not account for the total number of birds that spilled onto the floor. &nbsp; Mr. (B)(6) and I walked back to the scene where the initial incident had occurred and stumbled upon a second identical incident occurring where another two tan totes containing whole birds had spilled onto the floor and multiple establishment employees were again picking birds off of the floor and comingling them with clean whole birds that remained in their tan totes. None of the tan toes were labeled or marked in any way to distinguish them from the multiple covered tan totes containing wholesome product. Mr. (B)(6) immediately stepped in and told establishment employees to stop what they were doing and walk away from the scene. Mr. (B)(6)</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							enlisted the assistance of other (B)(6) and (B)(6) to gain control of the scene and collect all whole birds involved. I observed all whole birds involved or potentially involved consolidated into four tan totes, labeled with orange establishment retain for disposition tags and placed in a labeled product hold area next to rotisserie. I verbally informed Mr. (B)(6) that I would be issuing a noncompliance report. (B)(6) became involved and informed me that she wished to review the establishment's written floor salvage program and inform (B)(6) of the situation and she would get back with me shortly as to the establishment's disposition of the birds. I verbally informed Mrs. (B)(6) that I was unlikely to accept any disposition other than condemnation. At approximately 0910 hours Mrs. (B)(6) informed me that the establishment had decided to render all product involved or potentially involved. I accompanied Mrs. (B)(6) and Mr. (B)(6) out onto the packaging floor and observed all four totes of consolidated whole birds be placed into a red establishment condemn barrel. All whole birds from both instances that were involved or potentially involved were rendered and no unwholesome or potentially insanitary product entered commerce.
1326 1	M33901	HAY030002 1608N-1	02/06/2014	01C01	Operational SSOP Record Review	C	On the calendar date of February 6, 2014 at approximately 1855 hours while performing the Operational SSOP Record Review task, the following noncompliance was observed: The Implementation and Monitoring section of the establishment's Sanitation SOP's states that (B)(4), I, CS (B)(7)(C), reviewed the operational records from the previous day's operations, February 5, 2014. The record showed that all procedures were monitored and were found acceptable and included the initials of the QA technicians who performed the procedures. However, while performing the Operational SSOP Review and Observation task on the previous day, I, along with Dr. (B)(7)(C), observed water dripping from an overhead pipe onto bagged dry ingredients near processing line # 2. At the time of the observation, the line leader had notified maintenance of the leak and the dry ingredients were being removed from the area to prevent product contamination. The establishment failed to document the deficiency on the official SSOP record as well as the corrective actions that were taken to restore sanitary conditions. (B)(6), and (B)(6), were notified of the noncompliance and informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3803022 005N-1	02/05/2014	01C02	Operational SSOP Review and Observation	C	On 02/05/2014 at approximately 0022 hours while monitoring Operational Sanitation in Packaging Area 1, I observed the following. There was black UFM(Unidentified Foreign Material) specks and smears to approximately 1/2" by 2" on the whole body carcasses on line 1916. The birds had received their final trim, final antimicrobial intervention and the giblets were being added back into the 'Organic' birds at the location where I was making my observations. After taking off several birds in a row the line was stopped and (B)(6) was called. An additional employee was placed at the final trim location to removed the affected birds. Approximately 30 carcasses were removed and held for reconditioning. The UFM was located on the drumstick and at the joint area with the thigh on the carcasses. (B)(6) held 2 partial racks of packaged product for reinspection. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).
5308	M6137	BXL4619020 805N-1	02/05/2014	03J04	Poultry Zero Tolerance Verification	O	While performing Zero Tolerance Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 1452 hours, (B)(6) randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination, inside of the bird at the right side between the tail and the leaf fat area. The fecal material was dark green in color and pasty in texture, measuring approximately 1/4" diameter in size. This exceed the limit of Zero Tolerance for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1545 hours and it passed. This is a violation of the critical limits of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4723023 805N-1	02/05/2014	01C02	Operational SSOP Review and Observation	O	<p>At approximately 1815 hours to 1840 hours on February 5, 2014, while monitoring the establishments Operational Sanitation Standards in the Packaging Department and Rehang areas, I observed the following deficiencies:</p> <p>a) Plant 2 – Sanitation Personnel was washing down during production time at the Pre-chill/FPS tables, drip pans, pipes, and floor area. They were directly spraying the day’s slaughter production debris from a non-product contact surfaces into Chiller # 3, a direct product contact surface and onto product while passing on shackles. b) Plant 1 – Sanitation Personnel was washing down during production time by the Chillers and washing the day’s slaughter production debris from a non-product contact surface directly into the Chillers, which is a product contact surface and a hold orifice for the product while chilling. Plus they were washing down into the Chiller while the product was still in there chilling down to the correct temperature. c) Rotisserie Room – Sanitation Personnel was washing down before the completion of the task that was being performed. The wash down was creating heavy fog moisture which settles on pipes and ceiling, which are insanitary, non- product contact surfaces. The fog creates heavy moisture droplets coming from these insanitary areas, which falls onto the product and the boxes with the packing blue liners (ready for product and packing). Contaminating all product contact surfaces. All above discrepancies were creating food safety noncompliances. I informed (B)(6) and (B)(6), and (B)(6) of the non compliances. Corrective actions were implemented immediately. Inappropriate sanitation cleaning ceased until completion of production, product was removed, boxes and liners all condemned, and all the affected areas were restored to correct sanitary conditions by 1916 hours. My findings indicate a non compliance with the regulatory regulations 9 CFR 416.4(d) and 416.13(c). &nbsp; &nbsp;</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN210302 0105N-1	02/05/2014	01B02	Pre-Op SSOP Review and Observation	C	After QC had performed pre-operational sanitation and the area was released for USDA inspection, the following non compliances were noted in the respective areas: Food Service Area at approximately 0035 hrs. The white product transfer belt of multi-cut #2 had black grease like material on the surface. This belt is a product contact surface used to convey the cut up pieces of chicken to the red mesh net hopper. Packaging Area at approximately 0047 hrs. Leg Processor #1 had multiple pieces of fat and product residue on the frame along with numerous pieces of fat on the cutting board and frame of the cutting board located on the east side of the machine. The cutting board is also a product contact surface. I informed and showed (B)(6) these findings as he was present during the inspection and informed him of the issuance of the non compliance report. A USDA retain tag was not issued since the areas were in control with the lock-out/tag out procedures. After the units were washed and sanitized the areas were released for production. These findings represent a non compliance with 9 CFR 416.4(a) and 416.13(c). On 12/16/2013, Non Compliance report NJN3103121817N/1 was issued for similar findings on leg processor #2 in the packaging area.
1326 1	M33901	HAY341602 5706N-1	02/05/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	On the calendar date of February 5, 2014 at approximately 1543 hours while performing the recordkeeping component of the Fully Cooked -Not Shelf Stable HACCP task, the following noncompliance was observed: I, CSI (B)(7)(C), reviewed the HACCP record (CCP 3) from the previous day's operations; 2/4/2014. The record shows that the recorded temperatures met the critical limit prescribed in the HACCP plan, and that all monitoring and verification procedures were performed at the frequencies prescribed in the HACCP plan. "2/4/14" is the only date recorded in the "DATE" section of the record which indicates that all entries were made on 2/4/14. The record also shows that product temperatures were monitored and recorded past midnight on 2/4/14; however, the entries made after midnight do not include the date of 2/5/2014. (B)(6) was shown the noncompliance and she confirmed the findings. Ms. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on January 8, 2014; please reference NR # HAY0703013909N/1. The establishments response to NR # HAY0703013909N/1 of - (B)(4) - failed to prevent recurrence.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN421802 5504N-1	02/04/2014	01D01	SPS Verification	C	On February 4, 2014 while performing a routine patrol of the cook side departments I and FLS Dr. (B)(7)(C) observed noncompliance with SPS regulatory requirement(s) 416.4(d); 416.4(b) and 416.2(b)(1). At 15:35 hours I observed the east wall to have a hole in the white panel under the refrigeration unit above the pipe in the cook pack shipping dock; as well the metal frame of the door to the cook pack shipping dock cooler was broken; exposed wood and caulking was visible. As well on the east wall a white metal panel was broken and bent as well; there was a large exposed gap on both sides of the ceiling refrigeration unit and black unidentifiable black material on the seams from the ceiling to the walls in the same cook pack shipping dock storage cooler. Also there were three sections on the ceiling in the hallway between the coolers and the (B)(4) chillers where loose caulking or sections of metal ceiling material were hanging down. Mr. (B)(6) was notified and shown the noncompliances. This NR serves as written notification of SPS noncompliance; as well as notification that failure to comply with regulatory requirement(s) may lead to additional regulatory or administrative actions as described in 9 CFR 500.4.
5129	M210	LQN421802 5504N-2	02/04/2014	01D01	SPS Verification	C	On February 4, 2014 while performing a routine patrol of the establishment's raw production areas I and FLS Dr. (B)(7)(C) observed noncompliance with SPS regulatory requirement(s) 416.4(d), 416.4(b) and 416.2(b)(1). At 16:10 hours I observed in the raw cooler to the left of the scale a gap between the stainless steel guard and the floor, the gap had pieces of concrete coming loose and on the floor as well the wall area behind the stainless steel water system tank had loose caulking and rust between the white wall panels and stainless steel guard in several locations on the west wall. As well the oven loading area had a CIP monitoring equipment machine that had a severely rusted motor on the bottom side as well as rusted conduit attachments and components all over the machine parts and yellow gauges. Mr. (B)(6) was notified and shown the areas. This NR serves as written notification that failure to comply with regulatory requirement(s) may result in additional regulatory or administrative actions as described in 9 CFR 500.4.
5308	M6137	BXL5305022 404N-1	02/04/2014	01B02	Pre-Op SSOP Review and Observation	O	At approximately 2400 hours

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM581502 4804N-1	02/04/2014	01D01	SPS Verification	C	This morning approximately at 1040 hours, while performing PHIS routine SPS task (Other Inspection Requirements/ Facilities and Equipment Standard), the following noncompliance was observed: Cook side of the establishment Line (B)(6) North side wall of the fryer room hand pallet jack charger has peeling paint and very rusty. I informed (B)(6) and (B)(6) of the non-compliance. Poorly maintained facilities and equipment can and do harbor food borne pathogens, which can then multiply and be dispersed throughout the food processing environment increasing the chances of product contamination which can render product adulterated. 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that the product is not adulterated". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.
5112	M18909	JDD1405025 803N-1	02/03/2014	01B02	Pre-Op SSOP Review and Observation	C	On PRE-OP this date 02/03/2014 in Evisceration was noted the following: 1) 11/2 inch crack in the interior of the Gizzard Defatter by the Final Wash. 2) Above final wash, line two, the Overhead Fan is insanitary with Black UFM on Blades and supports for Fan are rusty. 3) I/O Wash Line Two has a Frayed Hose, 4) Picker Three has a Four Inch Weld that is Cracked. 5) Overheads in Picking Room has Feathers too numerous to count. 6) Plastic Strips insanitary with numerous Feathers from blood tunnel into first wash. 7) First Wash Spray Nozzles has UFM on both of them. 8) Pipes on Wall, Line One, near Head Pulling are black with UFM. 9) Evisceration Mens Restroom, the wall dividers between Urinals are insanitary and rusty. Mr. (B)(6) had been notified of this issue last week. Mr. (B)(6), Ms. (B)(6), Mr. (B)(6) were notified of their respective issues. Issues were not previously documented in QC paperwork prior to notification of the same. In TRAY PACK, LINE ONE, SHRINK TUNNEL, the Exhaust Hose and related Piping has Black Grimy UFM inside them. Mr. (B)(6) and QC notified and it was not documented in (B)(6) (B)(6) paperwork prior to my notification of the same. These are violations of the Establishment written SSOP program and the above 9 CFRs. This is linked to NR 011-2014, Dated 01/31/2014, JDD1407012031N/1 and Six other related JDD numbers.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1407012 031N-1	01/31/2014	01B02	Pre-Op SSOP Review and Observation	C	Pre-op this date 01/31/2014 at 0500 H PST in the (B)(4) Room off of Rosier Area, the Computer and Electrical Panel so dusty as to write your name in dust. This is a violation of the Establishment's written SSOP program and the above 9 CFRs. This is linked to NR 009-2014, Dated 01/23/2014, JDD3611015623N/1 and Five other associated JDD Numbers. Mr. (B)(6) was shown the Noncompliance and Q.C. Paperwork had no documentation of this prior to my notification of the same.
5568	M20923	XUM301101 4531N-1	01/31/2014	01B02	Pre-Op SSOP Review and Observation	C	At approximately 0645 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line #, Cook side of the establishment: I found lots of pieces of food particles on UHMW guide incline conveyor belt, few food particles under chute and also found food particles above (B)(4) belt bars from the previous day of production. Upon continuing my inspection Line #, some of the batter pipes have food particles also from previous day of production. Found one of the batter mixer pipe rusty. I took a regulatory control action and applied USDA retain/rejected tag# B24829877. I informed (B)(6) and (B)(6) (B)(6) and (B)(6) of the non-compliance. The finding described in the non-compliance was on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0735 hours. Plant SSOP Section1, page1, states: (B)(4) ". 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH050901 3531N-1	01/31/2014	03J02	Slaughter HACCP	C	<p>On Friday, January 31, 2014, at approximately 0801 hours, while performing Poultry Finished Product Standards (Prechill) on Evisceration Line #2, I observed fecal contamination on the outside of the first carcass randomly selected for the ten bird sample. The fecal material was located below the oil gland area. The fecal was approximately 1/4 inch in size and light brown in color. It had a watery texture to the touch. There were no plant employees between me and the chilling tanks when I performed this check. Therefore, It is reasonable to assume that the feces would have entered the chilling tanks in violation of Regulation 9 CFR 381.65(e). Mr. (B)(6) was notified of the deviation for the Critical Control Point CCP-1, (B)(6) at CCP-1, and he was shown the carcass. He immediately implemented the establishment's corrective action for visible feces at CCP-1. At 0815 hours, Mr. (B)(6) notified me that the cause of the noncompliance was equipment malfunction. Mr. (B)(6) stated, (B)(4) . The preventative measure that was given was that a supervisor or leadperson will check the Bird Brush rotation everyday at start up. A similar noncompliance was documented on NR NHH0801014321N/1 dated 01-21-2014. The further planned action may not have been implemented or was ineffective in preventing the reoccurrence of this similar noncompliance.</p>
5308	M6137	BXL4318010 429N-1	01/29/2014	04A06	Poultry Finished Product Standards	C	<p>On 01/29/2014 at approximately 1517 hours while performing a Pre-Chill Finished Product Standards Task on Line #2 in Plant #1, I observed the following. After taking a standard random 10 bird sample, I accumulated 32 nonconformance points. There were 3 cloacas, 1 intestine, 3 whole lungs, 1 pin-feather, 1 feather, and 2 long hocks. This exceeds the subgroup absolute limit of (B)(6) points. I informed (B)(6) of the failure and Quality Control performed a recheck. At approximately 1527 hours, the recheck failed with 34 nonconformance points. At this point the process is judged to be out of control. I informed (B)(6) of the noncompliance. There were no other rechecks at pre-chill due to the shift finishing. Post-Chill checks were performed every 30 minutes until the birds finished coming out of the chiller. My findings indicate a noncompliance with 9CFR 381.76(b).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4716014 729N-1	01/29/2014	03C02	Raw Intact HACCP	C	<p>At approximately 1725 hours on 01/28/2014, while monitoring the (B)(4) dip on Line (B)(4) in Packaging, I observed the following noncompliance. There was one spray nozzle that was not working on the spray rinse that is required after the thighs go through the (B)(4) dip. The spray nozzle that was not working was located on the end of the spraying unit and I noticed that the thighs going under it were not being rinsed. The establishments' HACCP Plan -Raw Intact-Packaging Step 16 Parts Dip, under Potential Hazards Introduced, Controlled or Reduced at the step lists (C) Cetylpyridinium Chloride and Is the hazard significant? No. Under 'Justification for Decision' it states (b) (4) (B)(4) [REDACTED].</p> <p>[REDACTED]. A review of FSIS Directive 7120.1 Rev 16 dated 08/13/2013 under 'Antimicrobial lists "Cetylpyridinium Chloride used 'To treat the surface of raw poultry carcasses or parts (skin-on or skinless) and then 'Dip tank application' to treat poultry carcasses/parts "When application of the additive is not followed by immersion in a chiller, the treatment will be followed by a potable water rinse. I informed (B)(6) and she informed the employee that was dumping a tub of thighs into the (B)(4) dip to stop. The line was stopped and I informed (B)(6) of the noncompliance. Quality Control retained the racks of packaged thighs from the last acceptable check. On 01/29/2014, the packages of thighs were opened and the thighs were rinsed with potable water. My findings indicate a noncompliance with 9CFR 417.2(a)(1) and 9CFR 416.4(d).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH271301 4029N-1	01/29/2014	06D02	Other Inspection Requirements	C	<p>On Wednesday, January 29, 2014, while performing an Other Inspection Requirement Task (Paw Diverter Check), on Evisceration Line #2 Station #2, I observed the following noncompliance. I asked the establishment to perform a Paw Diverter Verification Test; maintenance and production personnel performed the test. I observed when the paw diverter button for Inspection Station #2 was pushed, the paws did not divert into the condemn container; instead, they went into the paw chilling system where they were mixed with inspected paws. I immediately notified Mr. (B)(6), of the noncompliance and applied USDA Reject Tag # B 29 699848 to the system at 1134 hours. I checked the paw diverter paperwork that the establishment documents their checks on and the last acceptable check was made at 0930 hours. Mr. (B)(6), tagged and condemned 32 cases of Grade A paws and 2 cases of B Grade paws and 10 cases of C Grade paws that were produced between 0930 hours and 1134 hours. After lunch Mr. (B)(6) notified me that maintenance was ready for me to perform a retest. I performed a retest with production personnel on Evisceration Line #2 Station #2 and it failed at 1238 hours. I performed another retest with them at 1245 hours on Evisceration Line #2 Station #2 and it passed. I notified Mr. (B)(6) that he could resume saving paws; he had restored sanitary conditions to the chilling system during the lunch break. At this time the tagged was removed. There was a similar noncompliance documented on noncompliance report #NHH5500125412N/1 dated 12-12-2013. There was no further planned action given.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN421101 4128N-1	01/27/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	On January 27, 2014 at approximately 1220 hours, while performing records review on HACCP records. I observed that the Pre-Shipment Review Log for Further Processed Product cook log CCP-1B was not verified for production date January 25, 2014. The Pre-Shipment page was filed with no signature a deviation was in the works for an oven failure but there was no exception report or other documentation filed along with the log. This is a Noncompliance of the verification activities of the HACCP Plan. This does not comply with establishment Verification Activities for CCP-1B and CCP-2B to be met prior to shipment. This does not comply with 9CFR 417.5(c) which states in part "Review prior to shipment", and 9CFR 417.4(a)(2)(iii) which states in part: Records review" (B)(6) was informed of the Noncompliance and (B)(6) was shown and informed of the noncompliance. This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions.
5308	M6137	BXL3109015 226N-1	01/26/2014	03J02	Slaughter HACCP	C	On 01/25/2014 at approximately 2350 hours while monitoring Pre-Chill Finished Product Standards on Line in Plant #2, I observed the following. After taking a standard 10 bird sample, I observed one carcass with visible fecal contamination. I contacted (B)(6) and an employee was stationed at the end of the line to wash carcasses per the establishments' protocol for fecal failure, however hanging was not stopped. The fecal material was on the inside of the carcass on the tissue under the left side fat flap. The fecal material was olive green in color, pasty in texture and measured approximately 1/2" by 1/4" by 1/8". (B)(6) directed (B)(6) to perform a recheck as it was near break time. The recheck passed at 0013 hours. The cause of the failure was determined to be the Inside Outside Bird Washer. A QC check of the Inside Outside Bird Washer on line at 2342 hours documented that the bird washer was working satisfactorily including timing, alignment, one leggers, spray valves, and pump with the water pressure at 77psi. The Pickup Sheet for the shift had the average bird weight at 7.0 pounds. The line was running at birds per minute at the time of the failure. The tail of the bird had been marked by the Establishments' procedure to identify birds that do not pass through the (B)(4) or Body Opener correctly. issues with the fecal failure protocol (not stopping hanging), line speed, marked tail and bird size were all discussed with (B)(6). The production line was moved to line after break. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1304010 924N-1	01/24/2014	01B02	Pre-Op SSOP Review and Observation	C	On 01/23/2014 at approximately 2230 hours while performing Pre-Operational Sanitation verification after the establishments Pre-Operational checks, CSI (B)(7)(C) observed the following noncompliance to 9 CFR 416.4(b) in Plant 1 area 4 unit 13 line 2 liver harvester. CSI (B)(7)(C) observed blood and fat on the frame and sides of the liver harvester from the previous days production. Liver Harvester was cleaned and sanitized in my presence and (B)(6) and (B)(6) were notified of the noncompliance. In Plant 2 at approximately 2232 hours CSI (B)(7)(C) observed pasty fat on the inside of Chiller #3 above the water line covering an area measuring approximately 3 feet long to 6" wide and up to 1/4" thick. There was also numerous pieces of fat and tissue to approximately 1/2" splattered on approximately a 6' long section of a brace at the same location. There was also pasty fat covering approximately a 6" by 2" section of a bracket attached to the base of the kick out mechanism. The chiller was cleaned and released at approximately 2236 hours. At approximately 2233 hours the inside of the Finishing Chiller for line had numerous pieces of fat and tissue to approximately 1/2". There was also a heavy layer of grease on the paddle associated with the unit that was at the top of its cycle and out of the water. The Finishing Chiller was dumped, cleaned and released by approximately 2239 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c) and 9 CFR 416.14.
5309	P6137A	NJN560201 0724N-1	01/24/2014	03J04	Poultry Zero Tolerance Verification	C	At approximately 00:10, the following noncompliance was noted. During the performance of a zero tolerance verification procedure on "B" line, I noted visible fecal material on the exterior of a poultry carcass. The affected area was located on the hock joint area of the right leg. The fecal matter measured approximately one eighth of an inch in diameter, was brown in color and of a paste like consistency. Upon noticing the affected carcass, I stopped the processing line and showed the fecal matter on the affected bird to Ms (B)(6) and Mr. (B)(6). After notification, the establishment implemented corrective actions which included a subsequent recheck on "B" line. The recheck was conducted, completed and passed by Ms (B)(6) at 00:18. The establishment did not meet the requirements of 9 CFR 381.65(e) which requires that the establishment prevent poultry carcasses contaminated with visible fecal material from entering the chilling system. In addition, the finding of visible fecal on a carcass after the final wash does not meet the establishment's critical limit for CCP 1B of "no visible fecal". Consequently, there is also noncompliance with 9 CFR 417.2(c)4.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3611015 823N-1	01/23/2014	01B02	Pre-Op SSOP Review and Observation	O	Floor in OSD, Rosier OH, Inedible Hook
5112	M18909	JDD3611015 823N-2	01/23/2014	01B02	Pre-Op SSOP Review and Observation	O	In Tray Pack Shrink Tunnels Line one and (b)(4) were observed to be insanitary condition, Line One had a piece of styrofoam in it 1" x 6", feeding belt to tunnel is cracked and frayed and Line (b)(4) had UFM in the bottom Pan. This is a violation of the Establishment SSOP Program and the above 9 CFR's. Quality Control paperwork did not reflect these issues. This is linked to NR 002-2014, Dated 01/07/2014, JDD3010012407N/1 and four other associated JDD Numbers.
5308	M6137	BXL2804013 223N-1	01/23/2014	03J02	Slaughter HACCP	C	On 01/23/2014 at approximately 0000 hours while monitoring Pre-Chill Finished Product Standards on Line (b)(6) in Plant 2, I observed the following. After taking a standard 10 bird random sample I observed one carcass with visible fecal contamination. I contacted (B)(6) and the protocol for fecal failure was implemented. The fecal material was on the inside of the carcass on the tissue under the left side fat flap. The fecal material was olive green in color, pasty in texture and measured approximately 3/8" by 1/8" by 1/8". A QC recheck passed at 0035 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the critical limit of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL4514011 323N-1	01/23/2014	01C02	Operational SSOP Review and Observation	O	At approximately 1050 hours while performing Post Chill Finished Products Standards task in Plant #1, I was walking past Drop #3 in the Plant #1 Packaging Rehang Area when I observed the following noncompliance. I stopped next to the bin staged for product at Drop #3 and observed a carcass on top of the pile already in the bin with black UFM (unidentified foreign material) on one of its hocks. On further investigation I found 1 more carcass with black UFM on the hocks. I immediately informed (B)(6) of the noncompliance, as QC was walking past the area I informed QC of my findings and she applied a QC hold tag to the bin pending rework. I continued on to perform my Post Chill task on Chiller #2 where I took a random 10 bird sample and found 3 out of the 10 birds with black UFM on the hocks. I immediately informed (B)(6) and QC of my findings, (B)(6), (B)(6) and (B)(6) were also informed of the findings as well as (B)(6). My findings indicate a noncompliance with the regulatory regulations of regulations 9CFR 416.1 and 9CFR 416.4(d).

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5508014 823N-1	01/23/2014	06D02	Other Inspection Requirements	C	On 01/23/2014 after receiving complaints from inspectors on line (B)(6) concerning Presentation I reviewed the Presentation Log for the shift and found no documentation concerning "Parts" inside the birds. I conducted a Presentation procedure on line (B)(6) with the line running at (B)(4) birds per minute) and on the first station observed (1) viscera on shackle, (1) membrane, (3) not reflective (2) parts inside and (1) contamination for a total of 24 nonconformance points. This exceeded the limit of (B)(6) points or (B)(6) occurrences for one error for the process to be in control. The third station had (1) viscera on shackle, (2) not reflective, (6) parts inside for a total of 18 nonconformance points. (B)(6) was informed of the failure. QC rechecks at 0401 hours failed. At this point the process is judged to be out of control. The line was slowed to (B)(4) A recheck at 0427 hours at (B)(4) passed at which time the evisceration process was moved to Line (B)(6) My findings indicated a noncompliance with 9 CFR 381.76(b).
5308	M6137	BXL4208012 922N-1	01/22/2014	01C02	Operational SSOP Review and Observation	O	On 01/21/2014 at approximately 2240 hours in Plant 1, Line # 2 , Inspection station 7, Inspector (B)(7)(C) observed a piece of shiny metal measuring approximately 2 inches by 1 inch and 1 cm thick attached to the viscera of a chicken on the evisceration line . Inspector (B)(7)(C) immediately stopped evisceration line # 2 and informed CSI (B)(7)(C) of the metal on the chicken viscera. CSI (B)(7)(C) notified (B)(6) of the metal . Production on line 2 was stopped and corrective action was done to find the source of the metal. Production was resumed at approximately 2330 hours after corrective actions were completed. According to PDD, FSIS considers metal of any size on a carcass to be an unacceptable contaminate that should be addressed by establishments Hazard Analysis. The issue of metal contamination has been discussed at previous weekly meets with the establishment. This noncompliance is being linked to NR BXL5704014912N dated 1/12/2014.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM061101 1222N-1	01/22/2014	01B02	Pre-Op SSOP Review and Observation	C	<p>At approximately 625 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 2, Raw side of the establishment: I found few food particles on (B)(4) from the previous day of production. Upon continuing my inspection: Line 3, I found food particles on hopper 3A, also GCO in feed conveyor belt has lots of food particles and some build up on the bars, also from the previous day of production. All finding described in the non-compliance were on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. I took a regulatory control action and applied USDA retain/rejected tag# B24829888. I informed (B)(6) and (B)(6) and (B)(6) of the non-compliance. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0700 hours. Plant SSOP Section1, page1, states: (B)(4). 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH440501 3522N-1	01/22/2014	01C02	Operational SSOP Review and Observation	C	<p>On the night shift that began on 01/22/2014 at approximately 0225 I was in the Further Processing Room #1 at Establishment 33900&nbsp;P.&nbsp;I was in the area to perform a scheduled SSOP Operational Sanitation tour.&nbsp;As I walked through the room I observed a card board combo that contained inedible wing tips.&nbsp;&nbsp;The combo was not identified as containing inedible product.&nbsp;The requirements of 9CFR 416.3(c) were not being met. &nbsp;I walked approximately 20 feet further and saw a combo of back portions that were also inedible.&nbsp;This combo also did not display anything that would identify the product as inedible.&nbsp;The 2 combos were retained with USDA Retain tags #B38075849 and B38075850 respectively.&nbsp;&nbsp;Approximately 10 feet from this combo was a pallet of boxes with blue plastic liners that had been over sprayed during the floor wash down.&nbsp;These liners are product contact.&nbsp;&nbsp;Regulatory Control Action was taken by applying USDA Reject Tag #B38075851 to the pallet of boxes. Mr. (B)(6) and Mrs. (B)(6) were in the area and were shown the noncompliance. &nbsp;The Preventive Measure given by Mrs.(B)(6) was, "disciplinary action was taken against employee". &nbsp;(B)(6) and Mrs.(B)(6) were informed that a Noncompliance Record would be issued documenting the noncompliance. &nbsp;For similar noncompliance refer to NR # NHH5705015821N / 1, dated 1/21/2014. &nbsp;The requirements of Regulations 416.3(c) and 416.13(c) were not being met. &nbsp;The Establishments SSOP plan objective is (B)(4)</p>
5129	M210	LQN461901 4821N-1	01/21/2014	04B01	Labeling - Product Standards	C	<p>On January 21, 2014 at 1500 hours while observing the operation in the Cook Side Dicing Department, I observed a Labeling/ Product Standard Noncompliance.&nbsp;I observed five barrels of edible product staged at the dicer ready to be diced without labels to identify the product.&nbsp;U.S. Retain Tag NO. B38937059 was applied to the five barrels of edible product.&nbsp;I informed and showed Ms. (B)(6) the noncompliance.&nbsp;This does not comply with Regulatory Requirement 381.117; which states in part: (B)(4), 381.122; which states in part:&nbsp;(B)(4), and 381.123; which states in part:&nbsp;(B)(4). Immediate corrective actions was implemented by management:&nbsp;U.S. Retain Tag was removed after &nbsp;Product was Identified with the proper label in my presence.&nbsp;This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN402101 0421N-1	01/21/2014	01D01	SPS Verification	O	While performing an anti-mortem and humane handling check, I noticed that the cage washer machine was not operating at all. The cages were passing through the washing machine and coming out the same, dry as well as dirty. I immediately informed Mr. (B)(6), of my observation and notified him of the forthcoming noncompliance. Mr. (B)(6) assigned an employee to manually wash all the cages that were not washed. The cages were soiled with heavy lodes of fecal material
1325 7	P33900	NHH080101 4321N-1	01/21/2014	03J04	Poultry Zero Tolerance Verification	C	At 2140 hours on the night of production which began on 01/20/2014, while performing required PHIS Poultry Zero-Tolerance task at the designated Line #2 Pre-chill station at est. 33900 P, after randomly selecting 10 slaughtered and eviscerated and chilled chicken carcasses for the subgroup test and having begun the test at 2139 hours, Inspection found fecal material on the 3rd bird in the set. The fecal material was a dark green color and of a pasty consistency which would easily smear to the touch. It consisted of one piece 1/4" in diameter and 1/8" in thickness, located on the inside of the breast area (B)(6). (B)(6) was shown the carcass and he concurred that the material in question was indeed feces. Upon investigation, it was found that the cause of the fecal find was (B)(4). (B)(4) " Plant Management's Measure to prevent recurrence was (B)(4). " The requirements of 9CFR381.65(e) and 417.2(c)(4) were not met and Mr. (B)(6) was advised that the incident would be documented on a Noncompliance Record. Refer to NR #NHH5405010808N/1 dated 01/08/2014 for a similar Noncompliance. Plant Management's measure to prevent recurrence was: (B)(4). " To date all preventive measures may not have been implemented as described or were ineffective in preventing recurrence.
1325 7	P33900	NHH570501 5821N-1	01/21/2014	01D01	SPS Verification	C	On the night of production which began on 01/20/201 in est. 33900 P, Inspection was in Room 1 of Further Processing in est. 33900-P and found this Noncompliance: At 0359 Hours a 1/2-full Cardboard Combo of Wing Tips was found by the Leg Processor Machine with no identifying Label. The (B)(6) (B)(6) said that it was Inedible Product and was to be rendered. Inspection took Regulatory Control Action by applying US Retain Tag #B38075676 to the Combo until an Inedible Sticker was affixed. Inspection then released the Combo at 0407 Hours. Mr. (B)(6) was advised that a Non-compliance Record would be generated. The requirements of 9CFR416.3© were not met. Refer to NR #NHH2910114712N/1 dated 11/12/2013 for a similar noncompliance.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1823015 920N-1	01/20/2014	03J02	Slaughter HACCP	C	<p>On 01/20/2014 at approximately 1254Hrs, I observed that the establishment failed to perform the required 10 bird WIP (work in process) sample check per container prior to putting the reprocessed birds into the chilling tank.&nbsp;I observed a plant employee taking reprocessed whole body turkeys from the tank when the plants HACCP monitor and I were at the Quality Control table documenting our task.&nbsp;He was putting the birds onto the incline conveyor which was taking the turkeys into the chilling tank.&nbsp;I had observed the attached&nbsp;WIP red tag prior going to the Quality Control table. The WIP tag had now been removed from the tank.&nbsp;&nbsp;(B)(6) when&nbsp;ask her if she had performed the CCP 1B check and released the birds she said she had not. (B)(6) also had not performed the task. U.S. Retain Tag NO:B43241031 was applied to the tank of whole body turkeys which had&nbsp;not been inspected per HACCP Plan. (B)(6) was notified of the noncompliance. She questioned the employee and found that the employee had misunderstood instruction regarding the WIP birds. She took immediate corrective actions. She had all of the birds in the tank reconditioned bird by bird with (B)(4) water spraying. The whole body reprocessed birds were released back to production flow at approximately 1450Hrs after verifying the plants appropriate corrective actions and reinspection by&nbsp;Ms (B)(6). This observed incident of personnel not following the establishment's "Reprocessing Whole body Turkey's" WIP procedure is in violation to the Reprocessing Whole body turkeys HACCP Plan monitoring for CCP 1B. The in place CCP 1B is to comply with 9 CFR 381.65(e) zero tolerance for feces&nbsp;entering the chilling tank and also the plant's in place monitoring 9 CFR 417.2(c)(4). This noncompliance is being linked to noncompliance (#146) JDD4201114502N/1 dated 11/1/2013 for the same cause respectively.&nbsp;</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM001601 3220N-1	01/20/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	At approximately 1342 hours while performing HACCP task (the record review component of procedure for fully cooked-not shelf stable process), I observed the following noncompliance: Line (B)(6) while review the records of CCP-2B last check was made at 1338 hour all the entries were documented beside product description. I notified the (B)(6) and (B)(6) about the non-compliance. This does not meet the requirement of 9 CFR 417.5(a)(3) which states: "The establishment shall maintain: Records documenting the monitoring of CCPs and their critical limits, including the recording of the actual times, temperature, or other quantifiable values, as prescribed in the establishment's HACCP plan; the calibration of process-monitoring instruments; corrective actions, including all actions taken in response to a deviation; verification procedure and results; product code(s), product name or identity. Each of these records shall include the date the record was made". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.
5568	M20923	XUM302201 3820N-1	01/20/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	On 01/20/2014, at approximately 19:02 hours while performing a directed HACCP Review in response to a deficiency on the Palletizing Dept. Line (B)(6), I observed the following noncompliance: the metal detector kick out was overfilled causing the kick out platform to be stuck and remain in the open position. This condition caused all product to flow over the metal detector and product could not be rejected for possible metal contamination. The palletizing line operator failed to monitor the kick out box that was overfilled and caused the "Metal Detection Verification Procedure" to fail, a noncompliance per 9 CFR 417.5(a)(1). The establishment identifies metal contamination as reasonably not likely occur and controls metal hazards with the "Metal Detection Verification Procedure", however, this prerequisite program failed to identify possible metal detection due to the condition of the metal detectors kick out platform. This identified that the program is not effectively controlling the hazard and the establishment may not have adequate support for the decision made in its hazard analysis for that production lot. I took regulatory control by retaining two combo bins and 42 cases of Mini Corn Dogs product code 95038 with US Tag # 24829878. I showed and informed Mrs. (B)(6) of the forthcoming noncompliance. After corrective actions were performed by production, I relinquished the US Tag at 01:25 hours on 1/21/14. The requirements of 9 CFR 417.5(a)(1) and the establishment's Metal Detection Verification Procedure were not met.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN162101 4918N-1	01/18/2014	01D01	SPS Verification	C	On January 13, 2014, and January 16, 2014, during a recent follow-up visit, an EIAO observed insanitary conditions in the picking room. The drain below the paw cleaning/brush machine was clogged with skin and water was unable to drain. At the time of the observations, a pool of water filled with paw skins, bits of tissue and other debris was observed to be approximately 5' -6' in diameter and from 2-4" deep. At both occurrences, plant management was notified and corrective actions were immediately implemented. This is noncompliance with Title 9 CFR 416.1, 416.2(e)(4). QC was present at time of the observation and implemented immediate corrective actions. (B)(6) was informed of the noncompliance.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN222201 0318N-1	01/18/2014	01B02	Pre-Op SSOP Review and Observation	O	An EIAO observed the establishment Quality Assurance employees conduct pre-operational inspection as per the establishments written SSOP. After the QC had completed their pre-operational inspection and released the area for product, the EIAO observed the following: Evisceration January 16, 2014 Fat on the door to the control panel where the QC applies their lock out tag out locks. Non food contact. A feather inside the control panel where the QC applies their lock out tag out locks. Non food contact A large piece of fat on the drain cover by the PAC machine. Non food contact Unidentifiable foreign material brownish green with the appearance of fecal on a small gray hose above the steps into Inspection station 1 (non food contact) and blood on the hydraulic hose to the station lift (incidental food contact) Unidentifiable foreign material small black and flaky in appearance on the A&B line evisceration machine drain pan Non food contact Feather, skin and cartilage on the paw conveyor (after the paw chiller) Food contact Fat and feathers on the Line B IOBW Food Contact Packaging January 16, 2014 Fat on the side of the (B)(4) dip tank. Non food contact. Pipe tape hanging from the junction of the hose to the tank non food contact. Tissue adhered to the plastic belt guide food contact. Fat on the tank exit frame non food contact. Fat and meat residue on the control panel/ electrical box non food contact A piece of fat on the roth line dark meat (b)(4) non food contact Fillet January 17, 2014 Fat and tissue dried to the side of the East Ice hopper non food contact. Meat residue on the bottom of the conveyor non food contact. Fat inside the Westside Incline Coveyor food contact Large piece of fat on the chute adjacent to the Westside Incline Conveyor Hard dark round piece of unidentifiable foreign material with the appearance of metal on Breast Processor 16, non food contact A piece of meat and fat on the Organic incline conveyor that is adjacent to the Front Half Delivery System Establishment had not run Organic material for "several months" according to plant manager. Fat on plastic 'cog' food contact. Large piece of meat in white buckets, food contact Unidentifiable Foreign Material with the appearance of black grease and fat on removable cutting boards. food contact. This describes noncompliance with Title 9 CFR 416.4(a), 416.4(b) and 416.13(c). The establishment took immediate corrective actions.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN262101 4418N-1	01/18/2014	01D01	SPS Verification	O	<p>On January 16, 2014, during a recent follow-up visit, an EIAO observed floors throughout the establishment in both production and non production areas exhibit pits, divots, holes, exposed aggregate, scratches and areas where steel rods are inserted through the floor, but are not readily cleanable. Holes range from approximately 1" to 2' in diameter and approximately 1/2" to 2" deep and contain dark water and solids at all times, including at pre-op. Sections of the floor in Fillet and Packaging have holes running under a layer of sealant, that when stepped on allow fluid that was trapped under the sealant to come out. The floor wall junctions throughout the facility exhibit cracks, standing water and are not readily cleanable. The walls throughout the establishment appear to have dirt and product residue adhered to the surface. The sections of wall constructed of white FRP are beige in appearance, and some areas exhibit black residue that is removable with gentle hand pressure. Further, there are numerous areas of the wall that exhibit rust. Throughout the establishment, there are areas of caulking that are peeling away from the wall, creating potential for pest harborage, and creating conditions that are not readily cleanable. Further, there is a section of the floor in evisceration that exhibits unidentified foreign material green in color with the appearance of algae. This is noncompliant with Title 9 CFR 416.2(b)(2). EIAO notified (B)(6) of the findings.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN452201 2818N-1	01/18/2014	01D01	SPS Verification	O	<p>On January 16, 2014, and January 17, 2014, an EIAO performed Employee / Employee Equipment Inspection (all items listed are food contact) with the QC representative present. 3 steels taken out of production due to rust, rough welds that are not readily cleanable with &nbsp;holes in the handles. 8 steels had loose blue plastic stuck at the point where the metal of the steel is encased on the plastic of the handle. Production Supervisor and QCs removed the plastic prior to production. 4 knives had tissue adhered to the blade, or between the blade and theommel. 2 knives had loose blue plastic adhered between the blade and theommel. 3 cut gloves had tissue and fat stuck in between the links. Additionally, the floor of the evisceration, Packaging and Fillet areas was littered with several pieces of fat, meat and sinew.&nbsp; This describes noncompliance with Title 9 CFR 416.1, 416.3(a). During a recent follow up visit from January 13, 2014, through January 18, 2014, an EIAO observed the following: A gap approximately 2-3" at the maintenance door Gaps at the base of the roll up door from 2-4" in the Picker room Gaps at the base of the doors leading into Live hang The doors to the outside in the auxiliary rooms off of the Fillet room are not maintained to prevent the entrance of vermin as they are locked open with a gap at the base of the doors Gaps at the base of the air vent in the boiler room ranging from 1" to 4" high and 2" to 1' long. This is noncompliant with Title 9 CFR 416.2(a) and 416.2(b)(3). Plant management was notified of the findings. On January 16, 2014, EIAO and FLS entered into the New Product Rooms and noted a foul putrid odor. The odor was identified as coming from the floor drain near the exit side of the Rotisserie area. Plant management including the Plant Manager, were present and observed the odor. Further, on January 15, 2014, EIAO entered into the Picking room to observe a QC check. The Picking room had a strong foul odor and was filled with steam to the extent that visibility was severely limited, creating potential safety concerns. Your establishment failed to provide ventilation adequate to control odors and vapors. This is noncompliant with Title 9 CFR 416.2(d). Plant management took immediate corrective actions.</p>
5112	M18909	JDD1208013 317N-1	01/17/2014	01D01	SPS Verification	C	<p>In Evisceration 01/09/2014, around 0845 I stopped both lines due to the water refuse drainage canal under the lines was full and overflowing into traffic pattern areas. Downtime about six minutes&nbsp;on the&nbsp;canal to drain and resanitize areas on both sides of the line.&nbsp;Ms (B)(6), Mr. (B)(6), (B)(6), (B)(6), and Mr. (B)(6) were notified of the noncompliance. This is a violation of the above 9 CFR's.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2414012 218N-1	01/17/2014	03J02	Slaughter HACCP	C	<p>On 01/17/2014 at approximately 2013Hrs, I found the plant failed to meet the established Boning Room CCP 5B requirement of (b) (4) [REDACTED]. Using a company calibrated thermometer, I performed a physical verification check of the Heavy Tom Turkey Breast meat which was on the New Shipping dock. My findings were 50F, 48F, 50F & 48F, 46F, 40F. U.S. Retain Tag NO's: B43241029 & B43241030 were attached to the two tank's, containing Tom Turkey Brst 1, boneless, skinless without flt, with temperatures above 45F. The plant's Boning Room scan tags# T001913263 & T001912937&nbsp;showed the tanks leaving the Boning Room at 14:01Hrs and 12:00Hrs on kill date 01/17/2014. (B)(6) [REDACTED] was notified of the noncompliance and showed the temperatures above 45F. Mr.(B)(6) [REDACTED] chose to add more CO2 and put the affected breast meat into the P-157 blast (B)(6) [REDACTED]. was notified and verified the temperatures above 45F. He also applied his Quality Control retain tags. The total affected product was 2918 pounds (B)(7)(C) [REDACTED], CSI verified&nbsp;all sites of the product was below 45F at 0842Hrs on 01/18/2014. The establishment chose to run the University of Wisconsin PMP calculation and it showed no Salmonella outgrowth using the 1401Hrs & 1200Hrs found on 01/17/14 to 0030Hrs on 01/18/14 when product was 39F, per plant Q.C. record.&nbsp;The product was released back to shipping at 1620Hrs on 01/20/2014 after verifying the plant's corrective actions. The establishment has Salmonella Initiative Program (SIP), a waiver to 9 CFR 381.66(b). This waiver allows the establishment chill whole birds/parts to 45F in 8Hrs from slaughter. This observed incident of product temperatures above 45F exceeding the 8Hrs from slaughter is in violation to the plant's HACCP Plan at the Boning Department monitoring of CCP 5B which states in part; "(B)(4) [REDACTED]". The plants CCP 5B established company critical limit which states; "(B)(4) [REDACTED]", was not sufficient in preventing temperatures above 45F. This noncompliance is being linked to noncompliance (#150) JDD5910114705N/1 dated 11/4/2013 for the same cause respectively.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4508012 717N-1	01/17/2014	01D01	SPS Verification	C	On 01/14/2014 in the Old Shipping Dock around 0130HPST, I observed a stainless steel tank with a 1/2 inch crack in the corner with readily visible product residue in it. I informed Mr. (B)(6), of this issue. He indicated one of his people would take care of it. I waited until after PRE-OP was over and rechecked on it. It was missed and I tagged it, U.S. Reject Tag # B43241104. I then notified Ms. (B)(6) of it and it was taken to shop for repair. Later in the day, Ms. (B)(7)(C), C.S.I. released the Tag. This is a violation of the above 9 CFR's.
6036	P6164A	OIJ4601011 718N-1	01/17/2014	04A06	Poultry Finished Product Standards	C	On January 17, 2014 I, CSI (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is 40 points. My test at 2251 resulted in 42 points. At approximately 2320 a retest was performed by (B)(6) using a tighten criteria of 25 points which failed with 30 points. I verbally notified (B)(6) of the noncompliance and that I would be issuing a NR. The plant implemented the required procedures for FPS failure. The Prechill nonconformances I observed at 2251 were: 3 ingesta < 1/16" (3 pts), 5 partial oil glands (5 pts), 4 partial lungs (4 pts), 8 whole lungs (16 pts), 1 partial crop (2 pts), 1 trachea > 1" (2 pts), 2 small feathers (2 pts), 4 large feathers (4 pts), and 2 long hocks (4 pts). On December 12, 2013, NR # OIJ3913124612N (#85) was issued for processing noncompliance. The written response given that Maintenance made adjustments to bring the process under control were not effective to prevent recurrence. This noncompliance is linked to NR # OIJ3913124612N (#85) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the December 19, 2013 meeting.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN042201 3016N-1	01/16/2014	01D01	SPS Verification	C	On January 16, 2014 at approximately 1550 hours while walking through Raw Side Cooler #2, I observed noncompliance with SPS Regulatory Requirement(s) 416.1 and 416.4(d).Raw Side Cooler #2: I observed beaded condensation along the overhead stainless steel strip next to the overhead refrigeration unit and also on the overhead entrance door to cooler #2 (product traffic area). I informed and showed Mr. (B)(6) and Mr (B)(6) , the noncompliance. At the time of my observation I did not see any condensation dripping and the product staged in the cooler was completely covered.Immediate corrective action was implemented by Mr.(B)(6) by having the overhead structures wiped down and monitoring the condensation for the rest of the shift. Sanitary conditions was restored at 1605 hours. This does not comply with Regulatory Requirement(s) 416.1 which states in part: Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure product is not adulterated", and 416.4(d) which states in part: "Product must be protected during storage".This noncompliance is linked to NR#LQN4803115908N/1 dated 11/8/13, for a similar noncompliance on condensation in the coolers. This document serves as written notification that continue failure to comply with regulatory requirement(s) 9 CFR Part 416 could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.
5112	M18909	JDD5722013 015N-1	01/15/2014	01D01	SPS Verification	C	On 01/15/2014 at approximately 1300Hrs while performing ante-mortem inspection task, I observed a noncompliance to 9 CFR 381.95(c). I observed 4 clean; edible, clear plastic lined combo bins containing edible foods products. The product filled the combo bins and no red color consistent with an application of visible denaturant was present on any of the food products in the combo bins. The chicken and turkey food products (breasts, paws, fillets, thigh, whole body birds and ground products) were outside near the plants condemn dump truck. All of the bins plastic liner were open with the food products exposed. The exposed food products had written on the bins PC- 1/13/14. The products appeared to have been frozen in boxes prior to being put into the combo bins. (B)(6) was notified of the noncompliance and shown the edible food products with no denaturant. Ms.(B)(6) found a plant employee who had noticed the bins of food product at approximately 0200Hrs. At approximately 1312Hrs the product was released after verifying the plants implemented corrective actions and the liberal denaturizing which was applied in my presence.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM571401 2415N-1	01/15/2014	01D01	SPS Verification	C	This morning approximately at 0745 hours, while performing PHIS routine SPS task (Other Inspection Requirements/ Facilities and Equipment Standard), the following noncompliance was observed: Line 1, Cook side of the establishment (b)(4) transfer belt metal cover has crack on one of the corner. I informed (B)(6) of the non-compliance. Immediately the part was revoved and sends it to the maintenance shop for repair. Poorly maintained facilities and equipment can and do harbor food borne pathogens, which can then multiply and be dispersed throughout the food processing environment increasing the chances of product contamination which can render product adulterated. 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that the product is not adulterated". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.
5129	M210	LQN240201 0814N-1	01/14/2014	01D01	SPS Verification	C	On January 13, 2014 at approximately 1440 hours, I observed noncompliance with SPS regulatory requirement(s) 416.1, 416.4(d).Cook Side Film Room: I observed one roll of tan color plastic liners (food contact) with part of the roll laying directly on the floor. The tan color plastic is used to line the bins and tanks that edible product comes in contact with. U.S. Reject Tag NO. B38934386 was applied to the roll of plastic liners. Ms. (B)(6) was informed and showed the noncompliance. Ms. (B)(6) was also informed. Immediate corrective action was implemented by management : Ms. (B)(6) removed all of the plastic liners that was in contact with the floor and disposed into the trash. The rest of the plastic liners was properly wrap up. After sanitary conditions were restored U.S. Reject Tag NO. B38934386 was removed.This does not comply with Regulation 416.1; which states in part: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated".This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3123010 513N-1	01/13/2014	01D01	SPS Verification	C	On 01/13/2014 at approximately 1315Hrs, I was notified by Dr. (B)(7)(C), SPHV that Ms. (B)(6) and Ms. (B)(6), food inspectors, had just observed a live cock roach inside the U.S.D.A. break room. They saw the roach moving on the wall above the break table. The wall is connected to the plant's entry hallway. They called out as they tried to terminate the roach using a paper towel roll. Dr. (B)(7)(C) was near by and he was able to terminated the live cock roach when it landed on the table. (B)(6) was notified of the noncompliance and showed the terminated cock roach. The roach was removed and the table was sanitized. She notified plant management. This observed incident of a live cock roach inside the establishment's break room is in violation to 9 CFR 416.2(a) Grounds and Pest Control and 9 CFR 416.2(b)(3) walls/floors/ceilings constructed to prevent entrance of vermin. The establishment does have in place a outside pest management service.
5568	M20923	XUM251601 4013N-1	01/13/2014	01D01	SPS Verification	C	This morning approximately at 1410 hours, while performing PHIS routine SPS task (Other Inspection Requirements/ Facilities and Equipment Standard), the following noncompliance was observed: Line 2, Cook side of the establishment one of the electrical motor of MFG conveyor belt is very rusty. I informed (B)(6) and (B)(6) of the non-compliance. Poorly maintained facilities and equipment can and do harbor food borne pathogens, which can then multiply and be dispersed throughout the food processing environment increasing the chances of product contamination which can render product adulterated. 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that the product is not adulterated". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM302301 4613N-1	01/13/2014	01C01	Operational SSOP Record Review	C	<p>On 1/13/2104, at approximately 2025 hours, while performing a directed SSOP Record Review inspection task in response to a deficiency in the QC Lab, I observed the following noncompliance: while reviewing the SSOP Monitoring Log dated 1/10/14 Shift 1, Part&nbsp;2 Operational Sanitation, Section 1 Raw Products, there was a response in the Comments Corrective portion of the Monitoring Log complete by QC employee with the initial's NX. The response stated, (B)(4)</p> <p>. I noticed that there was no condemn&nbsp;report attached to the SSOP form. This is a procedure that the establishment performs to show&nbsp;when product has been condemned for various reasons at the plant. I inquired with the night shift QC Dept. and the Production Management on the status of the 40 lbs of QC retained product.&nbsp;I was informed that no condemn report had been completed&nbsp;for the 40 lbs of exposed 95507&nbsp;Turkey Ground Meat product identified on the SSOP Monitoring Log and the status of the retained product was unknown, a noncompliance per 9 CFR 416.15(b) and&nbsp;416.16(a). I showed and informed Mr. (B)(6) of the forthcoming noncompliance. The requirement of 9 CFR 416.15(b), 416.16(a) and the establishment's SSOP Plan Part 2, Section 1, Implementation and Monitoring #3 were not met.</p>
5308	M6137	BXL3104010 912N-1	01/12/2014	01B02	Pre-Op SSOP Review and Observation	C	<p>On 01/10/2014 at approximately 2230 hours while monitoring Pre-Operational Sanitation standards in Plant 2, I observed the following. There was varying amounts of black UFM(Unidentified Foreign Material) that smeared like grease &nbsp;on the shackles and&nbsp;guide bars&nbsp;above the inflow section of the scalders for kill line. The shackles were cleaned with green pads and paper towels.&nbsp;The area&nbsp;was released by approximately 2257 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) and 9 CFR 416.13(c).&nbsp;&nbsp;</p>
5308	M6137	BXL5704014 912N-1	01/12/2014	01C02	Operational SSOP Review and Observation	C	<p>On 01/08/2014 at approximately 0115 hours whole monitoring Pre-Chill Finished Product Standards on line in Plant 2, I observed the following. After taking a standard 10 bird sample there was a piece of shiny metal measuring approximately 5mm by 3mm by 2mm attached to the connective tissue in the neck area of a carcass. I informed (B)(6). According to PDD, FSIS&nbsp;considers metal of any size on a carcass to be an unacceptable contaminant that should be addressed by the establishments' Hazard Analysis.&nbsp;The establishment has no metal detectors. The issue of metal contamination has been discussed at previous morning meetings with the establishment. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1815010 511N-1	01/11/2014	01B02	Pre-Op SSOP Review and Observation	O	On 01/11/14 at approximately 0840 Hours while performing pre-operational sanitation verification in the Packaging Department with CSI (B)(7)(C), Dr. (B)(7)(C) observed the stainless steel product shoot lid at the end line (B)(4) having a cracked and broken hinge on one end. Regulatory control action was taken by applying U.S. Reject tag #B 39930856 to Line (B)(4) and informing (B)(6) and (B)(6) of the noncompliance to 9CFR 416.2(b)(1) regulatory control was relinquished at approximately 0920 Hours after lid and hinge were removed and area was cleaned and sanitized.
5308	M6137	BXL2517010 111N-1	01/11/2014	03J04	Poultry Zero Tolerance Verification	C	On 01/11/2014 at approximately 1444 hours, while performing the Zero Tolerance Task on Line (B)(4), I found visible fecal contamination on one of the ten birds I randomly removed. The fecal was located on the top side of the tail by the vent area. The fecal material measured approximately 1/8" in diameter in size, olive green in color and pasty in texture. This exceeds the limit of Zero Tolerance for the process to be in control. I informed (B)(6) of the noncompliance and the protocol for fecal failure was implemented. Quality Control performed the recheck at approximately 1513 hours and passed, bringing the process back into control.My findings indicate a noncompliance with 9CFR 381.65(e), 9CFR 417.2(c)(4), and the critical limit of CCP2B, (B)(4) of the Plant's HACCP Plan for Slaughter.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ0218014 611N-1	01/11/2014	06D02	Other Inspection Requirements	C	<p>At approximately 2148 on 01-10-14, I, CS (B)(7)(C) performed the missing viscera test component of the regularly scheduled Other Inspection Requirements task. The maximum allowed missing viscera at the line speed of (B)(4) is (B)(6) and I observed 14. (B)(6) witnessed the test and I verbally informed her of the failed test results. At approximately 2210, I performed the retest for missing viscera and I observed 17 (B)(6). (B)(6) Swing Shift witnessed the retest. I immediately notified him of the failed test results, that I was taking the regulatory control action of slowing the line to (B)(4) as per (b) (4) requirements, and that a NR would be issued to document the noncompliance. At approximately 2216, I performed a missing viscera retest requested by (B)(6) to verify process control at the line speed of (B)(4). The maximum allowed missing viscera at the line speed of (B)(4) is (B)(6) and I observed 6. The line speed was increased to (B)(4). At approximately 2258, I performed the missing viscera test to verify process control at the line speed of (B)(4) and I observed 8. This NR is linked to NR # OIJ401114109N issued on swing shift, 11-08-13. Including this NR, there have been four linked Other Inspection Requirements NRs issued in the last 90 days for the same root cause. Maintenance adjustments in response to previous Other Inspection Requirements NRs were not effective in preventing this NR. Other Inspection Requirements NRs were most recently discussed and documented during a weekly Establishment Awareness Meeting on 11-21-13.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM372301 2910N-1	01/10/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	On 1/10/2014, at approximately 1600 hours, while performing a routine scheduled HACCP Record Review inspection task in the QC Managers Office, I observed the following noncompliance: In the Fully Cooked Shelf Stable Whole Muscle / Diced Stripped Product hazard analysis the establishment identifies "Allergens" as a chemical hazard not reasonably likely to occur at the following steps in the hazard analysis; "Glaze Mix and Pre-Mixed" and "Glaze Mixing". The establishment implements a "Corporate Allergen Control Program" prerequisite program, which maintains that allergenic ingredients are identified and controlled were they are introduced into the process that the hazard is not reasonably likely to occur. However, the establishment does not identify "Allergens" as a hazard, at all applicable steps in the hazard analysis. The establishment failed to identify "Allergens" at the following steps; "Pro Grill", "Cooking", "Dicing / Slicing", "Cooling and Freezing", "Scaling and Packaging", and "WIP product in combo / labeling". Allergenic ingredients are utilized at these steps in the process. Failing to identify all hazards at those steps does not comply with 417.2(a)(1) and also the failure to document the prerequisite program that prevents the hazard of undeclared allergens through cross contamination or mislabeling at the steps described does not comply with 417.5(a)(1) by not supporting the decisions that allergens are not reasonably likely to occur at those steps. The requirements of Title 9 CFR 417.2(a)(1), 417.5(a)(1) and the establishment's "Corporate Allergen Control Program" were not met.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA300901 0809N-1	01/09/2014	01D01	SPS Verification	O	<p>While performing a Sanitation Performance Standard Inspection in the establishment's Raw processing department the following noncompliance were observed: 1. At approximately 0426 hours in the raw/cook side transfer holding cooler there were 2 full pallets of cheddar cheese product stored slightly under the overhead air unit. The top row of boxes were observed with some heavily covered unidentifiable black gradual looking material and drip of clear liquid randomly scattered over the top portion of all the boxes in areas to numerous to count. The liquid and unidentifiable material appeared to have come from the air unit. Some (approx. 5) of the boxes of product were slightly opened. The palletized containers of product did not have any cardboard box slips protector or other materials on the top of the boxes to protect the containers from foreign elements. Further investigation confirmed that no product contamination was involved. (B)(6) was immediately notified. No retain tag was applied because immediate corrective actions were taken by the establishment. 2. At approximately 0431 hours in the raw storage cooler I observed 4 combos of "Low fat Chicken Product" with the date 01/04/14 stored directly under the 2 air units (2 combos under each unit). I observed some clear liquid (that appeared to be condensate) that was falling from the each air units directly onto the blue plastic cover that was over the product. Further investigation confirmed that no product contamination was involved. The ceiling of the raw storage cooler had heavy liquid condensation build up over approximately 1/3 of the area. (B)(6) was immediately notified. No retain tag was applied because immediate corrective actions were taken by the establishment. -Raw (B)(6) was later notified of all the noncompliance and he assisted with the corrective measures. -The observed conditions did not meet the requirements of 9 CFR 416.1/Sanitation Performance Standards General Rule, 9 CFR 416.4(d)/Preventing insanitary conditions where product is storage, 9CFR 416.4(b)/Non food contact surfaces cleaning and 9 CFR 416.2(d)/Ventilation. -This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).</p>
5112	M18909	JDD3206015 313N-1	01/09/2014	01D01	SPS Verification	O	byg76y

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM061201 0209N-1	01/09/2014	01B02	Pre-Op SSOP Review and Observation	C	At approximately 0705 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 1, Cook side of the establishment: I found piece of chicken stuck on ishida scale bracket from the previous day of production. Upon continuing my inspection Line 1 (b)(4) transfer blue belt one of the bar underneath has few food particles also from the previous day of production. I took a regulatory control action and applied USDA retain/rejected tag# B24829883. I informed (B)(6) and (B)(6) and of the non-compliance. The finding described in the non-compliance was on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0745 hours. Plant SSOP Section1, page1, states: (B)(4) . 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.
5568	M20923	XUM322201 2709N-1	01/09/2014	01D01	SPS Verification	C	On 1/09/2014, at approximately 1928 hours, while performing a directed Sanitation Performance Standards (SPS) inspection task in response to a deficiency, I observed the following noncompliance: several cobb webs on the ceiling overhead exhaust fan cover in the Compacter Room of the Raw Area creating insanitary conditions, a noncompliance per 9 CFR 416.1 and 416.2(b)(3). I took regulatory control by rejecting the area with US Tag # 24829912. I showed and informed Mr. (B)(6) of the forthcoming noncompliance. After corrective actions were performed by production and sanitary conditions were concerned, I relinquished the US Tag at 2005 hours. The requirements of 9 CFR 416.1 and 416.2(b)(3) were not met.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA121401 0508N-1	01/08/2014	01C02	Operational SSOP Review and Observation	O	<p>On 01/08/14, while performing a Sanitation Performance Standard Inspection of the box rooms and shipping department to assure all product, equipment and product package containers were properly stored, I found the following noncompliance. 1. At approximately 0845 hours, I observed a pallet of partially covered and unprotected premade brown boxes, stacked approximately 7 rows high (to numerous to count) of the same unassembled box containers. These premade box containers have been observed in use in the packing area for direct handling/contact by the packing employees immediately before packing the ready to eat product. The pallet of premade boxes were partially (approx. 15-20) uncovered (exposed) with the possibility of being affected by foreign materials in the box room/shipping area (e.g. dust, fumes, hair, wood chips and etc.). The box room area is not required by the establishment GMPs for employees to wear hair covers/nets, or special footwear. The box room area is also used for continuous transporting of garbage/trash, chemicals, maintenance equipment, wood pallets, and pallet jacks and etc. The box room is an entrance point for the some employees from the outside (before covering the hair or changing footwear or garments). The conditions that the premade boxes were being handled and stored did not meet the requirements of 9 CFR 416.4(d). Employees (b) (6) was initially notified and (B)(6) was later notified and observed the pallet of boxes. No product contamination was observed. No regulatory control tag was applied because Employee (b) (6) took immediate corrective actions as instructed by the supervisor. 2. At approximately 0851 hours while inspecting the cook side dry ingredient storage cooler, I observed a pallet of dry ingredients (whole grain batter) that had one busted bag of product that had spilled onto the floor and frame of the storage shelf. The opening in the bag of product appeared to be approx. 4 to 5 inches in circumference and the opening in the bag left the product exposed. (B)(6) was notified. No tag was applied because I observed as immediate corrective action was taken by the establishment. -A similar noncompliance was observed on 09/17/13 and documented on NR #AOA3213091217N/1. The previous written further planned action that was provided by the establishment on 11/13/13 that states, (B)(4)</p> <p>appeared to be ineffective in preventing this noncompliance. -Continued failure to meet regulatory requirements can lead to enforcement actions described in 9 CFR 500.4.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2008014 008N-1	01/08/2014	01D01	SPS Verification	O	On 01/08/2014 at approximately 0350 hours, Line Food Inspector (B)(7)(C) observed a live cockroach when he was washing his gloves in the sink that it's located in Line 2 behind station #7 in Plant #1 during his USDA break time. The cockroach was running away from the sink. Food Inspector (b)(7)(C) caught the cockroach and contacted CSI (B)(7)(C). I informed (B)(6) and (B)(6) his finding. Cockroaches are carriers of bacterial contamination and disease which can spread to exposed product, and creates an insanitary condition. The sink was washed with potable water. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2 (a).
5310	M6137B	FFA2122010 908N-1	01/08/2014	01C02	Operational SSOP Review and Observation	C	On January 8, 2014 at approximately 1855 hours while performing my operational sanitation inspection in the Raw Side Blending/Rework area I observed noncompliance with SSOP Regulatory Requirement 416.13(c), and SPS 416.1, 416.4(d). I observed several small pieces of blue plastic casing on the re-work chicken franks product code 11005 dated 01/07/14. The chicken franks had already been cleaned and put into a clean cardboard bin ready to be used. U.S. Retain Tag NO. B34377425 was applied to this bin of Chicken Franks. Mr. (B)(6) was informed and showed the noncompliance and Ms. (B)(6) was also informed. At 2105 hours after the Re-work product was re-cleaned, and re-inspected U.S. Retain Tag NO. B34377425 was removed and product was released. This does not comply with Regulatory Requirement 416.1; which states in part: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated", 416.4(d); which states in part: "Product must be protected from adulteration during processing, handling, storage, loading, and unloading", and 416.13(c), which states in part: "Each official establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". This noncompliance report serves as written notification that failure to comply with regulatory requirement(s) of 9 CFR 416 could result in additional regulatory or administrative actions.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH540501 0808N-1	01/08/2014	03J02	Slaughter HACCP	C	<p>&nbsp;On the night shift that began on 01/07/2014, at approximately 0401 Hours, I was in the Evisceration Department, line #2, to perform Finish product Standards Verification for pre-chill standards.&nbsp; &nbsp; I randomly selected 10 carcasses at a collection point after the inside/outside rinse cabinet, designated by the Establishment as the point to collect carcasses for this procedure.&nbsp; There are no further interventions by the Establishment beyond this point.&nbsp; &nbsp; On the first carcass that I inspected, I observed a substance inside carcass, in the kidney area that appeared to be fecal material.&nbsp; I summoned Mr. (B)(6) and he agreed that the material was feces.&nbsp; The feces was approximately 1/16 inch in diameter to 1/8 inch in diameter and numbered 3 specks. The feces was brownish tan to dark brown in color and greasy to the touch.&nbsp; The material smeared easily to the touch. &nbsp; At approximately 0000 Hours I was informed that the cause of the deviation was investigated and found to be, (B)(4) " &nbsp; The preventive measure given was, (B)(4) &nbsp; &nbsp; The requirements of Regulations 381.65(e) and 417.2(c)(4) were not being met. &nbsp; Refer to NR#NHH3204011807N / 1, dated 07/07/2014, for similar non – compliance. &nbsp; All measures taken by the establishment to prevent recurrence to date have been ineffective or may not have been implemented properly.&nbsp; &nbsp;</p>
1326 1	M33901	HAY070301 3909N-1	01/08/2014	03G02	Fully Cooked-Not Shelf Stable HACCP	C	<p>On the calendar date of January 8, 2014 at approximately 2210 hours while performing the Fully Cooked, Not Shelf Stable HACCP task, the following noncompliance was observed: I, CSI (B)(7)(C), reviewed the HACCP records generated on the previous days operations, 1/7/2014. The records included the results of the monitoring and verification procedures at the CCP's, the initials of the person who made the entries, and the time in which the entries were made. The records also show that product temperatures were monitored after midnight and the results are acceptable, as the temperatures met the critical limits prescribed in the HACCP plan. The results recorded after midnight were actually entered on 1/8/14. However, the "DATE" section of the record only contains "1/7/14, which indicates that all entries were made on the date of 1/7/14. Please be advised that records generated under the Raw, Intact HACCP Plan&nbsp;for the date of 1/7/14, which are recorded on the Individually Frozen In-Process Temperature Monitoring Log, also show entries made after midnight but the person(s) making the entries failed to record the date of 1/8/14 next to the entries. (B)(6) , was shown the noncompliance and she&nbsp;confirmed the findings. Ms. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3010012 407N-1	01/07/2014	01B02	Pre-Op SSOP Review and Observation	C	In Tray Pack 01/07/2014 during PRE-OP I observed poultry residue on center line product contact zone and the Pink UFM noted in the Q. C. Leaker Check Apparatus. This was pointed out to Mr. (B)(6) and Mr. (B)(6). This is a violation of the Establishment's written SSOP program and the following above 9 CFR's.. This is linked to NR 176-2013, Dated 12/14/2013, JDD0310124414N/1 and its Three Associated Links.
5308	M6137	BXL3808015 307N-1	01/07/2014	01D01	SPS Verification	O	On 01/07/2014 at approximately 0458 hours, Line Food Inspector (B)(7)(C) observed a live juvenile cockroach when she was working on Line 1 on station #4 in Plant #1. The cockroach was crawling on the gray plastic tub that the company used to save the wings from the trimming. The tub was empty and turned upside down because it was almost company break time. Food Inspector (B)(7)(C) caught the cockroach and contacted CSI (B)(7)(C). I informed (B)(6) and (B)(6) of her finding. Cockroaches are carriers of bacterial contamination and disease which can spread to exposed product, and creates an insanitary condition. The area was washed with potable water. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2 (a).
5310	M6137B	FFA0416013 507N-1	01/07/2014	01D01	SPS Verification	C	On January 7, 2014 while walking through the cooking area, I observed noncompliance with SPS regulatory requirement(s) 416.1, 416.2(d) and 416.4(b). At approximately 11:35 hours I observed beaded dripping condensation on the bottom side of the gray beams and iron rails between oven #3 and the (B)(4) chiller area no product was affected. I informed and showed (B)(6) and (B)(6) the noncompliance. They had an employee wipe down the condensation in my presence. This NR represents SPS noncompliance of the regulations cited above; as well as written notification that failure to comply with regulatory requirement(s) may result in additional regulatory or administrative action as described in 9 CFR 500.4. This NR is link to NR #FFA0216125111 Dated 12/11/2013 for a similar noncompliance.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH211301 3607N-1	01/07/2014	01D01	SPS Verification	C	On 01/07/2014 at approximately 1145 hours while performing an SPS task in the paw room/giblet chiller area, I observed that water from the top of the ice machine chute was splashing onto the ceiling and other overhead structures and dripping onto covered plastic totes used for product; water was also dripping from overhead structures onto the floor adjacent to an ice bin containing potable ice. The outside surface of the exit end of the neck chiller was also insanitary and contained numerous fat particles and brown grease; a section of the outside surface of the neck chiller contained an area of rust approximately 10-12 inches in diameter. Adjacent glycol pipes attached to the neck chiller had extensive rust and a brown greasy substance along 24 and 30 inch sections of the pipes. Additionally, there was a 12-18 inch crack in the plastic insulation around a large pipe at the end of the neck chiller; the exposed surface of the pipe contained extensive rust and a brown/black greasy substance. USDA Reject/Retain tag # B38075651 was assigned to these deficiencies. I advised Mr. (B)(6) of these issues and that a Non-compliance Record would be issued. There was no product contamination involved with this non-compliance. The establishment did not meet the regulation requirements of CFR9 416.1, CFR9 416.2(b)(1), and CFR9 416.2(b)(2), which states that the establishment will operate in a manner to prevent insanitary conditions and in good repair.
1325 7	P33900	NHH320401 1807N-1	01/07/2014	03J04	Poultry Zero Tolerance Verification	C	On the night of production that began on January 6, 2014, at approximately 0345 hours while performing a Poultry Zero Tolerance task at the evisceration line 2 pre-chill station, I found feces inside the third bird of a ten bird set. The feces was located on the inner ventral surface of the bird's abdominal cavity at the level of the keel. The feces was approximately 1/8 inch by 1/8 inch, was pasty in texture, and was dark green in color. (B)(6) was shown the carcass. (B)(6) informed me that the cause of the fecal failure was a broken shackle guide in the inside-outside bird washer. The establishment's measure to prevent recurrence was to replace the broken shackle guide. The establishment did not meet the regulatory requirements of 9 CFR 381.65(e) and 9 CFR 417.2(c)(4). Refer to NR #NHH0200014502N written on December 31, 2013, for a similar noncompliance.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH240801 0006N-1	01/06/2014	01C02	Operational SSOP Review and Observation	C	<p>#3-14 At approximately 0718 while performing an operational sanitation observation and review task in the further processing areas I observed insanitary conditions in the thigh deboning/roastisserie department of room two. I observed whole thighs, fat and debris, and thigh trimmings along the wall, along the thigh deboning line and in the traffic area between thigh and roastisserie pack out conveyors. There was a massive pile of bones in the area thigh bones exit the deboning machine. The work area was totally congested with hardly any space to allow for wash down or cleanup of any sort while employees are working on the line. The requirements of 416.11 and the establishment's SSOP plan which requires (B)(4) . The line lead was notified and US tag #B38075641 was assigned to the noncompliance. The employees were removed from the line so that the floor area and stands could be washed to an area where the water and debris could drain properly. The line was released after sanitary conditions were restored. The same noncompliance was cited on 12/12/2013 and Management's response was that floor man will rinse the floor before leaving the production area. Employees were informed to push debris that is under the line to the wall and maneuver into a larger drain. Any efforts to do so either were unaccomplished or have been ineffective. Another noncompliance observed were insanitary conditions while wearing and storing aprons. In room one I observed two plastic hanging on the floor rack with the ties touching the floor. (B)(6) was notified. In room two the was one plastic smock hanging with the ties touching the floor. Another employee was observed walking to her work area with the garment untied allowing the ties drag over the floor. The establishment SSOP states that (B)(4) These requirements are not being met. The same noncompliance was cited on 12/19/2013 and efforts to prevent the recurrence of this noncompliance has been unsuccessful.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH450201 0006N-1	01/06/2014	04A06	Poultry Finished Product Standards	C	<p>2335 hours-01/05/2014-04C04-Chiller room, Line #2 exit end of chill system. &nbsp; On the night shift that began on 01/05/2014, at approximately 2318 hours, I monitored Procedure 04C04 (Finished Product standards for carcasses exiting the chill system).&nbsp; &nbsp;The test was being performed by (B)(6) on production line #2. On the initial test a score of 27 was obtained.&nbsp; This is 17 points above what is allowed for this test.&nbsp; Mr. (B)(6) performed a Verification check at 2326 hours with a result of 22.&nbsp; Action test at 2329 received a score of 11.&nbsp; &nbsp; Mr.(B)(6) informed the (B)(6) that the line was not in compliance and that the product needed to be retained for rework.&nbsp; For approximately four minutes Mr. (B)(6) and I observed product entering the room from the non-compliant line and being hung on the production line along with product from line #1.&nbsp; Mr.(B)(6) attempted to have the noncompliant product diverted from this line for approximately four and a half minutes before being successful.&nbsp; During this time product that was not eligible for production was being mixed with eligible product.&nbsp; &nbsp; (B)(6) was informed of the noncompliance, and he over saw the collection and retention of the product. &nbsp; &nbsp;</p>
1325 7	P33900	NHH010101 4504N-1	01/04/2014	01C02	Operational SSOP Review and Observation	C	<p>On the night shift that began on 01/03/2014 I was in the Evisceration Room at Establishment 33900&nbsp; P to perform a finished product standards procedure on Evisceration line #2.&nbsp; As I walked through the room on my way to the pre-chill station, I saw oily, black colored water dripping from the rail and the turn wheels on the #2 carcass line.&nbsp; This oily water was dripping from the greasy rail onto the carcasses below.&nbsp; &nbsp; &nbsp; Regulatory Control Action was taken by stopping the line and since the (B)(6) was present, he had the lines and turn wheels dried in a timely manner so On the production shift that began on 01/03/2014, at approximately 2140, I was in the no other action was taken at this time.&nbsp; I then released the line to production. &nbsp; The Preventive Measure given by Mr (B)(6) was that the line leads would inspect the shackle line before production begins. &nbsp; Mr. (B)(6) was informed that a Noncompliance Record would be issued documenting the noncompliance. &nbsp; For similar noncompliance refer to NR # NHH2204122803N / 1, dated 12/02/2013. &nbsp; The requirements of Regulations 416.1 and 416.13(c) were not being met. &nbsp; The Establishments SSOP plan objective is (B)(4)</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3808012 403N-1	01/03/2014	01B02	Pre-Op SSOP Review and Observation	O	On 01/03/2014 at approximately 0100 hours while monitoring Pre-Operational sanitation in Packaging Area #1, I observed the following. There was a layer of pasty fat and tissue on a cutting wheel on the out flow side of Breast Processor #9. The wing section collection belt that runs under the breast processors had numerous specks and smears of black UFM(Unidentified Foreign Material) that smeared like grease. The area was recleaned and released by approximately 0115 hours. Packaging Area #2, the (B)(4) the red fire fighting piping is severely deteriorated. The rust and peeling/flaking paint is extensive. At several locations the flaking rust and paint is granular size pieces that easily falls off the tops of the pipes with the slightest contact. In many locations the fire fighting piping is directly over the lines creating an insanitary condition. At approximately 0130 hours in Plant #1 there was pasty fat and tissue on the metal support brackets and semi-dried yellowish UFM on the rubber fingers on Picker #2 on Line 2. The area was released by approximately 0135 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(a) & (b) and 9 CFR 416.13(c).

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2922014 302N-1	01/02/2014	03C02	Raw Intact HACCP	C	<p>On 01/02/2014 at approximately&nbsp;1248Hrs, I performed a physical verification check of the Raw Not Ground Turkey Breast and Turkey Unsorted Skins which were weighed/scanned/loaded in a trailer for shipping to the establishment's Plant # 2. Using a company calibrated thermometer, I took the temperature of one Turkey 1 Brst, boneless, skinless, W/O&nbsp;FLT (3.50 - 5.00 weight)&nbsp;and one Turkey Unsorted skins container.&nbsp;The temperatures of the Breast were (B)(4) & (B)(4) and the Skins were (B)(4) & (B)(4). U.S. Retain Tag NO's:B39554882 & B39554881 were applied to the loaded affected Turkey Breast and Skins for temperatures above (B)(4) at shipping. (B)(6) was notified of the noncompliance and verified my temperature findings at shipping. The (B)(4) Ice appeared not to be evenly dispersed over the turkey breast and skins. Mr. (B)(6) notified the plant Q.C. The establishment chose to add more (B)(4) to the affected (1912 pounds) of turkey breast and (1773 pounds) of turkey skins with kill date 1/2/2014 and with time 1217Hrs & 1225Hrs leaving the boning room. At approximately1505Hrs the turkey breast and skins were released back to shipping after verifying all of the food products temperature readings which were performed by (B)(6) were below (B)(4) This observed incident of turkey products being shipped above (B)(4) is in violation to 9 CFR 381.66(b) and 417.2(c)(4) monitoring at the critical limit. The establishment's supporting documentation for Salmonella Initiative Program (SIP) states: '(B)(4)</p> <p>(B)(4)</p> <p>The establishment's HACCP Plan at shipping states: (B)(4)</p> <p>Since the supporting documentation for your SIP waiver states that (B)(4) and the SIP is used as justification in your HACCP Plan, a violation of 417.5(a)(2) also exists.&nbsp;This noncompliance is being linked to noncompliance (#156) JDD5604112312N/1 dated 11/11/2013 for the same cause respectively.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0311011 602N-1	01/02/2014	04A06	Poultry Finished Product Standards	C	<p>On 01/02/2014 while monitoring the Establishment's Reprocessing Procedures on Line ^{(B)(6)} in Plant #1, I observed the following noncompliance. At approximately 0825 hours I randomly removed a 10 bird sample and found one split tail bird with airsacculitis exudates remaining in the bird.&nbsp;i informed ^{(B)(6)} of my findings and at approximately 0829 hours&nbsp;i took a 10 bird sample for my recheck. Out of the 10 bird recheck I found four birds with airsacculitis exudates remaining in the bird. I immediately took regulatory control action by stopping the line, and I informed ^{(B)(6)} of the noncompliance. The line was started and all missing tail and split tail birds&nbsp;were retained while corrective actions were implemented.&nbsp;i tagged the tank of retained birds with U.S. Retained/Reject Tag #B31406693, pending rework of the product. Quality Control performed a recheck at approximately 0839 hours and passed, bringing the process back into control. I removed my tag and released the product to Quality Control and she applied her "Hold" tag to the retained tank of birds. At approximately 0957 hours Quality Control performed a recheck on the retained tank of birds and passed, the birds were released back to production.My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 381.84 and 9CFR 381.76(b).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5308012 202N-1	01/02/2014	01C02	Operational SSOP Review and Observation	C	<p>On 01/02/2014 at approximately 0425 hours while performing a direct observation function under Step 14 (b)(4) CCP-3B of the establishments' Notice of Deferral Verification Plan dated October 13, 2013, I observed the following. In the Rotisserie Room, I observed the injection process of the birds through packaging and labeling. While observing the Gas Flush part of the process, I observed that the stainless probes that are inserted into the plastic product bags to extract the air prior to sealing were coming into contact with the injected carcasses in the product bags. At approximately 0430 hours the injection process was completed and the establishment started to box out bulk packed product 00626 breast meat using the same Gas Flush machines. In the main Packaging Area the bulk product is packaged in to blue plastic 10 pound bags, placed into gray product baskets, crusted (chilled to 40°F or below) then held for the boxing process. The gray baskets that the bulk product is placed in are not treated as product contact surfaces. As the baskets of bulk product were being emptied in Rotisserie at approximately 0430 hours during boxing process I observed varying amounts of black and brown UFM (Unidentified Foreign Material) on the bottoms and sides of the baskets. The exterior of the blue plastic bags that the bulk product is packaged in that was in contact with the gray baskets was not being decontaminated in any way before being placed into the plastic liner before gas flushing. Again I observed the Gas Flush process and the stainless probes were coming into contact with the contaminated blue plastic bags that the bulk product is packaged in. As soon as the boxing of the bulk was finished the Second Processing Rinse began. During the Second Processing Rinse I observed packaging materials (boxes with plastic liners) were not covered/protected from over spray during the wash down. The establishments Second Process Rinse Procedure states under step (1) (B)(4) (b)(6). "I contact (b)(6) and the affected liners in boxes on the conveyor belt behind the brown packaging belt area were discarded. I also observed that the sanitizer (B)(4) was not applied to the product contact surfaces, stainless probes, of the Gas Flush Machines 1-4. The Second Rinse Procedure states under step 5(a) (B)(4) (B)(4) and under (b) (B)(4) (B)(6). An employee applied (B)(4) to the working surfaces on the 4 units. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.13(b), 9 CFR 416.13(c) and 9 CFR 416.15(b).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5708010 502N-1	01/02/2014	04A06	Poultry Finished Product Standards	C	On 01/02/2014 at approximately 0620 hours while performing the weekly monitoring of Reprocessing Line processes in Plant 1, I observed the following. After taking a standard 10 bird sample, I observed three birds with airsacculitis exudates. The exudates were inside the carcass on the keel bone near the interclavicular area. Of the random 10 bird sample 5 of the birds had split tails including the three with the visible exudates. The establishment has the tails split before the birds are placed on to line as an indicator that the carcass needs to be vacuumed for what ever reason. At this point the process is judged to be out of control. The line was stopped and Department (B)(6) was called. Adjustments were made to personnel and training was conducted. The line was restated and a recheck passed at approximately 0633 hours. The line was running at approximately (B)(4) (birds per minute) and there were two house inspection and three employees vacuuming at the time of the failure. My findings indicated a noncompliance with 9 CFR 381.84.
5308	M6137	BXL0717124 531N-1	12/31/2013	06D02	Other Inspection Requirements	C	At approximately 1238 hours while performing a presentation check on Line (B)(4) in Plant #2 I observed the following noncompliance. The first station on Line (B)(4) had (3) viscera on shackle and (1) contamination inside for a total of 30 nonconformance points. This exceeds the limit of 20 points or 2 occurrences for one error for the process to be in control. I informed (B)(6) of the failure. QC did a recheck at approximately 1247 hours which also failed with (2) viscera on shackle and (3) not reflected, which exceeds the limit of 2 occurrences for one error. The line speed was immediately reduced as per protocol (B)(4) to (B)(4). QC performed a recheck at 1307 hours that passed at (B)(4), the line speed was then raised to (B)(4). QC did another recheck at (B)(4) which passed, bringing the process back in control. My findings indicate a noncompliance with the regulatory regulations of regulation 9CFR 381.76(b).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2013121 331N-1	12/31/2013	04A06	Poultry Finished Product Standards	C	At approximately 1040 hours while monitoring the Establishments On Line Reprocessing procedure on Line (B)(4), I observed the following noncompliance. After taking a random 10 bird sample of split tails from Line (B)(4) I found 2 of the 10 birds had airsacculitis exudates remaining. The exudates were found on the inside of one carcass in the airsac on the left side and in the second carcass there was a large piece on the left flap that measured approximately 1/2" in diameter. I immediately informed (B)(6) of the noncompliance. (B)(6) immediately went and instructed personnel on the vacuuming procedure, as there were already 2 people vacuuming and the line was at (B)(4). I performed a recheck at 1050 hours which passed bringing the process back on control. My findings indicate a noncompliance with the regulatory regulations of regulations 9CFR 381.76(b) and 9CFR 381.84.
5308	M6137	BXL3208123 831N-1	12/31/2013	03J02	Slaughter HACCP	C	On 12/31/2013, while performing a HACCP Slaughter Review and Observation Task in Plant #2, Reprocessing Line (B)(4) I found a noncompliance with the following regulatory requirements of regulations of 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 0438 hours, I randomly removed a 10 bird sample from Reprocessing Line (B)(4) after the final house inspector station, I found one out of the ten birds with visible fecal contamination outside of the bird, on the right side by the tail area. The fecal material was green in color, pasty in texture and measured approximately 1/4" diameter in size. I immediately stopped the line and informed the Lead Person and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0444 hours and it passed. This is a violation of the critical limits of CCP-1B (B)(4) of the Plant's HACCP Plan for Slaughter.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH020001 4502N-1	12/31/2013	03J04	Poultry Zero Tolerance Verification	C	On the night of production that began on December 30, 2013 at approximately 2136 hours while performing the Poultry Zero Tolerance task at the designated line 1 prechill station at establishment P33900 after randomly selecting 10 carcasses, fecal material was observed on the seventh carcass inspected. The fecal material was green in color, pasty in texture and easily smeared when touched. The three smears observed each measured approximately one eighth inch by one eighth inch and were located in the tail area. Mr. (B)(6) was notified of the finding and informed the noncompliance would be documented on a noncompliance record. According to the plant's investigation the cause of the noncompliance was the IOBW was not properly adjusted for the size of bird. The measure to prevent recurrence was (B)(4). The requirements of 9 CFR 381.65(e) and 417.2(c)(4) were not met. Refer to NR NHH2408125816N/1 dated December 16, 2013 for similar noncompliance. The measure to prevent recurrence for this noncompliance was maintenance will monitor the I/O wash height 2 times more during the shift. These measures may have been implemented incorrectly or may have been ineffective at preventing recurrence.
5308	M6137	BXL2918124 830N-1	12/30/2013	03J04	Poultry Zero Tolerance Verification	C	At approximately 1537 hours while performing a Zero Tolerance task on Line (B)(4) in Plant #2, I observed the following noncompliance. After (B)(6) removed a standard 10 bird sample from the line, I observed 1 bird with visible fecal contamination. The fecal material was inside the carcass on the left side. It measured approximately 1/2" x 1 1/2" and extended from the left leaf fat to the kidney area above the tail. The fecal material was brownish green in color and thick and pasty in texture. This exceeds the limit of Zero Tolerance for the process to be in control. I informed (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck after the line gap and it passed at approximately 1610 hours. My findings indicate a noncompliance with the critical limits of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter, regulations 9CFR 381.65(e) and 9CFR 417.2(c)(4).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5108125 630N-1	12/30/2013	04A06	Poultry Finished Product Standards	C	On 12/30/2013, while performing Pre-Chill Finished Product Standards Task, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.84. At approximately 0548 hours, I randomly removed a 10 bird sample from Line ^{(B)(6)} in Plant #2 for my FPS check. I found one out of the ten birds with visible airsacculitis exudates, the bird had split tail. The establishment marking system uses a split tail to mark the birds requiring vacuuming. At approximately 0553 hours, Quality Control performed a recheck and failed. (B)(6) found two out of ten birds with split tail containing airsacculitis exudates. QC informed the Line Supervisor and birds from that line were retained. At approximately 0600 hours QC performed another recheck and it passed. The retained product was reworked. (B)(6) was informed about the noncompliance.
5309	P6137A	NJN191212 4031N-1	12/30/2013	04A06	Poultry Finished Product Standards	O	While performing a finished product standards check at approximately 1130 hours, on the reprocessing line prior to the birds entering the chiller, I observed a noncompliance. In a sample of ten carcasses, there were eight carcasses with split tail (which identifies that vacuuming is required to remove all affected tissues including the kidneys). Three out of the eight carcasses had yellow gelatinous tissue inside, located beside the pelvic bone and on the flap area, and another two carcasses had parts of the affected kidneys not vacuumed. I immediately took regulatory control action by stopping the re-processing line and showed Mr. (B)(6), my findings and informed him of the forthcoming noncompliance. The presence of five carcasses with airsacculitis affected tissues out of eight carcasses indicates that the re-processing line was not under control. The plant failed to effectively apply their procedures for air-sac and comply with federal regulation 9 CFR 381.84.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5708125 428N-1	12/28/2013	03J02	Slaughter HACCP	O	On 12/28/2013 at approximately 0555 hours while monitoring Post-Chill Finished Product Standards from product exiting Chiller #4, I observed the following. After collecting a standard 10 bird sample I found one bird with visible fecal contamination. There was a gizzard with approximately 6" of intestine attached inside the carcass. The cut end of the intestine was visible at the opening to the abdominal cavity. There was fecal material leaking from the cut end of the intestine onto the left exterior side of the carcass on to the thigh area approximately 1" from the base of the tail (B)(6) was observing so I immediately showed him the carcass and the fecal contamination. The fecal material was a smear, medium brown in color and measured approximately 3/8" by 1/8" in size. The hanging of carcasses going into packaging was stopped. A recheck passed at approximately 0558 hours. A partial tank of carcasses was placed under QC hold pending reinspection (B)(6) was informed of the noncompliance. My findings indicated a noncompliance with 9 CFR 381.65(e) and 9 CFR 417.2(c)(4).
5308	M6137	BXL5901124 528N-1	12/28/2013	01D01	SPS Verification	C	On 12/27/13 at approximately 2319 hours I was giving an Inspector a break in Plant one, line #2, Station #7, when I noticed a juvenile cock roach sitting on the left side faucet. I stop the line, took a piece of paper towel and killed the roach. I then started the line and turn on my call light (B)(6) answered my light and I informed him of the cock roach. My findings indicate a non compliance with CFR 416.2(a).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN091412 5927N-1	12/27/2013	01D01	SPS Verification	C	<p>While performing the review and observation component of one Sanitation Performance Standard (SPS) task, I observed noncompliance with SPS regulatory requirement 416.1 and 416.4(d). At approximately 0857 hrs in the Raw Product Processing Department/Injection Area, I observed numerous flakes (approximately 20 count &lt;= 1/16") of black unidentifiable foreign material (UFM) lying on the top surface of one large plastic bag which served to line one edible product stainless steel tank (# 562) and to protect the raw product contained within. I observed that the protective plastic material was partially draped back leaving a portion of the raw product contained within the tank exposed. Upon further investigation, additional black flakes of UFM (approximately 10 count &lt; 1/16") were observed lying on top of and in direct contact with random surfaces of the exposed raw product. Official regulatory control action was taken and U.S. Retain Tag No. B39554792 was used to retain the contaminated product (Turkey Breast Meat-Est. 157). (B)(6), was promptly notified who immediately implemented corrective action. I asked (b)(6) where the U.S Retained tank of raw product had been stored prior to being staged in the Injection Area. (B)(6) stated that the tank had been retrieved from Raw Product Cooler #4. Upon appropriate product disposition, official regulatory control action was relinquished and the above cited U.S. Retain Tag was removed (1225 hrs.). A review of the establishment's written SSOP Program was performed. Section II. Operational Objective states, (B)(4)</p> <p>"A similar noncompliance with the same root cause (black UFM on raw exposed product and protective plastic covering in Cooler #4) was observed and documented on NRLQN3923085210N/1 dated 8/10/2013. Plant Management's elected written response states, (B)(4)</p> <p>This linkage serves to demonstrate that the preventive measures were either not implemented or were ineffective in preventing recurrence of SPS regulatory noncompliance (cross contamination of raw product). Note: To date Plant Management has proffered that the source of the black UFM has not yet been identified. This document serves as written notification that failure to comply with regulatory requirements in 9 CFR Part 416 could result in contamination or adulteration of product and insanitary conditions and could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0409121 927N-1	12/27/2013	06D02	Other Inspection Requirements	C	<p>On 12/27/2013 at approximately 0003 hours the inspectors on line (b)(6) were complaining about the way the carcasses were arriving at the inspection station. After checking the Presentation Log for the shift and finding no issues documented I performed the task and observed the following. The first station on line (b)(4) had (1) viscera not uniform, (5) viscera on shackle, (1) membrane, (3) not reflected, (3) parts inside for a total on 59 nonconformance points. This exceeded the limits of (b)(4) points or (b)(4) occurrences for one error for the process to be in control. A total of over 40 nonconformance points requires an immediate reduction in line speed. I contacted (b)(6) and informed him that the process was out of control. The line was slowed to (b)(4) birds per minute. The second station had (1) viscera not uniform, (2) viscera on shackle, (3) not reflected and (2) parts inside for a total of 32 nonconformance points. The third station had (1) viscera on shackle, (1) membrane, (2) not reflected and (4) parts inside for a total of 18 nonconformance points. A Quality Control recheck passed at 0010 hours at (b)(4) (birds per minute) and a second recheck at 0040 hours passed at (b)(4) bringing the process back into control. My findings indicated a noncompliance with 9 CFR 381.76(b).</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ1021122 026N-1	12/26/2013	04B01	Labeling - Product Standards	C	<p>On 12-24-13 at approximately 1434, I, CS (B)(7)(C), was performing the regularly scheduled Labeling-Product Standards PHIS Task in the packaging area. I observed a pallet of twenty two cases of product &nbsp;# 090201 Frying Chicken Whole Breast located at the east end of the Rotis Area. I observed that some of the case's box end labels had a slaughter date of 12-23-13 and a Julian date of 357. According to the establishment's labeling procedure, the correct Julian date for 12-24-13 is 358. I did not know when this product had been packaged. To answer this question, at approximately 1438, I discussed the issue with (B)(6), and showed him what I observed in the Rotis Area. &nbsp;Mr. (B)(6) explained the product was part of an order of two hundred and thirty cases and had been slaughtered 12-23-12 and packaged 12-24-13. Mr. (B)(6) explained that two hundred cases were already on a trailer located at the shipping dock. At approximately 1439, I verbally informed Mr. (B)(6) that I was issuing a noncompliance record for the mislabeled cases with the wrong Julian date and applied US Rejected/US Retained Tag # B37852272 to one of the cases on the pallet. At approximately 1448, with the assistance of (B)(6), the two cases of product that had been mislabeled were relabeled with labels with the correct slaughter date and Julian date. At approximately 1449, I removed the US Rejected/Us Retained Tag from the cases and released the product back into the establishment's control. &nbsp;At approximately 1452, with the assistance of (B)(6), the two hundred cases of product # 090201 were located on five pallets inside trailer # 285 at bay # 3 at the shipping dock. I visually verified the labels on the cases had the correct slaughter date and Julian date. This NR is not linked to any recently issued NR for the same root cause.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ4509121 326N-1	12/26/2013	03J04	Poultry Zero Tolerance Verification	C	On December 26, 2013 at 0705 I, CSI (B)(7)(C) performed a routine scheduled Poultry Zero Tolerance task. I observed visible fecal material on one of the ten randomly selected carcasses. The 1/2" by 1/8" strip of dark olive green fecal material was found on the interior of the bird located along the right thigh/hip. Adjacent to the green fecal material was white urate approximately 1/8" in diameter. I verbally notified (B)(6) and (B)(6) of the failure and that a NR would be issued. The plant implemented their fecal failure program. The verbal response given as to the cause was a nozzle in the New York wash cabinet was not working. The nozzle was repaired. A retest by QC found no further incidence of visible fecal present. The verbal preventative measure given was that the New York bird wash cabinet nozzles will be added to the Maintenance machine checks required to be performed at every plant break. Records show that on December 4, 2013, NR# OIJ0908123505N (#84) was written for fecal found on a wing. The written response states the cause was the New York bird wash cabinet had a malfunctioning spray nozzle. The preventative action was that the New York bird wash cabinet was to be monitored every half hour until December 13, 2013. This NR is linked to NR# OIJ0908123505N (#84). The Establishment Awareness Meeting notes show the last time fecal noncompliances were discussed was on December 5, 2013.
5308	M6137	BXL2807120 924N-1	12/24/2013	01B02	Pre-Op SSOP Review and Observation	C	On 12/23/2013 at approximately 2223 hours while monitoring the establishments Pre-Operational Sanitation standards in Plant 2, I observed the following. The Scalders at the end of line 1 were being drained for cleaning. As discussed at the morning meeting with management on 12/18 the establishments' SSOP Pre-Operational Sanitation procedure states in part (B)(4) [REDACTED] A review of the SSOP Pre-Operational sanitation Implementation and Monitoring Log for the shift revealed that Plant 2 was released at 2213 hours by the SSOP for 'operations' although cleaning of the Scalders was not completed until approximately 2238 hours. At approximately 2226 hours there was a heavy yellowish pasty UFM(Unidentified Foreign Material) on the top of the guide bar associated with second Picker on line 1. The unit was recleaned and released by approximately 2232 hours. At approximately 2250 hours there were 3 hoses that each had several feet coated with a pink slimy UFM. The hoses are associated with the chiller aeration system. The hoses were disconnected and flushed restoring sanitary conditions by approximately 2256 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.13(c) and 9 CFR 416.14.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2114125 923N-1	12/23/2013	03J02	Slaughter HACCP	C	While performing Pre-Chill Finished Products Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 0957 hours, I randomly removed a 10 bird sample from Line (B)(6) in Plant #2, I found one out of the ten birds with visible fecal contamination inside of the bird, on the right leaf fat area. The fecal material was brownish in color, creamy in texture and measured approximately 1/8" diameter in size. This exceeds the limit of Zero Tolerance for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1027 hours and it passed. This is a violation of the critical limits of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.
5112	M18909	JDD5907121 420N-1	12/20/2013	01D03	Poultry Sanitary Dressing	C	On 12/16/2013, Dr. (B)(7)(C), at about 0230 H PST observed a bird from Tanked Off Birds being returned to line without washing off the Fecal Contamination. They were adding the affected carcass to the community vat, this is at the Hock Cutter/Rehang Station. Dr. (B)(7)(C) took control of the Carcass and had it reconditioned by Mr. (B)(6) prior to him putting it back on the line. Mr. (B)(6) and Ms. (B)(6) were notified of this issue and of our intent to document. The birds were tanked off because of the size (birds were abnormally small) and condition of the birds, Contamination with Fecal before and after opening the cavity. This in turn caused the Establishment to stop the kill line for while, tank off birds while getting caught up on the reprocessing of birds with Fecal Contamination that had been removed at the Two Inspection Stations. Noted: Later this Lot the Establishment stationed one employee on each line spaying fecal contamination off the carcass prior to opening. The contamination rate was 25%. This is a violation of the Establishment written SSOP Program stating in (B)(4) " and the above 9 CFR's.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1323120 020N-1	12/20/2013	01C02	Operational SSOP Review and Observation	C	<p>On 12/19/2013 at approximately 0400 hours while performing a direct observation function under Step 10 (b)(4) CCP-3B of the establishments' Notice of Deferral Verification Plan dated October 13,2013, I observed the following.&nbsp;At Rehang 1 at approximately 0400 hours I monitored the&nbsp;mid-shift Second Processing Rinse Procedure. At approximately 0440 hours&nbsp;according to (B)(6) the requirements of the process were met and packaging production&nbsp;resumed. I had monitored the area the entire time and the 'kickers' for the Check/Weight lines and the parts of the drip trays that drain back into the (B)(4) spray cabinets that are treated as product contact surfaces had not been rinsed or treated with (B)(4) I informed (B)(6) who called (B)(6) (B)(6) and (B)(6) and I repeated my observations. I was informed by (B)(6) that he was not aware of the requirement to (B)(4) the kickers or the drip pans so he would not do so today. I informed him&nbsp;that a noncompliance would be issued.&nbsp;A review of the Establishments' HACCP Plan -&nbsp;Raw Intact - Packaging Step 6 Sort/Size under Potential Hazard lists (B)&nbsp;Salmonella and then Is the Hazard Significant? YES. Under Justification for Decision it states (B)(4)</p> <p>(B)(4). Supplement 53 is listed as a supporting document. Supplement 53 states under procedure Step 4 (B)(4)</p> <p>(B)(4) The procedures in Supplement 53 regarding (B)(4) application were not implemented as written.&nbsp;&nbsp;My findings indicated a noncompliance with 9 CFR 416.13(b) & (c), and 9 CFR 416.15(a) & (b).&nbsp;&nbsp;</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2504120 519N-1	12/19/2013	01C02	Operational SSOP Review and Observation	O	<p>On 12/18/2013 at approximately 2220 hours after the area had been released from Pre-Operational Sanitation and while monitoring Operational Sanitation in the Rotisserie Room, I observed the following. There was an employee standing on the top of the (B)(4) Tank for the Injection Machine assisting with the assembly of the Injector Machine. The establishments' SSOP Section II and Operational sanitation under Implementation; (B)(4)</p> <p>(B)(4) There was no plastic or other protective measure in use as the employee boots were in direct contact with the top of the tank. The SSOP and Operational Sanitation under Corrective Action; a Plant Management Team Member; under Restoration of Sanitary Conditions: (B)(4)</p> <p>(B)(4) "A review of the SSOP Daily Implementation and Monitoring log for the shift under Operational SSOP found everything acceptable for the shift. The lack of access to reassemble the machine was discussed with management previously; at a weekly meeting. My findings indicated; indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.3(a), 9 CFR 416.12(a), 9 CFR 416.14 and 9 CFR 4156.15(b).</p>
5308	M6137	BXL3617124 719N-1	12/19/2013	03B02	Raw Non-Intact HACCP	C	<p>On 12/18/2013, at approximately 1800 hours, while performing HACCP Raw Non-Intact Record Review Task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.5 (a)(3). The day before (12/17/2013) while performing direct observation on Raw Non-Intact task in the Rotisserie Room, I observed the following. During the mid-shift (lunch break) rinse, the HACCP monitor or designee measured the sanitizer concentration on five contact surfaces. The first check; Quality Control had two failures, (each of (B)(4) of (B)(4) and the third recheck passed (B)(4) ppm of (B)(4). The second and the third regular checks passed. The fourth check had again two failures, (each of (B)(4) ppm of (B)(4) and the third recheck passed (B)(4) ppm of (B)(4). The fifth regular check passed. When I review the records, the HACCP Monitoring Log -CCP 3B- (B)(4), Raw Non-Intact, dated on 12/17/2013, PM shift, did not have any Corrective Action Log. I observed that the corrective actions were performed but not documented in the Corrective Action Log. I informed Quality Control (B)(6) about the noncompliance.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA1304124 619N-1	12/19/2013	01D01	SPS Verification	C	On December 19, 2013 at approximately 0145 hours, after the establishment had finished their pre-operational sanitation inspection and prior to the start of operation, I observed noncompliance with SPS 416.1; 416.2(b)(1), and 416.4(b). While performing my pre-operational sanitation inspection on Oven #1 and Oven #2, I observed that at the exit end of oven 1 and 2 the overhead exhaust drip pans and supports have an excessive amount of what appears to be Rust and Smoke build up. I informed and showed (B)(6) the noncompliance. Ms. (B)(6), was also informed. This does not comply with Regulatory Requirements: 416.1; which states in part, "Each official establishment must operate in a manner to prevent insanitary conditions", 416.2(b)(1); "Establishment buildings, compartments must be kept in good repair", 416.4(b); "Non-food contact surfaces of facilities must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.
1325 7	P33900	NHH501212 3119N-1	12/19/2013	01C02	Operational SSOP Review and Observation	C	#200 At 0638 hours while walking down the hall to enter the evisceration area I observed two sleeved aprons hanging on the rack along the hallway were resting on the floor. The ties on these aprons are extremely long and measures need to be taken to prevent the ties from dragging on the floor hanging or wearing them. The rack in the further processing hallway also had three aprons hanging that were in contact with the floor. US tag numbers B38075647 and B38075646 were applied to the aprons. Management was notified and all the aprons that were contacting the floor were thrown away. The SSOP plan states that (B)(4) " This requirement and the requirements of requirements of 416.11 were not met.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1231 11	V210A	000061912 3519N-1	12/19/2013	04B05	General Labeling (V)	C	On December 19, 2013 while performing a visual inspection of "Chicken Paws" to be exported to Hong Kong I observed noncompliance with 9 CFR part 381.96 & 381.123 of the Meat & Poultry Regulations. At 16:45 hours I observed four pallets of product stamped with export MPJ#567367; the plant number on the label; P6137A was printed directly into the inspection bug and unclear to read; as well there were several cases of product where the plant number was tore off of the label all together, I was unable to determine the plant number. Mr. (B)(6) & Mr. (B)(6) were both verbally notified and shown the noncompliance. A regulatory control action; (RCA) was taken on the four pallets with U.S. Retain tags# B43241946, 47, 48, 49. At 18:30 hours when the plant implemented corrective action I relinquished the (RCA). This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions as described in 9 CFR 500.4.
1231 11	V210A	000430112 2319N-1	12/19/2013	01D04	SPS Verification (V)	C	On December 18, 2013, at approximately 1645 hours I was performing my export inspection on the boxes of product staged in the shipping dock at V210A. I observed that the lighting near door #5 where some of the product was staged to be inspected was not acceptable making it difficult to check the plant number, exports stamp number, use by dates, and labels on each box of product. I informed (B)(6) who accompany me when I performed my export inspection. Mr.(B)(6) informed me that he would notify his boss Mr.(B)(6). This is a violation of Regulation 416.2(c); which states in part: "Lighting of good quality and sufficient intensity is required in areas where product is stored or examined". This document serves as written notification that failure to comply with regulatory requirement(s) in 9 CFR 416 could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3505123 318N-1	12/18/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 12/17/2013 at approximately 2200 hours while monitoring the Establishments' Pre-Operational Sanitation standards in Plant #1, I observed the following. There was a heavy layer of pasty yellowish UFM(Unidentified Foreign Material) on the stainless guide bar above the third Picker for line #2. The unit was cleaned and released by approximately 2210 hours. At approximately 2330 hours Packaging Area 1 in the Plant #1 Rehang area there was a thick coating of dried black and brown UFM on the guide bars for the Check /Weight line. An area approximately 6 feet long of the guide bars on the return side of line 1 & 2 and the spray assemblies at the same location were recleaned and released by approximately 0000 hours. At approximately 2340 hours there were several pieces of fat and tissue to approximately 1/4" on the inside surfaces of a stainless steel tank covered with blue plastic and staged for use near the outflow conveyor for Chiller 2. The blue plastic is used by the Establishment to identify tanks that are clean and ready for use. The tank was rinsed with potable water restoring sanitary conditions. At approximately 2335 hours there were numerous pieces of tissue to approximately 1" inside of the (B)(4) unit filter. The filter was rinsed with potable water and returned to service by approximately 2345 hours. (B)(6) was informed of the noncompliance. At approximately 0004 hours in Packaging Area #1 along line B on the blue product belt for the (B)(4) Dip system there was black UFM(Unidentified Foreign Material) that smeared like grease contaminating an area of the belt measuring approximately 1 square foot. There was also several pieces of tissue to approximately 1/4" on the stainless under the belt at the same location. There were several pieces of fat and tissue measuring to approximately 2" on the sprocket for the tray belt at the head of line B. The area was cleaned and released. At approximately 0010 hours there was fat and tissue to approximately 2" on the chain of Leg Processors 1-3. The machines were released by approximately 0015 hours. At approximately 0025 hours in Packaging Area 2, the (B)(4), there was black UFM (Unidentified Foreign Material) that appeared to be mold along the ceiling support beam near the vertical belt that transports breast fillets from the final trim table to Packaging Area 1. The area will be cleaned after production. (B)(6) was informed of the noncompliance. As discussed in the morning meeting on 12/18 the establishments' SSOP Pre-Operational Sanitation procedure under Monitoring states in part (B)(4)</p> <p>Yet for each area even with the SSOP log completed certifying that the area is 'released for operations' the USDA inspector is told by the area Sanitation Supervisor that the area is not ready with cleaning still in progress. The SSOP Pre-Operational Sanitation 'Implementation' daily procedure steps should</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							routinely be completed before the 'Monitoring' step is performed. This issue was discussed with management at the morning meeting on 12/18/2013. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) (b), 9 CFR 416.13(c) and 9 CFR 416.14.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3805124 018N-1	12/18/2013	01D01	SPS Verification	O	On 12/17/2013 at approximately 2000 hours while monitoring the establishments' Operational Sanitation Standards in the Plant #1 Cooler, I observed the following. (b) (4) Refrigeration Unit W-1 mounted from the ceiling near the Staging Cooler door was in the defrost cycle. Thawing condensates were dripping from the bottom the the drip pan onto three pallets of brown product tubs of giblets staged directly below the cooler unit. The condensates were adding an untold number and variety of contaminants on the exterior of the brown product tubs that are handled during dumping by employees wearing green product contact gloves. The condensates were creating an insanitary condition. I contacted (B)(6) and showed him the noncompliance. A mechanic was called and after checking the computer he said that the unit was defrosting. The drip pan that should be collecting the condensates and directing them to a drain was leaking. I got a ladder and inside the drip pan was a large area of a blackened slimy mass of UFM (Identified Foreign Material). I collected some of the UFM and it consisted of plastics coated with a blackened grease like substance. The defrosting fluids were passing through the blackened mass before dripping from the leaking catch tray onto the brown product tubs. The tubs were moved and reconditioned with (B)(4) water. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).
5308	M6137	BXL3817120 318N-1	12/18/2013	01C02	Operational SSOP Review and Observation	C	At approximately 0858 hours while monitoring the shift change rinse procedure and (B)(4) application at the Plant #2 Post Chill Rehang area, I observed the following noncompliance. Production employees were rinsing and applying sanitizer (B)(4) to the product contact surfaces as prescribed in the SSOP Plan. A company employee was still rinsing Line #2 at Rehang 2 when he was asked to hurry up so (B)(4) could be applied at which time he stopped rinsing the line, without rinsing inside the drop chutes for carcasses to reach the lower belt. I then observed company personnel applying the sanitizer (B)(4) to Line (B)(4) the Bag Fryer line. When the employee was through with the line, I had observed that he had not sprayed inside the drop chutes that take birds to the lower belt, which is a product contact surface. I immediately informed QC and (B)(6) of the noncompliance. The SSOP Plan states in part under Second Processing Rinse Procedure that (B)(4) ". (B)(6) had a sanitation employee rinse the inside of the drop chutes on Line #2 and then had sanitizer (B)(4) applied to the inside of the drop chutes on Line #2 and the Bag Fryer Line (B)(4) as well, restoring sanitary conditions.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2621120 817N-1	12/17/2013	01C02	Operational SSOP Review and Observation	O	<p>On 12/16/2013 at approximately 1935 hours while monitoring Operational Sanitation in Packaging, I observed the following. There were employees deboning leg meat on line 1 and at the salvaged parts table adjacent to line 1 and placing the meat in blue plastic bags. The establishments' Notice of Deferral Verification Plan dated October 13, 2013 step 17 had the establishment install Acidified (B)(4) sprays on all lines. The HACCP Plan - Raw Intact - Packaging step 7. Cut/Deboning/Trim under (C) Chlorine and (B) Pathogens states 'The process is designed to reduce the risk associated with the hazard. (b) (4) (B)(4)</p> <p>(b) (4) Supplement 59 and has the (B)(4) sprayers monitored (b) (4)</p> <p>" and The SSOP Daily Implementation and Monitoring Log - Packaging for the shift showed that the last sprayer check in Packaging was performed at 1612 hours. The sprayers were not on as required by the establishments' Verification Plan. I contacted (B)(6) and a partial rack of leg meat was placed into 3 brown tubs to be treated and repacked. My findings indicated a noncompliance with 9 CFR 416.13(b) and the establishments' Verification Plan.</p>
5308	M6137	BXL2710125 717N-1	12/17/2013	03J04	Poultry Zero Tolerance Verification	C	<p>While performing Zero Tolerance Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). On 12/16/2013, at approximately 1243 hours, (B)(6) removed a 10 bird sample from Line #1 in Plant #1, I found one out the ten birds with visible fecal contamination, inside of the bird at the left side, close to the tail. The fecal material was brownish in color, creamy in texture and measured approximately 1/4" diameter in size. This exceed the limit of Zero Tolerance for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1312 hours and it passed. This is a violation of the critical limits of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM580212 3617N-1	12/17/2013	03G02	Fully Cooked-Not Shelf Stable HACCP	C	On 12/16/2013, at approximately 2020 hours, while performing a routine scheduled HACCP Records Review inspection task in the QC Managers Office, I observed the following noncompliance: while reviewing the Fully Cooked Shelf Stable Whole Muscle / Diced Stripped HACCP Program's Hazard Analysis dated 12/16/13, several process steps from the Refrigerated Storage Step to the Shipping WIP Product to FTP2 Plant or approved Co-Packer for High Pressure Pasteurization Step were missing the hazard of concern, a noncompliance per 9 CFR 417.5(a)(1). The hazard analysis did document the hazard as not likely to occur and establishment's reasoning / prerequisite program used, thus there were no food safety hazards identified with the establishment shipping adulterated product into commerce during that production. I showed and informed Mr. (B)(6), Production Superintendent of the forthcoming noncompliance. The requirement of 9 CFR 417.5(a)(1) was not met.
5112	M18909	JDD1523125 816N-1	12/16/2013	01B02	Pre-Op SSOP Review and Observation	C	On PRE-OP this date 12/16/2013 I observed the following: 1) Black Piece of Plastic 1/2 in long, on the End Chute off the Breast Sorting Belt. 2) Grease Zirk missing on bearing at Spiral Belt, this has been gone several days. 3) Product Residue on both side of the door between Cooler Five and Raw Fab. 4) In little Dry Storage Room off of Raw Fab, the racks there had Product Residue on them. 5) Broken Air Lines on bottom of Chiller B. Mr. (B)(6), Mr. (B)(6) and Ms. (B)(6) were advised of these issues and no note of these were seen in Q.C. POaperwork. This is a violation of the Establishments SSOP program and the above listed 9 CFR's. This linked to NR 176-2013, Dated 12/14/2013, JDD0310124414N/1 and its associated JDD Numbers.
5112	M18909	JDD5119121 417N-1	12/16/2013	03J02	Slaughter HACCP	C	On 12/16/2013 at approximately 1824Hrs while reviewing the establishments 12/14/2013 records in the Quality Control Lab as part of my Slaughter records task, I found the following noncompliance to the relevant regulations cited above. The (b)(4) (CCP 2B) - Gib Temperature Monitoring and Documentation Log dated 12/14/2013 showed that the shift B HACCP Monitor performed her temperature check at 1812Hrs. The record did not show the second required hourly temperature check for the 1800Hrs. The pre-shipment review at 0600Hrs on 12/16/2013 to ensure completeness was performed by plant management also the HACCP record was reviewed and verified on 12/16/2013 by Quality Control. (B)(6) was notified of the noncompliance by e-mail. Dr. (B)(7)(C) SPHV was also notified of the noncompliance.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5907125 616N-1	12/16/2013	01C02	Operational SSOP Review and Observation	C	<p>Observed Boning Supervisor&nbsp;Ms. (B)(6) employee doing operational tasks of putting liners in tanks. I then checked the tanks and the employee had liners in&nbsp;five&nbsp;tanks that had product residue in them. Mr. (B)(6) was witness to the events.&nbsp;The tanks were then recleaned by Sanitation. Ms. (B)(6) was advised of the operational noncompliance as was Ms. (B)(6). There was not any previous documentation of this issue, &nbsp;prior to my notification of the same. Along the same issue Mr. (B)(6), employee is putting equipment into a dry storage area and the equipment has pieces of poultry residue too numerous to readily count. This was put in there, "&nbsp;not cleaned". This is a grinder and it is the (B)(6) office and Mr. (B)(6) &nbsp;is witness as to the condition of the grinder. This is a violation of the Establishment's written SSOP program, stating in part: ' (B)(4) ' This is also a violation of the above 9 CFR's. This is linked 152-2013, JDD1623115706N/1, Dated 11/06/2013 and 158-2013, JDD3803110513N/1, Dated 11/13/2013 and both NR's associated JDD Numbers.</p>
5309	P6137A	NJN310312 1817N-1	12/16/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>At approximately 0049 hours, after the QC Technicians had performed Pre Operational Sanitation and released the area for production, I proceeded to perform Pre Operational Sanitation in Area 2-Packaging/ Section C: Segment Line & (B)(4). While doing so, I observed numerous pieces of fat and skin on and around Leg Processor # 2 as well as conveyors directly below LP #2. On a supporting structure above there was grease and fat build up from the previous day's production. I took immediate regulatory control action by applying US Rejected Tag # B 43303634 to the affected area and informed Mr. (B)(6) of the forthcoming Non Compliance Record. At 0103 hours, after the restoration of sanitary conditions, I reinspected and released the area. The establishment failed to adequately monitor the implementation of the sanitation SOP, which in turn created an insanitary condition. The findings represent a non-compliance with 9 CFR 416.4a, 416.4b and 416.13c.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH240812 5816N-1	12/16/2013	03J04	Poultry Zero Tolerance Verification	C	#199At approximately 0803 hours while performing a zero tolerance task on eviscerating line two I observed feces inside the lower keel area of the first sample bird. It was approximately 3/16" in diameter, olive green in color with a pasty consistency. The bird was shown to QA, maintenance personnel, and Management. The establishment failed to comply with the requirements of CFR 381.65(e). After investigating the incident, according to the report,Maintenance found that the I/O wash was too low for the smaller birds and the probe not entering the cavity of the bird. It also stated that Maintenance will monitor the I/O wash height 2 more times during the shift.
5310	M6137B	FFA2100121 815N-1	12/15/2013	01D01	SPS Verification	C	On December 14, 2013 at 1510 hours while monitoring the operation in the Frank Peeling Area I observed insanitary conditions. I observed an excessive amount of product on the floor in front and underneath the Frank Peelers numbers 1, 2, and 3. I observed excessive amount of product on the floor underneath the Hoppers/Convery Belts to (b)(4) numbers 1, 2, and 3. At the time of my observation I did not see anyone cleaning up in this area. Mr. (B)(6) and Ms. (B)(6), was informed. Immediate Corrective Action was implemented by Management: Product was condemn and the floor was cleaned and sanitized.This does not comply with Regulation 416.1 which states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated", and Regulation 416.2(b)(2); which states in part: "Floors within the establishment must be cleaned and sanitized as necessary to prevent adulteration of product or the creation of insanitary conditions". This NR is Linked to NR#FFA5818120006N/1 dated 12/06/13, for a similar noncompliance. As of today 12/14/2013, Management has not given a written response to this NR.This document serves as written notification that continue failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.
5112	M18909	JDD0310124 414N-1	12/14/2013	01B02	Pre-Op SSOP Review and Observation	C	1) Water Reuse Tank off of Chiller B had Poultry Residue in it. 2) Product Discharge Belt into Chiller A had Poultry Residue on it. 3) Product Residue and Rust in the Final Wash. 4) Hoses in I/O Wash One are frayed. 5) Overheads by Picker Three with Feathers > 10. Mr. (B)(6), Mr. (B)(6) and Mr. (B)(6) were notified of these issues. No documentation of these issues was observed in QC Paperwork. The is a violation of the Establishment's written SSOP program and the above listed 9 CFR's. This is linked to NR 172-2013, Dated 12/09/2013; 171-2013, dated 12/07/2013; 168-20132, Dated 12/02/2013 and their associated JDD Numbers.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0423125 514N-1	12/14/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 12/14/2014 at approximately 1730Hrs while performing my PHIS Zero Tolerance fecal check, I observed visible fecal material on the 10th bird sampled out of the ten whole body Light Hen Turkeys sampling test from line one. The feces was found on the left side of the distal pelvic cavity&nbsp;at the cavity opening. The fecal material was non granular; uniformly green in color, moist and pasty consistency with the distinct odor consistent with fecal material.&nbsp;The two fecal material pieces were at the same site one in front of the other. They were&nbsp;approximately 10mm x 3mm and 8mm x 3 mm in size. U.S. Retain Tag NO:B39554629 was applied to the affected carcass. (B)(6); (B)(6), (B)(6) and Dr.(B)(7)(C), SPHV were notified of the noncompliance and shown the affected carcass. Dr.(B)(7)(C) concurred that it was fecal material. Ms.(B)(6) immediately implemented the establishment's corrective actions. The had the affected turkey reconditioned by trimming and (B)(4) spraying and reinspection. At approximately 1836Hrs the turkey was released back to production after verifying&nbsp;the plant's corrective actions and reinspection. Ms.(B)(6) conducted her rechecks after the final wash and they passed. This observed incident of visible fecal material is a noncompliance to 9 CFR 381.65(e). Also is a violation to 9 CFR 417.2(c)(4) monitoring at the critical control point to ensure compliance to the established CCP 4B (B)(4) after the final wash and before entering the chiller. At approximately 2055Hrs the plants implemented corrective actions at the post chill were completed and passed by Ms.(B)(6) Ms.(B)(6) verified the checks per HACCP Plan. This noncompliance is a repeated noncompliance and is being linked to noncompliance (#173) JDD5422121809N/1 dated 12/9/2013; (#170) JDD2423120405N/1 dated 12/5/2013, (#167) JDD 1623110427N/1 dated 11/27/2013 and (#134) JDD5821101818 dated 10/17/2013 for the same cause respectively.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5008124 214N-1	12/14/2013	04B03	Labeling - Net Weights	C	<p>On 12/14/2013 at approximately 0540 hours while monitoring Weigh & Price, I observed the following. As the Night Shift was finished in Weigh & Price Production Supervisors and Quality Control were leaving for the Day, I left Weigh & Price to ensure other production areas were finished. I again passed through the Weigh & Price area at approximately 0550 hours on my way home when I observed establishment personnel boxing out product in Weigh & Price. I went to the Production Supervisors office and the Quality Control office but everyone was gone. I went to NCDC to see if a QC person was monitoring the Net Weight process. An employee placing the cases onto a pallet said QC already went home. I asked for a Supervisor and found (B)(6) in the NCDC loading area. I asked if he frequently operated without Quality Control personnel monitoring the Weigh & Price function. He said that Weigh & Price personnel normally do not go home so early. The employee palletizing the product said they were expecting approximately 40 cases. I checked a case of wings and a case of B/S breast for Net Weight compliance using a nearby QC Scale and found that none of the packages were in compliance (net or better). I explained (B)(6) at the scale that the weight on the consumer packaging label should be the weight of the product plus the tare. The product including 3 cases of 00510 wings for order 704201, 22 cases of b/s breast for order 708001 and 8 cases of 00510 wings for order 702500 were placed under USDA retained until being released for rework at 1719 hours on 12/16/2013. A review of the establishments computer showed that the last entries in Weigh & Price by Quality Control were made at 0512 hours and 0531 hours. No checks were made of the wings and B/S Breast packed at 0550 hours. A review of the establishments' Master Container Net Content Compliance Testing Program - RTC Plants under responsibility states ' It is the responsibility of QC personnel to follow this procedure when sampling product for net weight compliance purposes. There were no QC personnel available. The product was for a Sunday order and with the day shift coming in at 0930 hours until orders were filled; there was no reason to by pass normal Quality Control Net weight procedures. My findings indicated a noncompliance with 9 CFR 442.1, 9 CFR 442.2 and NIST Handbook 133.</p>

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5112	M18909	JDD2423123 713N-1	12/13/2013	01D01	SPS Verification	C	On 12/13/2013 at approximately 1323Hrs, I observed standing water/fluid approximately 3" deep at the cooler #3 drain and extended outwards from the drain approximately 3' x 3'. The drain runs across the entire hallway. The floor drain appeared to be backing up in the cooler #3 hallway. At this time the Boning Room was performing a shift washdown. The wheels of three tanks which contained edible food products and 2 tanks of clean ice were staged in the standing water/fluids. (B)(6) was notified and observed the overflowing drain. Ms. (B)(6) called to the personnel in the Boning Room to check their drains. She had the cooler #3 traffic stopped. The affected area was cleared of the water/fluids (fat, skin, meat) debris. The area was cleaned and sanitized. All of the wheels were sanitized. The food traffic area resumed at approximately 1329Hrs. I observed the restored sanitary conditions no U.S. retain tag was applied. I did not observe any direct food product contact adulteration at this time of my observation. The standing water at the drain was creating insanitary conditions that may lead to product contamination and/or a potential cross contamination when the tanks are moved to production areas. This observation is in violation to the relevant regulation cited above. Joe Lemos, Supervisor was notified of the noncompliance.
5129	M210	LQN301812 3513N-1	12/13/2013	01D01	SPS Verification	C	On December 13, 2013 while performing a routine patrol of the oven control room I observed noncompliance with SPS regulatory requirement(s) 416.2(b)(1) & 416.2(b)(2). At 16:11 hours I observed three large cracks running down the east, white painted wall located at the end of (B)(4) chiller #3 and oven #7; two of the cracks had areas of paint beginning to chip away from the wall, the cracks run from the ceiling to the base of the wall. Mr. (B)(6) was verbally notified and shown the noncompliance. This NR serves as written notification of a SPS noncompliance; as well as notification that failure to comply with regulatory requirement(s) may lead to additional regulatory or administrative actions as described in 9 CFR 500.4.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA0817122 613N-1	12/13/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On December 12, 2013 at approximately 0130 hours, after the establishment had finished their pre-operational sanitation inspection and prior to the start of operation, I observed noncompliance with SSOP Regulatory Requirement(s) 416.13(c), SPS 416.4(a), and 416.4(b). While performing my pre-operational sanitation inspection in the Raw Side Department I observed Rust on the inside of the Large Spice Bin (product contact). I observed one small piece of meat on the inside surface of the stainless steel bucket that is used to measure and weigh ingredient (product contact). I observed several pieces of meat on the bottom side of the small dumper platform (non-product contact). U.S. Reject Tag NO. B38937058 was applied to the Bin and Bucket. Mr. (B)(6), Ms. (B)(6), and Ms. (B)(6), was informed and showed the noncompliance. Immediate corrective action was implemented by management. The Spice Bin, Stainless Steel Bucket, and Dumper was Re-washed, Sanitized, and Re-inspected. After sanitary conditions was restored U.S. Reject Tag NO. B38937058 was removed. This does not comply with Regulatory Requirement(s) 416.13(c); which states in part: "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's, 416.4(a); which states in part: All food -contact surfaces must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product", 416.4(b); which states in part: "Non-food-contact surfaces must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions". This NR is lined to NR#FFA5203122903N/1 dated 12/03/13 for a similar noncompliance on Pre-op Product Contact Surface. This document serves as written notification that continue failure to comply with regulatory requirement(s) of 9 CFR Part 416 could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH391312 5713N-1	12/13/2013	01C02	Operational SSOP Review and Observation	C	#198At approximately 0842 while performing an operational sanitation observation and review task shortly after the beginning of the shift I observed insanitary conditions in the thigh deboning/rotisserie department of room two. I observed fat and debris, puddled water, thigh trimmings, and a pile of bones along the thigh deboning line and in the traffic area between thigh and rotisserie pack out conveyors. The work area was totally congested with hardly any space to allow for wash down or cleanup of any sort while employees are working on the line. There is also a problem with proper drainage in the area. The requirements of 416.11 and the establishment's SSOP plan which requires that (B)(4) (B)(6) was notified and US tag #B38075645 was assigned to the noncompliance. The employees were removed from the line so that the floor area and stands could be washed to an area where the water and debris could drain properly. The line was released after sanitary conditions were restored.
5308	M6137	BXL0418122 312N-1	12/12/2013	03J02	Slaughter HACCP	C	While reviewing the company computer records for CP's, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.5 (a)(1). The Salvage Parts Treatment (CP-19) for 12/11/2013, AM shift -Plant #1- had only three checks, at 0002 hours, 0254 hours and 0356 hours. The last check between the hours of 0500 and 0700 for that day was not performed. HACCP Plan -Slaughter Plant 1- under step #37 states in part: (B)(4) The process is designed to reduce the risk associated with the hazard. Parts are washed with (B)(4) water or (B)(4) to reduce bacterial contamination. Supplements 2,7,17,18,56. HACCP Supplement #56, Salvage Parts Treatment: CP-19 under procedure #4 states in part (B)(4) (B)(6) was informed about the noncompliance.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3804125 712N-1	12/12/2013	01B02	Pre-Op SSOP Review and Observation	C	On 12/11/2013 at approximately 2137 hours while monitoring the Establishments' Pre-Operational Sanitation standards in Plant #2, I observed the following. There was a yellowish pasty UFM (Unidentified Foreign Material) on the fingers of the second Picker on Line (B)(6). The fingers on the half of the unit randomly selected were scrubbed then rinsed with potable water restoring sanitary conditions by approximately 2145 hours. There was a heavy layer of a yellowish pasty UFM on the fingers of the third Picker on line (B)(6). There were numerous pieces to approximately 1/8" of tissue and feathers on the guide bars associated with the picker. The guide bar and the fingers on the half of the picker randomly selected were scrubbed then rinsed with potable water restoring sanitary conditions by approximately 2230 hours. (B)(6) was informed of the noncompliance. This is a recurring issue that has been discussed with the Establishment at previous morning meetings and has yet to be resolved. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.13(c) and 9 CFR 416.14.
5568	M20923	XUM582012 1912N-1	12/12/2013	01D01	SPS Verification	C	On 12/12/13, at approximately 1811 hours, while performing a directed Sanitation Performance Standards (SPS) inspection task on the Cooked Area by the entrance to Line (B)(4) I observed the following noncompliance: an overhead dome light CL-4-18 with chipping paint directly over exposed product being further processed on the transfer conveyor belt creating insanitary conditions, a noncompliance per 9 CFR 416.1 and 416.4(b). This condition could cross contaminate/adulterate exposed Pop Dog product being ran on the transfer belt in a post lethality processing environment. I took regulatory control by stopping the Line (B)(4) production and rejecting the area with US Tag # 24829894. I showed and informed Mr. (B)(6) of the forthcoming noncompliance. After corrective action were performed by production and sanitary conditions were restored, I relinquished the US Tag at 1832 hours. The requirements of 9 CFR 416.1 and 416.4(b) were not met.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ3913124 612N-1	12/12/2013	04A06	Poultry Finished Product Standards	C	On December 12, 2013 I, CSI (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is 100 points. My test at 0942 resulted in 43 points. At 0950 a retest was performed by (B)(6) using a tighten criteria of 25 points which failed with 32 points. I verbally notified (B)(6) of the noncompliance and that I would be issuing a NR. The plant implemented the required procedures for FPs failure. The Prechill nonconformances I observed at 0942 were: 3 ingesta < 1/16" (3 pts), 6 partial oil glands (6 pts), 2 whole oil glands (4 pts), 4 whole lungs (8 pts), 1 trachea < 1" (1 pt), 6 trachea > 1" (12 pts), 6 small feathers (6 pts), and 3 large feathers (3 pts). On October 18, 2013, NR # OIJ2416101418N (#80) was issued for processing noncompliance. The written response given is that Maintenance made adjustments to bring the process under control. This noncompliance is linked to NR # OIJ2416101418N (#80) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the October 24, 2013 meeting.
1325 7	P33900	NHH411112 2912N-1	12/12/2013	03J04	Poultry Zero Tolerance Verification	C	#197At approximately 0837 hours while performing a zero tolerance task on eviscerating line one I observed feces inside the lower keel area of the ninth sample bird. It was approximately 3/16" in diameter, olive green in color with a pasty consistency. The bird was shown to QA, maintenance personnel, and Management. The establishment failed to comply with the requirements of CFR 381.65(e). After investigating the incident, Maintenance found that the (B)(4) bottom cam was too high causing the opener arm to push intestines to the front of the birds. The cam was lowered so it would not lift the bird to high.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH550012 5412N-1	12/12/2013	06D02	Other Inspection Requirements	C	<p>On the night shift that began on 12/11/2013, at approximately 2125 hours I was in the picking room of Establishment 33900 P. This Establishment uses a batching system of inspection, if the carcass is condemned or hung back for re-inspection the paw condemn button is pressed and a batch of paws are condemned. This insures that all paws from condemned carcasses are also condemned. I asked a picking room employee to block the electronic eye on both lines for a second. If the paws were put into the drain, this would prove the establishment could segregate and discard the affected paws. The result of the test was that the establishment could not collect any of the paws that are used to show that all condemned paws would be captured and condemned. I talked to Dr. (B)(7)(C) the IIC on night shift and explained what I had observed and informed him that I was going to reject the paw system. Regulatory Control Action was taken by applying USDA Reject Tag #B38075846 to the system. After repairs to the system, at approximately 2130, another test was performed on the line #1 system and the results allowed the Establishment to begin collecting paws at 2230 Hours, after the system had been rinsed with (B)(4) water. The requirements of Regulation 381.76(b) were not being met. Refer to NR NHH2504123402N / 1 dated 12/02/2013 for similar noncompliance.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4420120 511N-1	12/11/2013	01C02	Operational SSOP Review and Observation	C	At approximately 0915 hours while monitoring the Establishment's Second Processing Rinse procedure, I observed the following noncompliance. While observing the shift change rinse in the Rotisserie Room, I was watching a sanitation employee rinsing near the (B)(4) tank, which had been covered prior to the rinse procedure with blue plastic. I noticed the end of the (B)(4) tank has a bracket attached to it that the large screen sits in while in use and the plastic covering the tank had not completely covered the end of the tank where the bracket attaches to it. There was a gap approximately 1" wide x the width of the tank. While the employee was rinsing, overspray from water hitting the outside of the injection machine went into the (B)(4) in the tank in the form of spray and from dripping off of the plastic covering the tank. As the outside of the injection machine is not considered a product contact surface and is not cleaned as such, the overspray water contaminated the (B)(4). I immediately took regulatory control action and attached USDA Retain tag # B31 407354 to the tank. I immediately notified (B)(6) of the noncompliance. (B)(6) immediately had the employee drain the (B)(4) tank and rinse it, she then had them apply (B)(4) to the tank to ensure it was clean. The tank was then tested for (B)(4) the test strip read (B)(4), restoring sanitary conditions. I then released the (B)(4) tank back to production and removed my tag at approximately 0935 hours. My findings indicate a noncompliance with the regulatory regulations of regulations 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.4(d).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5617122 811N-1	12/11/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0900 hours while walking past the Post Chill Rehang area in Plant #1, I observed the following noncompliance. As I was walking by Drop #3; I observed a bird on the top of an almost full cardboard bin with black UFM (unidentified foreign material) on the hock. Upon further investigation I found 3 more birds on the top with black UFM on the hocks. I immediately took regulatory control action and attached USDA Retain tag #B31 407355 to the bin and notified (B)(6) of the noncompliance. (B)(6) had the bin of birds covered and removed for rework. He then notified the company employees working the line at rehang to watch for birds with the black UFM on the hocks and put them in stainless steel carts for rework as well. The bin of birds was reworked and I performed a recheck which passed at approximately 1721 hours, at which time I removed my tag. USDA (B)(6) was advised of the noncompliance. (B)(6) on further investigation found numerous birds exiting Chiller #1 with black UFM on the hocks. (B)(6) immediately advised Quality Control personnel of his findings so that they could take corrective actions. The company took corrective action by reducing the line speed and having employees trim the contaminated parts for the rest of the day. At approximately 1010 hours while performing a Finished Products Standards task on Line 6 in Plant #1, I collected a random 10 bird sample from the line and found 4 out of the 10 birds with black UFM on the hocks. I immediately stopped the line and informed QC and (B)(6) of my findings. They immediately started checking the birds that were on the line for UFM and pulled them off for rework. They then notified the employees to watch for UFM on the hocks and clean them. At approximately 1022 hours QC did a recheck on the line and it passed, bringing the process back in control. My findings as well as (B)(6) findings indicate a noncompliance with the regulatory regulations of regulations 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.4(d).</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA0216125 111N-1	12/11/2013	01C02	Operational SSOP Review and Observation	C	<p>On 12/11/2013 at approximately 1330 hours while performing my Operational Sanitation Inspection. I observed the following noncompliance. In the oven area between the (B)(4) chiller and ovens 3 and 4 there was numerous beads of condensation dripping from the over head beams. I informed and showed (B)(6) and (B)(6) the noncompliance. At the time of my observation I did not see any condensation dripping into the Frank racks. Mr (B)(6) immediately moved any racks that were close to the affected area and began to wipe down the condensation in my presence. This does not comply with the establishment written SSOP program which states in part: Objective; (B)(4)</p> <p>. This is also a violation of Regulatory Requirement(s) which states in part: 416.1; "Operate in a manner to prevent insanitary conditions", 416.4(d); "Product must be protected during processing", and 416.13(c); "Plant monitors implementation of SSOP Procedures". This noncompliance report serves as written notification that failure to comply with regulatory requirement(s) of CFR 416 could result in additional regulatory or administrative action.</p>
1326 1	M33901	HAY120912 4211N-1	12/11/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On the calendar date December 11, 2013 (Wednesday) at approximately 0715 hours while performing the Pre-Op SSOP Review and Observation task in zone 4 the following noncompliance was observed: I, CSI (B)(7)(C) observed two pieces of fat/meat present on the product belt of the Injector machine that's set up on the Individually Wrapped Individually Frozen, Line (B)(6). The pieces fat/meat had a brownish color and ranged from 4/16" to 7/16" in size. This belt is a product contact surface. The Injector Machine was rejected with U.S. Rejected tag #B39506491. Mr (B)(6) and Ms. (B)(6) were informed and shown the insanitary conditions. I informed Mr. Blanch that the conditions present on the equipment was from previous operations, he immediately had (B)(4) sanitation workers to reclean the Injector Machine. At 0730, zone 4 was released after equipment had been cleaned and sanitized. The establishment's SSOP, states that (B)(4)</p> <p>" Regulatory requirements were not met for 9 CFR 416.13(c) and 416.11. For similar noncompliance record with the same cause, refer to NR HAY1116095219N/1 dated 9/19/13 where the Plant Management Response states "the affected pieces of equipment were recleaned, rinsed, re-inspected, passed and sanitized."</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3814124 510N-1	12/10/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0850 hours, while monitoring the change-shift rinse procedure at the rehang area #2, I observed the following: (B)(4)</p> <p>(B)(4) Two carts and a table that the USDA Graders used to inspected the birds &nbsp;for Grade A, located at the beginning&nbsp; of the sorting lines were not sanitized with (B)(4). The table that&nbsp;USDA&nbsp; used to performed the FPS post-chill check&nbsp;and&nbsp;is located between the chillers was also not sanitized with (B)(4). The SSOP Plan states in part under Second Processing Rinse Procedure that (B)(4)</p> <p>(B)(6) was nearby and I asked her if the area was finished, she had all her checks done and sanitation personnel were also finished. I&nbsp;informed&nbsp;(b) (6) &nbsp;about the noncompliance. She informed (B)(6) of the deviation.&nbsp;(B)(6) &nbsp;and sanitation employees, rinsed and sanitized the carts and the tables. At approximately 0915 hours the area was released. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.13 (b) and 9CFR 416.13 (c).</p>
5308	M6137	BXL5317123 410N-1	12/10/2013	03J02	Slaughter HACCP	C	<p>At approximately 1400 hours while performing HACCP Slaughter Record Review Task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.4 (a)(2)(iii). The HACCP Monitoring Log-CCP 1B-Salvage Parts Inspection dated on 12/06/2013, Plant #2 AM shift&nbsp;"Records Review" was not&nbsp;performed by Quality Control or designee. The HACCP Plan Slaughter Plant&nbsp;#1, States in part under Verification Procedures that (B)(4)</p> <p>(B)(6) informed (B)(6) of the noncompliance.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2123123 409N-1	12/09/2013	04B01	Labeling - Product Standards	C	On 12/09/2013 at approximately 1552Hrs, I observed a noncompliance to 9 CFR 381,129(6)(i) in that "Raw poultry product whose internal temperature has ever been below (b)(4) may not bear a label declaration of "FRESH". Raw poultry product bearing a label declaration of "fresh" but whose internal temperature has ever been below (b)(4) is misleading. In the Bagging Department, I observed plant personnel taking (b) (4) Fresh Young Organic Turkey out of their bag. They took two birds to the line and put the birds into Fresh Young Turkey bags (Foster Farms) at the Bag Line. Using a company calibrated thermometer, I took the temperature of the two turkeys which were bagged on the line. My temperatures were (B)(4) and (B)(4). I notified (B)(6) and showed him my findings. (B)(6) and Dr. (B)(7)(C)SPHV were notified of the noncompliance. U.S. Retain Tag NO:B39554627 was applied to the birds found with temperatures below (B)(4) Ms. (B)(6) took temperature of the (b) (4) Fresh Turkey's. She found ten more birds with temperature (B)(4) & (B)(4) She had all 12 birds with temperatures below (B)(4) put into a tank. She will notified Boning Room Supervision of the issue. The retain tag will remain pending plant decision.
5112	M18909	JDD3707124 809N-1	12/09/2013	01B02	Pre-Op SSOP Review and Observation	C	At 0200 H PST I was asked to do PRE-OP in Boning Room and I observed the following issues: 1) By wing belt, the overheads had black UFM on it., 2) 2nd grinder for MDP had poultry residue on it., 3) Conveyor off of Drum Machine had peeling surfaces coming off of the Cutting Board Type Material., 4) In Raw Fab the Switch on the Stand for large grinder had poultry residue on it. Mr. (B)(6), Mr. (B)(6), and Mr. (B)(6) were notified of the noncompliances. No documentation of these was observed. Mr. (B)(6) was also advised of missing wear guides on conveyor feeding the MDP PRE-GRINDER. This is a violation of the Establishment's written SSOP program and the above 9 CFR's. This is linked to the following NR 171-2013, Dated 12/07/2013, JDD3907120807N/1 and it's associated JDD numbers.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5422121 809N-1	12/09/2013	03J04	Poultry Zero Tolerance Verification	C	On 12/09/2013 at approximately 1825Hrs while performing my PHIS Zero Tolerance fecal check, I observed visible fecal material on the first bird sampled out of the ten whole body Consumer Tom Turkeys sampling test. The feces was found on the upper third of the right thigh in front of the longitudinal axis of the thigh bone or femur. The fecal material was non granular; uniformly green in color; moist and pasty consistency with the distinct odor consistent with fecal material. The fecal material was approximately 10mm x 3.5mm in size. U.S. Retain Tag NO:839554628 was applied to the affected carcass. (B)(6); (B)(6), (B)(6) and Dr. (B)(7)(C), SPHV were notified of the noncompliance and shown the affected carcass. Dr. (B)(7)(C) concurred that it was fecal material. Ms. (B)(6) immediately implemented the establishment's corrective actions. She had the affected turkey reconditioned by trimming and (B)(4) spraying and reinspection. At approximately 1913Hrs the turkey was released back to production after verifying the plant's corrective actions and reinspection. Ms. (B)(6) conducted her rechecks after the final wash and they passed. This observed incident of visible fecal material is a noncompliance to 9 CFR 381.65(e). Also it is in violation to 9 CFR 417.2(c)(4) monitoring at the critical control point to ensure compliance to the established CCP 4B (B)(4) after the final wash and before entering the chiller. At approximately 2138Hrs the plant's implemented corrective actions at the post chill were completed and passed by Ms. (B)(6). Ms. (B)(6) verified the checks. This noncompliance is being linked to noncompliance (#170) JDD2423120405N/1 dated 12/5/2013; (#167) JDD1623110427N/1 dated 11/27/2013 and (#134) JDD5821101818 dated 10/17/2013 for the same cause respectively.
5308	M6137	BXL1018121 509N-1	12/09/2013	01B02	Pre-Op SSOP Review and Observation	C	While monitoring the Establishments' Pre-operational Sanitation Procedures in Plant #2 (Evisceration), I observed a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4 (b) and 9CFR 416.13 (c). At approximately 0658 hours while inspecting Area #2, picker 1- Line (B)(6) I found in the scalders (unit #5) that it is next to the picker, white/cream color residue in the water covering the entire scalders. The residue appeared to be melted fat. I went to check the scalders for Line (B)(6) (unit #8) and found the same issue. (B)(6) was informed. He immediately drained the water from both scalders and had sanitation personnel rinsed and scrubbed both scalders. At approximately 0723 hours, I reinspected and found them to be clean, I then released the area.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3417120 109N-1	12/09/2013	01802	Pre-Op SSOP Review and Observation	C	At approximately 0855 hours while performing Pre-Op SSOP review and observation task in the (B)(4) room I observed the following noncompliance. While inspecting the Breast Tender Harvester conveyor belts I observed a large piece of dried breast meat left over from the previous shifts production, which was 2 days prior. The piece of breast meat was approximately 1 1/2" x 1/2" in size, it was located on the small belt that dumps the tenders into bins and tanks, it was on the side of the bracket, the bracket is in continuous contact with the belt. I also found ground up breast meat on the ends of the brackets and multiple tiny pieces along the edge of one of the brackets holding the belt, between the belt and the bracket. I immediately informed (B)(6) of the noncompliance. (B)(6) immediately had a sanitation employee clean and rinse the belt and brackets, restoring sanitary conditions by approximately 0905 hours. My findings indicate a noncompliance with the regulatory regulations of regulations 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.4(d).
1325 7	P33900	NHH030312 4510N-1	12/09/2013	01802	Pre-Op SSOP Review and Observation	C	On the night of production which began on 12/09/2013, Inspection performed scheduled PHIS procedure Pre-op SSOP Review and Observation in the Further Processing Department of 33900 P. This was after Sanitation had finished cleaning the equipment and QA had finished their Pre-operational inspection of the equipment and released the area for USDA inspection. There are no additional Sanitation or Pre-operational steps prior to the start of production. The following noncompliances were observed: At 2328 hours while checking the Truss Conveyor (Zone #13-Unit #11), Inspection found the Conveyor (Product contact surface) in an unsanitary condition: Weld Spots and tiny gritty and grainy particles. Inspection took Regulatory Control Action by applying US Reject Tag #B3075666 to the Unit until it could be recleaned and reinspected, and was released at 0046 Hours. At 2338 Hours while checking the Case Scale Infeed Conveyor (Zone #15-Unit #17) and also a Product Contace Surface, Inspection found the surface of the Belt in an unsanitary condition with a thin layer of grease that appeared to be several days old and could be scraped off with the fingernail. Inspection took Regulatory Control Action by applying US Reject Tag #B38075671 to the Unit until it could be restored to a sanitary condition and released at 0000 Hours. The Requirements of 9CFR 416.13(c) were not being met and (B)(6) was shown the noncompliance and advised that a Noncompliance Record would be issued. The items of Equipment cited were Stumble-on Finds. For a similar noncompliance refer to NR #NHH2522113213N/1 dated 11/13/2013. To date, all Preventive Measures may not have been implemented as described or were ineffective in preventing recurrence.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH291712 3709N-1	12/09/2013	01D01	SPS Verification	C	<p>On 12/09/2013 while performing an export task on the front dock at approximately 1650 hours, I observed rain water dripping excessively from the overhead bay doors of bay # 3, # 4, and # 5. Bay # 3 was the loading bay for the export load, bay # 4 was partially loaded with other product and bay # 5 did not have a trailer in it at that time. There were no precautions being administered that I could see or was told they were using to prevent the dripping water from contaminating the boxes containing the product. The rain water was contaminated and it was dripping from an unsanitized area. I tagged the affected bays with U. S. Retain/Reject tag #'s B38075968 for bay's # 3 and # 4 as they were being utilized and U. S. Retain/Reject tag # B38075655 for bay # 5 that was not in use at the moment. I advised Mr. (B)(6), and they were tagged and a noncompliance would be issued. Mr. (B)(6) had maintenance hang plastic to divert the dripping water and I removed my tags allowing the establishment to resume loading product on the trailers. No product was contaminated. This clearly violates CFR9 416.1; CFR9 416.2(b); CFR9 416.4(d) which states the establishment must operate in a manner to prevent insanitary conditions, maintain sound construction, good repair, and sufficient size, and protect the product during processing, handling, storage, loading, unloading, and transportation.</p>
5112	M18909	JDD3907120 807N-1	12/07/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>At 0450 H PST in evisceration I observed the following 1): In final gizzard defatter was a rock and poultry residue. 2): Five pieces of poultry residue in the cross over belt to Chiller A. 3): Numerous feathers in picking room. 4) Rosier had dripping condensation from overheads in to unit and one bagged bird with bag torn open found in the Rosier. The carcass was condemned. This is a violation of the Establishments written SSOP Program and the above CFR's. Mr. (B)(6), Mr. (B)(6), and Mr. (B)(6) were all advised or shown the Noncompliances. No note of these issues were in Q.C. Documentation. This is linked to NR #165-2013, Dated 11/19/2013 JDD3504114321N/1 and it's associated Linking JDD # and NR # 168-2013, Dated 12/03/2013, JDD22001218031N/1 and it's associated linkages.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1007123 807N-1	12/07/2013	01C02	Operational SSOP Review and Observation	C	<p>On 12/07/2013 at approximately 0225 hours while monitoring the Establishments' Sanitation Performance Standards in Plant 1, I observed the following. There was a clear fluid dripping from the side of a ceiling mounted ventilation duct above the Check/Weight lines near the final trim station access to line (B)(6). The fluid was dripping on to a blue wheel that supports the chain for line (B)(6) and the dripping onto the carcasses passing down Reprocessing line (B)(6) just prior to entering the Chilling System. The fluid dripping from a leaking ceiling on to carcasses was creating an insanitary condition. I contacted (B)(6) who was nearby and showed him the noncompliance. The line was stopped. Carcasses on Line (B)(6) were tanked off and placed on hold pending reconditioning. Plastic was affixed at the location to direct the fluid to a drip pan. A QC red tag was placed on a partial tank of birds for reconditioning. A steady rain was observed falling during a Good Commercial Practices procedure conducted at approximately 0200 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1) and 9 CFR 416.4(a).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1407123 607N-1	12/07/2013	04B04	General Labeling	C	<p>On 12/05/2013 at approximately 2000 hours while performing a Labeling procedure in the Weigh & Price Cooler (Finished Product A & B) observed racks of product in the general storage area as old as 11/29/2013. An employee was conducting an inventory at the time. I returned at approximately 2010 hours on 12/06/2013 to see if the old product had been culled. The cooler seemed to be colder than normal and my pocket thermometer registered temperatures between 22 and (B)(4) and (B)(6). Production was done so I waited until (B)(6) arrived at approximately 2145 hours. (B)(6) helped me with a company calibrated thermometer in the QC Office. In the Weigh & Price Cooler using the company calibrated thermometer I showed QC (B)(6) and the temperature of a couple of packages of Boneless Skinless Thighs that registered to (B)(4). I told her I would take up the issue with the Weigh & Price Supervisor. At 2245 hours again using the company calibrated thermometer I showed Weigh & (B)(6) the temperatures of several packages of boneless skinless product. The product below (B)(4) was confined to racks with dates of 12/04/2013 to 11/29/2013 except for 5 racks of Organics located on the 'B' side of the cooler that were dated 12/05/2013. 12 racks of (b) (4) and Foster Farms boneless skinless product and two racks of (b) (4) thighs labeled "Fresh" were culled and placed on hold for being too cold to be labeled as fresh. A printout from Refrigeration indicated that the Weigh & Price Cooler temperature was below (B)(4) the monitoring station for the entire day. A review of the HACCP Plan -Raw Intact -Packaging Step 12 (Shipping) states in part (B)(4). Supplement 35 under 'Crust Tunnel' states (b) (4) is <(B)(4)> and Note: (b) (4) (B)(4). The Establishments' Weigh & Price procedure does not include monitoring of Shipping temperatures. A check of Foster Farms Refrigerated Status Report for 12/6/2013 lists a target temperature for Finished Product 'A & B' Coolers as (B)(4). While the log registers temperatures every 4 hours for PLT1, PLT2, NCDC, Deli and DC 2 Coolers there is no documentation for the actual monitoring of Finished Product Coolers "A & B". A computer printout from Refrigeration from 11/30/2013 thru 12/06/2013 indicated that temperatures in the Weigh & Price Coolers varied between approximately 20°F and 25°F at the monitoring station. The product was released on 12/09/2013 and 12/10/2013 for down grading to</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA301412 1006N-1	12/06/2013	01D01	SPS Verification	C	<p>On Friday 12/06/13 at approximately 1350 hours while performing Sanitation Performance Standard Inspection in the Retail Fryer room area, I observed the extended space in the fryer room that is located to the left side of Fryer #8. In the open space beside fryer #8 I noticed there was evidence of a liquid substance that had run down the wall in two areas and there was some clear liquid dripping from the edge of the ceiling close to the beam that separated the open space from product fryer # 8. There were rainy weather conditions at the time of my observance. There were 3 unopened boxes of sticks that are used in the edible product process stored in the open space area. The unopened boxes of sticks were not affected by the unsanitary condition of the liquid substance. Production employee traffic was observed in the effected area however I did not observe any employees being affected by the falling liquid. (B)(6) and (B)(6) was notified. I observed as the unopened boxes of sticks were removed from the area and the maintenance department immediately closed the area off to stop any further production employees traffic until the process was under control. I observed as (B)(6) instructed the employees not to enter the effected area until corrective action were complete. No FSIS regulatory control tag was provided because I observed as (B)(6) took immediate corrective action. No product or product contact surfaces were affected. (B)(6) came by the FSIS office at approximately 1425 hours to inform me that the maintenance department had taken action in the ceiling to prevent any further leaking conditions in that area. He also said that maintenance would continue to monitor the area to assure sanitary conditions were maintained. -A similar noncompliance was observed on 08/22/13 and documented by Inspector (B)(7)(C) on NR#AOA1222081022N/1 dated 08/22/13. The preventive measure (further planned action) provided by the establishment that states, (B)(4) appears to be ineffective in preventing this noncompliance. -This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s). -Continued failure to meet regulatory requirements can lead to enforcement actions described in 9 CFR 500.4.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0518121 806N-1	12/06/2013	01D01	SPS Verification	C	At approximately 1020 hours while walking through the packaging area, I walked by Line (B)(6) (the Leg Processors) and observed the following noncompliance. While walking by the leg processors I observed the bottom of the drip pan directly above Leg Processors #11,12,13 and 14 had what appeared to be heavy beaded condensation; the full length of the drip pan. I was informed by the Line lead person that it was over spray from the shift change wash down that had not been cleaned. The over spray was dripping all around the line. I immediately informed (B)(6) of the noncompliance. (B)(6) immediately had a plant employee stop the line and remove the product from the line. (B)(6) then had sanitation wipe down the drip pan, restoring sanitary conditions. My findings indicate a noncompliance with the regulatory requirements of regulations 9CFR 416.1, 9CFR 416.2(d), 9CFR 416.4(b) and 9CFR 416.4(d).
5310	M6137B	FFA5818120 006N-1	12/06/2013	01D01	SPS Verification	C	On December 06, 2013 at 1520 hours while walking to the oven room I observed insanitary conditions. I observed franks all over the floor in front of Oven #1 and Oven #2. At the time of my observation I did not see any supervisor in the area nor did I see anyone cleaning up in this area. Ms. (B)(6), and Mr. (B)(6) was informed. Immediate Corrective Action was implemented by Management. Product was condemn and the floor was cleaned and sanitized. At approximately 1533 hours after performing my product temperature check on product in oven number #3, I observed rust on the overhead beams in front of Oven #4 and Oven #3, I also observed on the overhead unit in front of Oven #4 Rust on the bottom of the unit drip pan (product traffic areas). This unit was brought to management attention in the weekly meeting dated 10/08/13. I left a voice mail for Mr. (B)(6) and also informed Ms. (B)(6) about the noncompliance. This does not comply with Regulation 416.1 which states in part: "Each official establishment must operate in a manner to prevent insanitary conditions", 416.2(b)(1) which states in part: "Establishment buildings, compartments must be kept in good repair", and 416.4(b) which states in part: "Non-food contact surfaces of facilities, equipment, and utensils must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". This document serves as written notification that failure to comply regulatory requirement(s) could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM451312 3106N-1	12/06/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 645 hours, while performing a routine Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 1, Raw side of the establishment: I found few pieces of food particles on hopper pipe, from the previous day of production. Upon continuing my inspection: Line 1 I found small piece of food particles on hopper A , hopper B and C4 conveyor belt, also from the previous day of production. All finding described in the non-compliance were on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. I took a regulatory control action and applied USDA retain/rejected tag# B24829889. I informed (B)(6) and (B)(6) of the non-compliance. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0720 hours. Plant SSOP Section1, page1, states: (B)(4) ". 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2423120 405N-1	12/05/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 12/5/2013 at approximately 1645Hrs while performing my PHIS Zero Tolerance fecal check, I observed visible fecal materials on the 7th. bird sampled out of the ten whole body light hen turkey sampling test. The fecal material was inside the turkey's pelvic and kidney area. U.S. retain Tag NO:B39554890 was applied to the affected carcass. The size of the fecal materials were approximately 1/2" x 1/4" on the turkeys pelvic cavity and approximately 1/4" x 1/8" in size on the kidney. The fecal was greenish in color, semi-solid in nature with the distinct odor consistent with fecal material. The line two ten bird random sample was collected after the final wash and before entrance into the chiller by the establishment's (B)(6). I notified and showed the fecal materials to Dr. (B)(7)(C), SPHV; (B)(6) and (B)(6) and Dr. (B)(7)(C) concurred that it was fecal material. Dr. (B)(7)(C) and I watched as (B)(6) using a knife removed the feces from the turkey. She put it on the top side of her left gloved hand. She moved the fecal around with the knife and smelled it. She then put the fecal back into the turkey (not in the site found and the fecal was not the amount that I had found). I hung the turkey inside the product wash cabinet for reconditioning and requested to be present for the reconditioning. Ms. (B)(6) conducted her required fecal checks after the final wash and they passed. At approximately 1730Hrs I watched (B)(6) put the affected turkey on the USDA table and then she took a picture of the fecal inside the turkey. She had the turkey reconditioned by (B)(4) and trimmed. The turkey was released back to production at approximately 1734Hrs after verifying the reconditioning and reinspection. This observed incident of visible-fecal material is a noncompliance to 9 CFR 381.65(e). Also is in violation to 9 CFR 417.2(c)(4) monitoring at the critical control point to ensure compliance to the established CCP 4B (B)(4) after the final wash and before entering the chiller. At approximately 2005Hrs the plant's implemented corrective action at the post chill were completed and passed by Ms. (B)(6). Ms. (B)(6) verified the checks (B)(6) was notified of the noncompliance. This noncompliance is being linked to noncompliance (#167) JDD1623110427N/1 dated 11/27/2013; (#134) JDD5821101818N/1 dated 10/17/2013 and (#112) JDD1623092204N/1 dated 9/4/2013 for the same cause respectively.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0916121 505N-1	12/05/2013	04A06	Poultry Finished Product Standards	C	At approximately 1248 hours while performing a Poultry Finished Products Standards check on Line# in Plant 2, I observed the following noncompliance. After removing a 10 bird sample from Line (B)(6) I found 3 birds with split tails with airsacculitis exudates remaining. I immediately informed (B)(6) and (B)(6) of the noncompliance. (B)(6) asked me to do a recheck immediately, at which time I found 1 more bird with airsacculitis exudates remaining. (B)(6) immediately started tanking birds, with all split tail and missing tail birds being retained. Another person was added to vacuum and I performed another recheck at approximately 1316 hours that passed, bringing the process back in control. QC put their hold tag on the tank for rework. QC rechecked the tank of birds and released it back to production at 1404 hours. My findings indicate a noncompliance with the regulatory requirements of regulations 9CFR 381.76(b) and 381.84.
5308	M6137	BXL2104124 805N-1	12/05/2013	01C02	Operational SSOP Review and Observation	C	On 12/05/2013 at approximately 0055 hours in the MV Cooler there was a partial stack of brown product tubs with a few specks of black UFM (Unidentified Foreign Material) on the outside. I separated several of the tubs and found more black specks inside. I observed the area for several minutes and production personnel were using the brown product tubs from another pallet closer to the door. The tubs were on a wooden pallet covered with blue plastic. A second stack of brown product tubs on the same pallet still had a lid on top and was partly wrapped with clear plastic. The plastic wrap is used by the establishment to identify clean product tubs. I contacted (B)(6) and showed him the noncompliance. The tubs were taken to the tub wash room. In the tub wash room, I checked several more of the tubs from the affected stack and found two pieces of wood measuring approximately 1/2" by 1/8" in two separate tubs. There were also numerous specks of black and brown UFM to approximately 1/4" on several of the tubs. Approximately half of the tubs in the stack were dirty. A check of the Establishments' 12-05-2013 SSOP Daily Implementation and Monitoring Log for the shift in the MV Cooler at 2341 hours (B)(6) found everything in the cooler to be acceptable. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(a).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH010312 5705N-1	12/05/2013	01C02	Operational SSOP Review and Observation	C	<p>On the night of production that began on December 3, 2013 at approximately 0408 hours while performing Sanitation Performance Standards verification activities in room 1 Further Processing, a plant employee was observed using a floor hose with his gloved hands to spray off his boots.&nbsp;The employee then went to the breast processor line and began putting product into the machine without washing or sanitizing his gloves.&nbsp;The line was rejected and the product retained with US tag B38075664.&nbsp;Mr. (B)(6), and Mr. (B)(6) were notified of the noncompliance.&nbsp;Inspection observed as sanitary conditions were restored to the breast processor and belts.&nbsp;The product, approximately 150 pounds of breast meat, was taken to the wash station and washed with (B)(4) water.&nbsp;Mr. (B)(6) stated "The employee would be retrained" as a preventive measure.&nbsp;The regulatory control action was then released.&nbsp;Mr. (B)(6) was informed the noncompliance would be documented on a noncompliance record and that due the staffing shortage and the associated time constraints the NR would not be issued to the plant until the following shift. Refer to NR NHH2202094917N/1 dated September 17, 2013 for a similar noncompliance.&nbsp;The preventive measure for this noncompliance was (B)(4).&nbsp;These measures may have been implemented incorrectly or may have been ineffective at preventing recurrence.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0623123 204N-1	12/04/2013	01C02	Operational SSOP Review and Observation	C	<p>On 12/4/2013 1745Hrs Dr. (B)(7)(C), SPHV and (B)(6) went to the Quality Control Lab during our record review as part of my Operation Sanitation (SSOP) records review task for 12/2 & 12/3/13 dates. I found the establishment failed to make available the SSOP monitoring verification record performed by the plant Quality Control on 12/3/2013 for the "A" shift's Evisceration production. The shift "A" was scheduled for 7.87Hrs and was in operation for approximately 8Hrs. This production time of approximately 8Hrs with no available SOP monitoring verification record is a violation to 9 CFR 416.16(a) which states in part; "each official establishment shall maintain daily records sufficient to document the implementation and monitoring of the Sanitation SOP's..." This is also in violation to the plant's page one: Personnel Responsibility Monitoring and Sanitation SOP's which states in part; (B)(4)</p> <p>" (B)(4)</p> <p>"&nbsp; (B)(6) pulled the records out of the plant's file for us. Dr. (B)(7)(C) verified that the record was missing from the 12/3/13 filed SOP's. (B)(6) was notified of the missing record. She looked for the record and when she could not find the record she notified (B)(6). Ms. (B)(6) also verified the record was not available. Ms (B)(6) was notified of the record keeping noncompliance.</p>
5308	M6137	BXL2719122 104N-1	12/04/2013	03J04	Poultry Zero Tolerance Verification	C	<p>While performing Zero Tolerance Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4). At approximately 1317 hours, (B)(6) removed a 10 bird sample from Line #1 in Plant #1, I found one out of the ten birds with visible fecal contamination outside of the bird between the neck and the wing area. The fecal material was dark green in color, pasty in texture and measured approximately 1/4" wide by 3/4" long. This exceed the limit of Zero Tolerance for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at approximately 1346 hours and it passed. This is a violation of the critical limits of CCP-2B (B)(4) of the Plant's HACCP Plan for Slaughter.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3119122 104N-1	12/04/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1325 hours, while monitoring the mid-shift rinse procedure at the rehang area #1, I observed the following: (B)(4) as prescribed in the SSOP Plan. The drip pan that is attached to the (B)(4) cabinet at the rehang area #1 and is identified as a food contact surface, was not rinsed and sanitized. The SSOP Plan states in part under Second Processing Rinse Procedure (B)(4). This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.13 (b) and 9CFR 416.13 (c) (B)(6) and (B)(6) were notified about the noncompliance.
5308	M6137	BXL4304123 504N-1	12/04/2013	01B02	Pre-Op SSOP Review and Observation	C	On 12/03/2013 at approximately 2200 hours while monitoring Pre-Operational Sanitation Procedures in Plant 1, I observed the following. There was heavy beaded condensation over a large area on the concrete ceiling between stations 4 and 8. The ceiling was mopped off by approximately 2220 hours. At approximately 2202 hours there was a pink colored slimy UFM (Unidentified Foreign Material) inside two air hoses used to agitate the chiller water for Chiller #2. The UFM filled several feet of each hose. The hoses were disconnected and flushed restoring sanitary conditions. (B)(6) was informed of the noncompliance. At approximately 2320 hours in Packaging Area 1, there were numerous black specks of UFM that smeared like grease/oil on the white wheels that hold the product during cutting on Leg Processors 4-6. There was pasty fat on the white nylon product portion of the ejector arm that moves the product from the shackle to the Leg Processor for Leg Processors 4 & 5. The area was recleaned restoring sanitary conditions by approximately 2325 hours. In Packaging Area #2, the (B)(4) Room, the white product cones on lines 1 are severely deteriorated with scuffs, scratches and deep cuts. The plastic pieces becoming part of the product is creating a Physical Hazard condition. The rough surfaces are also making it impossible to clean the cones efficiently. (B)(6) was informed of the noncompliance. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(a) and 9 CFR 416.13(c).

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM581412 3104N-1	12/04/2013	01802	Pre-Op SSOP Review and Observation	C	At approximately 0715 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 2, Cook side of the establishment: I found pieces of chicken stuck on (b)(4) scale bracket from the previous day of production. I took a regulatory control action and applied USDA retain/rejected tag# B24829879. I informed sanitation (B)(6) and (B)(6) and of the non-compliance. The finding described in the non-compliance was on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0755 hours. Plant SSOP Section1, page1, states: (B)(4) 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.
6036	P6164A	OIJ0908123 505N-1	12/04/2013	03J04	Poultry Zero Tolerance Verification	C	On December 4, 2013 at 1333 I, CSI (B)(7)(C) performed a routine scheduled Poultry Zero Tolerance task. I observed visible fecal material on one of the ten randomly selected carcasses. PHV (B)(7)(C) verified my finding. The 3/4" by 1/8" strip of fecal material was found on the left wingtip area consisting of dark green creamy material. I verbally notified (B)(6) of the failure and that a NR would be issued. The plant implemented their fecal failure program. The verbal response given as to the cause was the bottom nozzle of the New York wash cabinet was not working. The nozzle was replaced. A retest by QC found no further incidence of visible fecal present. The verbal preventative measure given was that the New York bird wash cabinet nozzles will be checked every half hour until December 13, 2013. Records show that there have been no fecal noncompliances since August 29, 2013 which was caused by the PNT rollers. Therefore, this NR is not linked to any other NR. The Establishment Awareness Meeting notes show the last time fecal noncompliances were discussed was on September 5, 2013.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2200121 803N-1	12/03/2013	01B02	Pre-Op SSOP Review and Observation	C	On 12/02/2013, I observed the following: (1) Belting needed trimmed up on Grader Belts; A and B.; (2) Poultry Residue on Contherm Seals, (3) Hand Wash sign in Boning by MDP is separating and appears to have mold growth, (4) Rusty Interior Motors and Pumps on all injectors, (I was told months ago they were to be sand blasted and reconditioned). (5) Observed a piece of loose plastic in Filter Part in Cooler Nine. (6) Six Stainless Steel Tanks from Sister Plant were found with product residue in them. (7) Yellow Checkweigh line has loose parts that need tightening. (8) Cracks in end chute off of the Breast Sorter. These were shown to Mr. (B)(6) and or Mr. (B)(6). Ms. (B)(6) was advised of these issues. This is linked to NR 0125-2013, Dated 10/3/2013 and its linkages.
5308	M6137	BXL0217121 403N-1	12/03/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1030 hours while performing Zero Tolerance Fecal Task, I observed three out the ten birds from each line in Plant #1, with black UFM (Unidentified Foreign Material) on the hock of the bird. I went to performed a Post-Chill Finished Product Standards at the exit of the chiller and found more birds with UFM on them. For the past two weeks at the weekly meeting USDA informed Management about the issue. USDA documented on MOI # BXL0111113927G and BXL4619114320G that CSI's and Line Inspectors saw black UFM on the hock of the birds. At approximately 0500 hours CS (B)(7)(C) informed (B)(6) about the same issue. This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.4 (a) and 9CFR 416.4 (d). (B)(6) was informed about the noncompliance.
5308	M6137	BXL5308122 903N-1	12/03/2013	03J02	Slaughter HACCP	C	On 12/02/2013 during the 0100 hour while performing a direct observation of the establishments' proffered IOBW Monitoring procedure from the Verification Plan, I observed the following. The Quality Control monitor performed a check verifying the sprayers, shower heads and pumps and the psi, timing, alignment, and improper shackling on the IOBW's on Lines (B)(4) and (B)(4). I did not observe her monitoring the IOBW on the reprocessing Line (B)(4). I later checked the computer records for the IOBW on Line (B)(4) and checks were performed at 1040, 1131, 1246, 0331, and 0425 hours. There was no record of a check being done at the 0100 hour, (lunch is during the 0200 hour). The Notice of Deferral Verification Plan #4 states in part (B)(4). I informed (B)(6) of the noncompliance. My findings indicate a noncompliance with regulatory requirements of regulation 9CFR 417.5(a)(1).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA5203122 903N-1	12/03/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On December 02, 2013 at approximately 0130 hours, after the establishment had finished their pre-operational sanitation inspection and prior to the start of operation, I observed noncompliance with SSOP Regulatory Requirement(s) 416.13(c) and SPS&nbsp;416.4(a). Raw Side Blending Room: I observed several specks of black unidentifiable foreign material on the inside surface of the Large Frank Hopper(product contact) and aslo several specks of black&nbsp;unidentifiable foreign material on one of the white shovels (product contact). U.S. Reject Tag NO. B38934391 was applied to the Hopper and Shovel. (B)(6) and (B)(6) was informed and showed the noncompliance. Immediate corrective action was implemented by management: The Hopper and Shovel was re-washed and sanitized. After sanitary conditions was restored U.S. Reject Tag NO. B38934391 was removed.This does not comply with Regulatory Requirement(s) 416.13(c); which states in part: "Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's, and 416.4(a); which states in part: "All food-contact surfaces, must be cleaned and sanitized prior to the start of production". This NR is linked to NR# FFA1704092319N/1 dated 09/19/13 for a similar noncompliance on Pre-op Product Contact Surface. Management written response in Part:</p> <p>" Employee was instructed to inspect the equipment and re-clean when necessary", " Maintenance was asked not to handle the equipment until it has been released during USDA inspection and to re-sanitize food contact surfaces when necessary".This document serves as written notification that continue failure to comply with regulatory requirement(s) of 9 CFR Part 416 could result in additional regulatory or administrative actions as described in 9 CFR Part 500.4.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM171212 5603N-1	12/03/2013	01D01	SPS Verification	C	At approximately 0945 hours, while performing a schedule routine SPS inspection task, on the cook side of the establishment, I observed the following noncompliance: Raw side of the production, I observed beaded and dripping condensation above air unit in front of wing cooler. I informed and showed to (B)(6) and (B)(6) of my finding. Immediate corrective action was performed by establishment upon notification of my finding. Plant SSOP Part 2 Operational Sanitation, Section 2, and Subsection B: Equipment and Facilities, Step 4 which states (B)(4). 9CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated". 9CFR 416.2(d) states: "Ventilation adequate to control odors vapors and condensation to the extent necessary to prevent adulteration of the product and the creation of insanitary condition must be provided". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.
6036	P6164A	OIJ1103121 903N-1	12/03/2013	01D01	SPS Verification	C	At approximately 1843 on 11-30-13, while I, CSI (B)(7)(C), was performing the scheduled Raw Non Intact HACCP PHIS Task in the IF area, (B)(6) asked to speak with me. At approximately 1844, she showed me a leak from the elbow of a pipe containing (b)(4). It was located above and west of the box sealer in the IF area. I visually verified the leak did not directly contaminate product and was not in a high traffic area for moving or staging product. At approximately 1845, I verbally informed (B)(6) that I was issuing a noncompliance record. The (b)(4) pipe leak was the creation of a condition which may lead to adulteration of product. At approximately 1856, with the assistance of establishment employees, a red condemn barrel wrapped with yellow caution tape was placed below the leak. At approximately 1857, I applied US Rejected/US Retained Tag # B37852253 to the red barrel. At approximately 2335, I was informed by (B)(6), the leaking (b)(4) pipe had been wrapped with plastic by maintenance. At approximately 2336, I visually verified the (b)(4) pipe had been wrapped and I removed the US Rejected/US Retained Tag # B37852253 I had applied to the red barrel in the IF area. This NR is not linked to any other recent NR for the same root cause.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH180312 3304N-1	12/03/2013	03C02	Raw Intact HACCP	C	<p>On the night of production that began on December 3, 2013 while in the HACCP office performing the records review portion of the raw intact HACCP task, the following was observed in the hazard analysis for rotis product. At the (B)(4) recirculation step of the rotis hazard analysis a biological hazard (Salmonella) was identified but was considered not reasonably likely to occur. The basis for this decision is outgrowth of the organism is controlled by keeping the (B)(4) below (B)(4) nbsp; The (B)(4) temperature control program and results of the SIP sampling are cited in the HACCP plan at the (B)(4) recirculation step as supporting documentation for this decision. nbsp; Mr. (B)(6) , was asked how the cited supporting documentation could justify that reusing (B)(4) that had previously been applied to raw poultry, the excess collected and subsequently reused and reapplied to additional raw poultry would not introduce a microbiological hazard into the process. nbsp; Mr. (B)(6) indicated he had no explanation. nbsp; Reuse of the (B)(4) was not addressed elsewhere in the HACCP or SSOP plans or in any prerequisite program and there were no antimicrobial steps in the (B)(4) recirculation process. nbsp; The establishment was reusing (B)(4) at the time. Mr. (B)(6) was informed the requirements of 9 CFR 417.2(a) and 417.5(a)(1) and 417.5(a)(2) were not met and the noncompliance would be documented on a noncompliance record. nbsp; For a similar noncompliance refer to NR NHH1404070929N/1 dated July 28, 2013. nbsp;</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH220412 2803N-1	12/03/2013	01C02	Operational SSOP Review and Observation	C	<p>On the production shift that began on 09/18/2013, at approximately 2130, I was in the Evisceration Room Department at Establishment 33900 P to perform a finished product standards procedure on Evisceration line#2. As I walked through the room on my way to the pre-chill station, I saw an oily rust colored liquid on the floor under the viscera shackle line on the #2 viscera line. This oily water was dripping from the greasy rail onto the edible viscera below. Regulatory Control Action was taken by rejecting the line with USDA Reject Tag #B38075842. Mr. (B)(6) was shown the non-compliance. The shackles were washed down with food grade chemicals and (B)(4) to remove the substance from the shackles by Sanitation, as a corrective action. I then released the line to production. The Preventive Measure given by Mr. (B)(6) was that (B)(6) would inspect the shackle line before production begins, for the rest of the week (12/03-12/06). Mr. (B)(6) was informed a Noncompliance Record would be issued documenting the noncompliance. The requirements of Regulations 416.1 and 416.13(c) were not being met.</p> <p>The Establishments SSOP plan objective is (B)(4)</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1608122 502N-1	12/02/2013	01C02	Operational SSOP Review and Observation	C	At approximately 2215 hours Food Inspector (B)(7)(C) on line 2 station 7 at startup observed black UFM (Unidentified Foreign Material) on the viscera. I collected several more sets of viscera and contacted Department (B)(6). There were numerous specks and flakes to approximately 1/4" on the fat on the gizzard and on other tissues (hearts, livers, intestines) that extended below the length of a normal hanging visceral. From the location of the UFM on the viscera it was obvious that the viscera was being dragged across some insanitary surface. The line was already stopped as it was out of sequence. A small number of viscera at stations 7 & 8 involved were condemned. A mechanic was called to address the issue. The line was repaired and after lunch I observed the same black UFM on the viscera at stations 7 & 8. The inspectors on stations 7 & 8 were told to condemn viscera hanging lower then a normal set of viscera until the end of the shift. (B)(6) was informed of the ongoing condemnation and the noncompliance. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.4(d), 9 CFR 416.4(d) and 9 CFR 416.14.
5308	M6137	BXL1808124 902N-1	12/02/2013	03J04	Poultry Zero Tolerance Verification	C	At approximately 0542 hours while performing a Zero Tolerance check on line 2 in Plant 1, I observed the following. After taking a standard 10 bird sample, I observed one bird with visible fecal contamination. The fecal material was inside the carcass adjacent to the opening cut on the left side. The fecal material was olive green in color, pastry in texture and measured approximately 1/4" by 1/8" in size. This exceeded the Zero Tolerance for the process to be in control. (B)(6) was shown the fecal material and the protocol for fecal failure was implemented. A recheck passed at approximately 0517 hours. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4), and the CCP-2B (b)(4) of the Plant's HACCP Plan for Slaughter.
5568	M20923	XUM112112 5102N-1	12/02/2013	01B01	Pre-Op SSOP Record Review	C	On 12/2/2013, at approximately 1857 hours, while performing a routine scheduled SSOP Pre-Op Record Review in the QC Lab, I observed the following noncompliance: while reviewing the SSOP Weekly Implementation and Monitoring Log dated 11/25/2013 the QC Representative with the initials (B)(6) identified an unacceptable finding at 06:40 hours during Pre-Op on Part 1 Pre-Operational Sanitation, Section 1 Raw Area, Unit 79 (front of GCO) and didn't document the corrective actions performed to the area, a noncompliance per 9 CFR 416.16(a). I showed and informed Mr. (B)(6) of the forthcoming noncompliance. The requirement of 9 CFR 416.16(a) was not met.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ0721125 102N-1	12/02/2013	01C02	Operational SSOP Review and Observation	O	<p>At approximately 2348 on 11-29-13, I, CSI (B)(7)(C) was observing sanitary conditions in the packaging area. I observed nineteen unwrapped trays of product # 90883 Jumbo Thighs stacked one on top of each other in two piles. The trays were located on either side of the thigh line belt immediately east of the thigh line wrapper. I observed the bottoms of the trays were in direct contact with product in the trays below them. It is reasonable to assume, considering the conditions I observed, there was direct product contamination. At approximately 2349, I showed (B)(6) (B)(6), the conditions and verbally informed her I would be issuing a noncompliance record. At approximately 2350, I observed (B)(6) and (B)(6), remove the product from the nineteen trays and place it in a brown tub. At that time, (B)(6) proposed a corrective action. To ensure the appropriate disposition of the product, the contaminated product would be salvaged according to the establishment's written Reprocessing Floor Salvage Program. I agreed. At approximately 2351, I took a regulatory control action and applied US Rejected/US Retained Tag # B37852254 to the brown tub containing the contaminated product. I observed the tub of retained product as it was moved to the packaging floor salvage station. At approximately 0030, after observing the process several times, I observed the establishment employee had finished individually washing and inspecting the contaminated product and putting it into another tub. This tub had a QC retained tag applied to it as per the establishment written salvage procedure. At approximately 0031, I removed the US Rejected/US Retained Tag # B37852254 from the tub and released the product. Later on the morning of 11-30-13, I verified the proposed preventative measure of retraining the establishment employee on the proper handling of trays had been completed. It was documented on the establishment's Employee Retraining and Monitoring Form as completed on 11-29-13. This NR is not linked to any other recent NR for the same root cause.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH130612 1002N-1	12/02/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At 0359 hours on the night of production which began on 12/01/2013, while performing required PHIS Poultry Zero-Tolerance task at the designated Line #1 Pre-chill station at est. 33900 P, after randomly selecting 10 slaughtered and eviscerated and chilled chicken carcasses for the subgroup test and having begun the test at 0358 hours, Inspection found fecal material on the 5th bird in the set. The fecal material was a dark green color and of a pasty consistency which would easily smear to the touch. It consisted of three pieces 1/4" in diameter and 1/8" in thickness, located on the inside of the breast area. (B)(6)</p> <p>(B)(6) was shown the carcass and he concurred that the material in question was indeed feces. Upon investigation, it was found that the cause of the fecal find was (B)(4). Plant Management's Measure to prevent recurrence was "Employee counseled; first step of Company Disciplinary Policy." The requirements of 9CFR381.65(e) and 417.2(c)(4) were not met and Mr. (B)(6) was advised that the incident would be documented on a Noncompliance Record. Refer to NR #NHH2304110330N/1 dated 11/30/2013 for a similar Noncompliance. Plant Management's measure to prevent recurrence was: (B)(4)</p> <p>(B)(6). To date all preventive measures may not have been implemented as described or were ineffective in preventing recurrence.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH250412 3402N-1	12/02/2013	06D02	Other Inspection Requirements	C	<p>On the night shift that began on 10/01/2013, at approximately 2215 hours I asked the Evisceration supervisor, Mr. (B)(6), to perform a test in the picking room of establishment 33900 P. This Establishment uses a batching system of inspection, if the carcass is condemned or hung back for re-inspection the paw condemn button is pressed and a batch of paws are condemned. This insures that all paws from condemned carcasses are also condemned. The result of the test was that the establishment could not collect any of the paws that are used to show that all condemned paws would be captured and condemned. I talked to Dr. (B)(7)(C) the IIC on night shift and explained what I had observed and informed him that I was going to reject the paw system. Regulatory Control Action was taken by applying USDA Reject Tag #B38075841 to the system. At approximately 2230 another test was performed on the line#1 system and the results allowed the Establishment to begin collecting paws from that line at 2300 Hours, after the system had been rinsed with (b)(4) water. At approximately 2305 another test was performed on line #2 paw system and the results displayed that the condemned paws could be captured and condemned. At this time I was on the line inspecting carcasses due to a staffing shortage. The Establishment began collecting paws from that system also. The requirements of Regulation 381.76(b) were not being met. Refer to NR NHH4600104801N / 1 dated 10/01/2013 for similar noncompliance.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY521912 3301N-1	12/01/2013	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of December 1, 2013 (Sunday) at approximately 1820h while performing the Operational SSOP Review and Observation task, I observed the following noncompliance during shift 2: I, CSI (B)(7)(C), observed a production employee pick up an empty cardboard roll from the floor and lay it on top of the freezer plate for line (B)(4) in the "IF" department. The plate freezer film was being replaced. The old cardboard roller had fallen on the floor. A production employee picked it up from the floor and laid it on the surface of the product freezer plate. No product was on the plate freezer, but the surface of the product freezer plate was contaminated by the cardboard roll from the floor. I immediately rejected the line with U. S. Tag #B34 913535 and informed the (B)(6) and Mr. (B)(6) (Shift 2) that there was SSOP noncompliance. In addition, Mr. (B)(6) was shown the empty cardboard roll and he was shown the area of the plate freezer that had been contaminated. In order to restore sanitary conditions, maintenance turned the freezer plate off. Mr. (B)(6) had the freezer plate rinsed and sanitized. As a preventive measure, he stated that the employee involved would be retrained. After corrective actions were completed at approx. 1845h, the regulatory control action (U. S. Tag B34 913535) was removed. (No product was contaminated.) The establishment's Standard Operating Procedures for Sanitation (Part 2; Section 1) states: (B)(4). Equipment was not maintained in a sanitary manner and ineffective SSOP monitoring failed to prevent equipment used to transport raw product to the freezer from contamination. In addition, the regulatory requirements for 416.13(c), 416.1, and 416.4(d) were not met.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH230411 0330N-1	11/30/2013	03J04	Poultry Zero Tolerance Verification	C	At 0339 hours on the night of production which began on 11/29/2013, while performing required PHIS Poultry Zero-Tolerance task at the designated Line #1 Pre-chill station at est. 33900 P, after randomly selecting 10 slaughtered and eviscerated and chilled chicken carcasses for the subgroup test and having begun the test at 0339 hours, Inspection found fecal material on the 1st bird in the set. The fecal material was a dark green color and of a pasty consistency which would easily smear to the touch. It consisted of one piece 1/8" in diameter and thickness, located on the outside of the bird on the upper right drumstick. (B)(6) was shown the carcass and he concurred that the material in question was indeed feces. Upon investigation, it was found that the cause of the fecal find was (B)(4). Plant Management's Measure to prevent recurrence was (B)(4). The requirements of 9CFR381.65(e) and 417.2(c)(4) were not met and Mr. (B)(6) was advised that the incident would be documented on a Noncompliance Record. Refer to NR #NHH5502112830N/1 dated 11/30/2013 for a similar Noncompliance. To date all preventive measures may not have been implemented as described or were ineffective in preventing recurrence.
1325 7	P33900	NHH331311 3930N-1	11/30/2013	03J04	Poultry Zero Tolerance Verification	C	At approximately 1136 hours I performed a 10 bird Zero Tolerance task at the designated check station on (b)(4) line. The first sample bird contained feces in the lower kidney crypt area just below the tail of the bird. It was a smear of about 1/4 of an inch, past, and bright green in color. On the third and fifth sample bird there visible feces bedded in the same location as the first sample and were close to an inch or more in diameter of the same consistency. After finding three incidents in the 10 bird sample and having knowledge of the amount fecal contamination we were having due to the bird size, I took official control action by stopping the line. I notified and showed (B)(6) the three birds. Maintenance began an investigation to determine the cause. Afterwards (B)(6) notified me that the high pressure rinse nozzle on the line had been readjusted. I then released line. Shortly afterwards I began doing a check at the final trim station to determine if the adjusted showerhead had taken care of the problem. About the seventh bird that I looked at had a glob of feces an inch or so in diameter inside the crypts under the tail. I allowed the bird to continue through the final rinse before the chiller entrance and when I removed it the fecal matter was still present. I showed this to (B)(6) and the line was stopped immediately. Further investigation was done and it was found that the IOBW had a busted hose. The line remained down until the hose was removed and replaced. QA was notified of the fecal failure.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1623110 427N-1	11/27/2013	03J04	Poultry Zero Tolerance Verification	C	<p>On 11/27/2013 at approximately 1554Hrs while performing my PHIS Zero Tolerance feces check, I observed visible fecal materials on the first bird sampled out of the ten whole body light hen turkey sampling test. One of the fecal material was lodged inside the turkeys pelvic cavity and the second was on the inside flap (same right side). U.S. Retain Tag NO: B39554892 was applied to the affected carcass. The fecal materials were approximately 1/4" x 1/4" (pelvic cavity) and 1/8" x 1/8" (inside flap) in size; greenish, with white material in it which is an (indicative of uric acid) in color, as per Dr. (B)(7)(C) SPHV, semi-solid in nature with the distinct odor consistent with fecal material. The line two ten bird random sample was collected after the final wash and before entrance into the chiller by the establishment's helper. I showed the fecal material to (B)(6) ; (B)(6) and (B)(6) Dr. (B)(7)(C) also was shown the fecal materials. Dr. (B)(7)(C) concurred that it was fecal materials. Ms. (B)(6) immediately implemented the establishment's corrective actions. She had the turkey reconditioning by trimming and (b)(4) water (b)(4) ppm spraying and reinspection. At approximately 1600Hrs the turkey was released back to production after verifying the plant's appropriate corrective actions and reinspection. Ms. (B)(6) conducted her rechecks after the final wash and they passed. This observed incident of visible-fecal material is a noncompliance to 9 CFR 381.65(e). Also is in violation to 9 CFR 417.2(c)(4) monitoring at the critical control point to ensure compliance to the established CCP 4B (b)(4)) after the final wash and before entering the chiller. At approximately 1919Hrs the plant's implemented corrective actions at the post chill were completed and passed by Ms. (B)(6) Ms. (B)(6) verified the checks. (B)(6) was notified of the noncompliance. This noncompliance is being linked to noncompliance (#134) JDD5821101818N/1 dated 10/17/2013 and (#112) JDD1623092204N/1 dated 9/4/2013 for the same cause respectively.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2504113 727N-1	11/27/2013	03J02	Slaughter HACCP	C	On 11/27/2013 at approximately 0145 hours in Packaging while monitoring sprayer functions required by the Establishments' Verification Plan that resulted from a Notice Of Intended Enforcement (NOIE) dated October 7, 2013, I observed the following. On Line ^{(B)(6)} there was an uncut gizzard with approximately 2" of intestine attached and two more pieces of intestines piled on top of a half breast. There was fecal material leaking from the intestines onto the half breast. I contacted ^{(B)(6)} . The half breast and intestines were scooped up and placed onto a yellow product tray. The immediate area of the belt was checked for more intestines but none were found. The half breast had not been packaged as it was a 'B' grade that would be sent to the end of the line for deboning. The fecal material on the half breast was light brown, creamy in texture and measured approximately 1" by 1/8" in size. As the product was coming from Plant #1 ^{(B)(6)} was called and shown the noncompliance. ^{(B)(6)} was called to perform immediate corrective actions. My findings indicated a noncompliance with 9 CFR 381.65(a), 9 CFR 381.65(e) and 9 CFR 417.2(c)(4).
5308	M6137	BXL3802113 427N-1	11/27/2013	01C02	Operational SSOP Review and Observation	C	At approximately 0500 hours while walking past Line #2 in Plant 1 I observed the following noncompliance. The heater duct that is directly above Station #8, Line #2 and the reprocessing line was covered in heavy beaded condensation that was dripping close to the line. I immediately informed ^{(B)(6)} of my concerns, at which time he began cleaning the heater duct with a sponge mop. The condensation dripped heavily from the mop spraying condensation on Station #8, Line #2 and Line ^{(B)(6)} which had birds on it at the time. I immediately stopped the line and ^{(B)(6)} finished cleaning the heater duct, at which time the lines and Station ^{(B)(6)} were rinsed off. The birds on the reprocessing line ^{(B)(6)} at Station #8 were condemned, restoring sanitary conditions by approximately 0535 hours. My findings indicate a noncompliance with the regulatory requirements of regulations 9CFR 416.4(b), 9CFR 416.1, 9CFR 416.4(d) and 9CFR 416.2(d).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4700112 527N-1	11/27/2013	01C02	Operational SSOP Review and Observation	C	On 11/26/2013 at approximately 0724 hours while monitoring Facilities in Plant #1 rehang area, I observed the following. There was (b)(4) spraying onto a light fixture from the (b)(4) Cabinet used to treat carcasses going into Packaging for lines (B) and (B). The fluid was dripping from approximately a 1 1/2 foot section of the light fixture into a tank of WOG's (with out giblets) being collected for the Rotisserie Room. The Rotisserie WOG's have already received there final microbial intervention. The light fixture is treated as a non-product contact surface. The fluids would rinse untold contaminants from the light fixture on to the finished product creating an insanitary condition. (B)(6) was called and after seeing the problem called for a mechanic. The partial tank of WOG's was reconditioned with (b)(4) water and returned to production by 0745 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d), and 9 CFR 416.2(b)(1).
5308	M6137	BXL5000115 627N-1	11/27/2013	01B02	Pre-Op SSOP Review and Observation	C	On 11/26/2013 at approximately 2145 hours while monitoring the Establishments' Pre-Operational Sanitation standards in Plant #2, I observed the following. There was a coating of a light brown pasty UFM (Unidentified Foreign Material) on the black fingers associated with the fourth Picker on line (B). The UFM was in the grooves and on the smooth surfaces of most of the fingers associated with the unit. (B)(4) was applied to the unit followed by a potable water rinse which removed very little of the UFM. The UFM was on the last three pickers on line (B) and was discussed at the morning meeting on 11/27/2013. At approximately 2204 hours there was three paint chips to approximately 1/2" by 1/8" medium gray in color on the incline belt that moves product from the Reprocessing Line (B) to the Chillers. The belt was rinsed with potable water restoring sanitary conditions. The top of the wall opening that the incline conveyor belt passes through is severely deteriorated with rust and peeling paint that is the same color as that found on the belt. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a), 9 CFR 416.2(b)(1), 9 CFR 416.13(c) and 9 CFR 416.14.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2618110 626N-1	11/26/2013	03C02	Raw Intact HACCP	C	On 11/26/2013 at approximately 1100 hours while performing a HACCP Raw-Intact Record Review Task, I found the following; the HACCP Monitoring Log -CCP 3B- (b)(4), Plant #2 Rehang, dated on 11/22/2013, PM shift had a concentration failure on one of the five sanitizer concentration checks. The first check at 1327 had a concentration of (b)(4) ppm of sanitizer (b)(4). The second check (Drop #7 top C) had (b)(4) ppm of sanitizer (b)(4). At the comments Quality Control or designee had "fail re-check, 1347 released". The following three checks were in compliance. I asked (B)(6) about the failure. The concentration and the location for the recheck were missing. She informed me that the corrective action was completed, Quality Control or designee did not document the recheck concentration of the sanitizer (b)(4) and the location for the failure on the corrective action Log. My findings indicate a noncompliance with the following regulatory requirements of regulation 9CFR 417.5 (a)(3). I notified (B)(6) of the noncompliance.
5308	M6137	BXL3018110 926N-1	11/26/2013	03J02	Slaughter HACCP	C	On 11/26/2013 at approximately 1100 hours while performing a HACCP Slaughter Record Review Task, I found the following; the HACCP Monitoring Log -CCP 2B- (b)(4) (Plant 2) PM Shift dated on 11/22/2013 at approximately 1019 hours, Line (b)(4) had a Zero Tolerance Failure by Quality Control. Production started performing corrective actions as the HACCP Plan for Slaughter Plant #2 stated. Corrective actions were performed and finished at approximately 1224 hours. The Pre-Shipment Records Review CCP 2B (b)(4) mid-Shift, was signed at 1201 hours. The signed documented certifies that the product is ready to be shipped. The Pre-Shipment Records Review, mid-Shift was signed before the corrective actions for the failure were completed. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 417.5 (c). I notified (B)(6) of the noncompliance.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN211811 0726N-1	11/26/2013	03J02	Slaughter HACCP	O	In regards to the establishment's corrective actions to the Notice of Intended Enforcement (NOIE), issued on 10/07/13; the following noncompliance has been noted. The verification plan included several antimicrobial treatments to mitigate bacterial pathogens. According to the Notice of Deferral Verification plan dated 10/13/13 (including the most recent revision dated 11/6/13), the establishment made a commitment to implement a pre-chill (b)(4) cabinet by 10/20/13 and monitor the (b)(4) concentration. In addition, per the verification plan, the establishment is to monitor the (B)(4) levels of the "Chiller Fresh Make Up" as well as the "Chiller Red Water" with acceptable levels of (b)(4) ppm FAC and (b)(4) ppm FAC, respectively. From 11/18/13 to 11/20/13, the establishment discontinued the use and monitoring of (b)(4) concentration for the pre-chill (b)(4) cabinets. Also, from 11/18/13 to the present, the establishment discontinued the use and monitoring of acidified (B)(4) in the chiller. These actions contradict the terms outlined in the Notice of Deferral Verification Plan, dated 10/13/13 (including the most recent revision dated November 6, 2013). Consequently, there is noncompliance with 9 CFR 417.5(a)1. The noncompliance referenced above was discussed with (B)(6), on November 22, 2013 by the FLS, Dr. (B)(7)(C) and EIAO (B)(7)(C).
5309	P6137A	NJN391211 5827N-1	11/26/2013	01C02	Operational SSOP Review and Observation	C	While I was performing an operational sanitation task in the fillet department, at approximately 1245 hours, I observed a mist of water raised from the area between (b)(4) # (b) & (b). When I went there to check the area, I found a plant employee washing down the floor using high presser water. I immediately stopped him because he over sprayed the portable incline conveyor as well as the products on the conveyor. I informed Mr. (B)(6), of the noncompliance and explained to him that the incline conveyor is too close to the floor which exposes the conveyor as well as the product to the splashes of contaminated water from the floor. Also, I suggested that using the squeegee is better during operations, to clean the debris. Mr. (B)(6) stopped the production line, washed and sanitized the conveyor, and sent the affected product to be reprocessed. The plant failed to comply with the regulations 9 CFR 416.1, 9 CFR 416.4(d), and protect the product from cross contamination.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3113110 025N-1	11/25/2013	03J02	Slaughter HACCP	O	On 11/19/2013 while reviewing the company's computer records for IOBW (CP-4), I observed the following. On Line #1 the frequency of one hour on one check was over by 28 minutes. On Line #2 the frequency of one hour on one check was over by 38 minutes and on reprocessing Line# the frequency of one hour on one check was over by 30 minutes. This is a noncompliance of the establishment not following the proffered IOBW Monitoring procedure. The Notice of Deferral Verification Plan #4. states in part "(B)(4) . I informed Quality Control (B)(6) of the noncompliance. My findings indicate a noncompliance with regulatory requirements of regulation 9CFR 417.5(a)(1).
1325 7	P33900	NHH232311 1625N-1	11/25/2013	01B02	Pre-Op SSOP Review and Observation	C	On the night of production which began on 11/25/2013, Inspection performed scheduled PHIS procedure Pre-op SSOP Review and Observation in the Evisceration Department of 33900 P. This was after Sanitation had finished cleaning the equipment and QA had finished their Pre-operational inspection of the equipment and released the area for USDA inspection. There are no additional Sanitation or Pre-operational steps prior to the start of production. The following noncompliance was observed: At 2035 hours while checking Line #2 Paw Unloader (Unit #1/Zone #3), Inspection found the Picker Fingers (Product contact surface) in an unsanitary condition with a greasy black residue which would easily rub off onto the hand. Inspection took Regulatory Control Action by applying US Reject Tag #B38075678 to the Unit until it could be recleaned and reinspected, and was released at 2124 Hours. The Requirements of 9CFR 416.13(c) were not being met and (B)(6) was shown the noncompliance and advised that a Noncompliance Record would be issued. The item of Equipment was randomly selected for Inspection as required. For a similar noncompliance refer to NR #NHH4423105223N/1 dated 10/23/2013. To date, all Preventive Measures may not have been implemented as described or were ineffective in preventing recurrence.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1609113 423N-1	11/23/2013	04A06	Poultry Finished Product Standards	O	On 11/23/2013 at approximately 0511 hours while performing a Post-Chill Finished Product Standards check in Plant #1 from Chiller#1, I observed the following. After taking a standard random 10 bird sample, I accumulated 12 nonconformance points. 5 of the 10 birds had black UFM(Unidentified Foreign Material) on the back side of the left hock. I contacted (B)(6) and informed him of the noncompliance. A QC recheck failed with 9 nonconformance points at 0539 hours. At this point the process is judged to be out of control. Post-Chill rechecks at 0546 hours and 0600 hours brought the process back into control. Post-Chill rechecks were performed every 30 minutes until the end of the shift. An employee was stationed near the (b)(4) to wipe off the UFM until the end of the shift. (B)(6) stated that it was determined that the UFM was caused by dirt on the shackles being transferred to the carcasses at the auto-rehanger and that a work order to acid wash the shackles over the weekend had been submitted. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv) (d)(3). and 90 CFR 381.65(a).
5309	P6137A	NJN150111 2923N-1	11/23/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 2235 hours, after the QC Technician had performed Pre operational Sanitation and released the area for production, I went on to perform the Pre-operation Sanitation task in area five, new products room, section A (Rotisserie Line). While doing so, I observed a precipitation of salt residue inside the pipe of the (B)(4) tank from the previous production shift. The residue measured approximately a ¼ of an inch in thickness, whitish in color, and extended along the length of the pipe. The (B)(4) tank was rejected with US tag NO. B43303529. At 2255 hours, and after the restoration of sanitary conditions, I re-inspected and released the tank. I informed Mr. (B)(6), of the non compliance. The establishment failed to adequately monitor the implementation of sanitation SOP which in turn created insanitary conditions. This finding represents a non-compliance with 9CFR 416.13(c), 9CFR 416.4(a) and 9 CFR 416.1. Plant's written SSOP, part (1) Preoperational Sanitation section 4 further Processing, dated 10/15/2013 revised, which states: (B)(4) ". Continued failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action as described in 9 CFR 500.4.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA4421113 522N-1	11/22/2013	01D01	SPS Verification	C	<p>On November 22, 2013, at approximately 0215 hours prior to the start of operation in the Blending Room I observed the following noncompliance. On the underneath side of the metal bar that runs across the large blender dumper I observed a sharp piece of metal and pieces of glue like material, this metal bar comes in contact with product, but at the time of my observation operation had not started. U.S. Reject Tag NO. B34377420 was applied to the dumper. Ms. (B)(6) and Ms. (B)(6) was informed and showed the noncompliance. Ms. (B)(6) was also informed. At approximately 0300 hours the metal bar was repaired and re-inspected by CS (B)(7)(C) and released after sanitary conditions restored. This does not comply with Regulatory Requirement(s) 416.1; which states in part: "Each official establishment must be operated and maintained in a manner to ensure product is not adulterated", 416.3(a); which states in part: "Equipment and utensils must be maintained in sanitary conditions so as not to adulterate product". This document serves as written notification that failure to comply with the regulatory requirement(s) of 9 CFR 416 could result in additional regulatory action as described in 9 CFR 500.4.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0905114 121N-1	11/21/2013	01802	Pre-Op SSOP Review and Observation	C	<p>At approximately 2139 hours while monitoring the Establishments Pre-Operational Sanitation Standards in Plant #2, CSI (b)(7)(F) observed the following noncompliance. While inspecting the Line 6 Stunner, I observed a large amount of sand, ingesta and feathers from the previous days production floating in the water at the bottom of the stunner. I immediately informed (b)(6) of the noncompliance. The stunner was cleaned, restoring sanitary conditions and released at approximately 2213 hours. At approximately 2151 hours while inspecting Picker #3 on Line 6, there was a brown residue buildup on the metal plates associated with the picker fingers, the residue easily scraped off with a fingernail. There were also numerous feathers all over the picker and a thick, slimy yellow film on the back side of the rubber curtain at the top of the picker. I immediately informed (B)(6) of the noncompliance. The picker was cleaned restoring sanitary conditions by approximately 2215 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b) and 9 CFR 416.13(c). At approximately 2154 hours in Plant #1 (b)(7)(C) observed the following. There were several specks and smears to approximately 1/2" of black UFM (Unidentified Foreign Material) on the product contact surfaces of rehang belt and on the white rollers that support the rehang belt for line #1. There was black UFM that smeared like grease on the white nylon material covering the guide bar above the rehang belt. The nylon material was replaced. There was a piece of caulking coated with black UFM that appeared to be mold hanging loose from the drip pan located adjacent to the rehang belt. Sanitary conditions were restored by approximately 2217 hours. The Cropper for Line 1, at approximately 2213 hours, the shaft that extends into the carcass during production had varying amounts of black UFM. The unit was cleaned and released by approximately 2219 hours. At approximately 2220 hours there were flakes of black UFM measuring to approximately 3/8" by 1/4" on 2 chiller paddles near the line 6 carcass drop unit for product entering Chiller #1. The UFM was removed. At approximately 2222 hours there were several specks of black UFM on the paddle at the outflow side of chiller #2. There was a wear mark approximately 6" in length on the end of a paddle at the exit end of chiller #2 with loose metal flakes. A small loose piece measuring approximately 2mm by 1mm was removed. (B)(6) was present so I showed him the deteriorated condition of the paddle. There was several pieces of tissue to approximately 2" on the exit conveyor belt also from chiller #2. Sanitary conditions were restored by approximately 2225 hours. (B)(6) was informed of the noncompliance. In Rotisserie at approximately 2325 hours, the needles for the</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							<p>injection machine were installed in the injection machine and not out ready for inspection. The needles were removed, inspected and reinstalled. At approximately 2327 hours there was a large amount of brown UFM leaking from a gear assembly for the dumper unit. The brown UFM wipes off easily with any contact. A mechanic was informed. The area was recleaned. The brown UFM will continue to collect on the outside support bracket until repairs are made. At approximately 2328 hours there were several flakes of black UFM on the first two white product belts on the right side of the Rotisserie cone line. There was a piece of tissue measuring approximately 2" by 1/4" inside the white nylon injection belt at the out flow side of the injection machine. Sanitary conditions were restored by approximately 2330 hours. (B)(6) was informed of the noncompliance. In Packaging Area #1 at approximately 0000 hours there was brown UFM leaking from a gear assembly at the end of the overhead wing conveyor belt. The gear assembly associated with the belt located at the end of the belt near the elevator. The conveyor belt transports the wings from the (b)(4) Deboning room to the Packaging Area. The brown UFM was dripping from the unit onto a second flexible product conveyor belt directly below it. Plastic was attached to the assembly until repairs can be made. The area was recleaned and released by approximately 0025 hours. (B)(6) was informed of the noncompliance. In Packaging Area #2, the (b)(4) Room, there was a red paint chip measuring approximately 1/8" on a salvaged parts table near line #1. The fire fighting system piping mounted on the ceiling is painted the same bright red color. If on a chicken the bright red paint would be mistaken for a piece of blood. There were two white paint chips on a product belt along line #2. Paint issues in the (b)(4) Room were addressed at the morning meeting with establishment on 11/20/2013 and documented on MOI BXL4619114320G. Towards the end of Pre-Operational Sanitation the drains in the (b)(4) Room overflowed due to a plugged drain in the Paw Room. The water backs up in the (b)(4) Deboning Room, Plant #1 Cooler, and the Staging Cooler. Supervisors were called. Production was shut down on the loading dock and traffic through the plant 1 cooler was stopped. The drains were cleared. (B)(6) had the floors rinsed and treated with (b)(4). The (b)(4) Room, Cooler #1, and the Staging Cooler were released by approximately 0230 hours. The Paw Room was rinsed and treated with (b)(4) by approximately 0330 restoring sanitary conditions. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.2(b)(1), 9 CFR 416.2(e)(4), 9 CFR 416.3(a), 9 CFR 416.3(b) and 9 CFR 416.13(c).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4820110 321N-1	11/21/2013	03J02	Slaughter HACCP	C	<p>While reviewing the company computer records, I found the following; (b)(4) (CP-19) was not performed on night shift in plant #1 on 11/20/2013 and only two checks were performed on 11/21/2013 in Plant #1 night shift also. I asked (B)(6) for a print out of Salvage Parts Treatment results for these two days. She informed me later that the Salvage Parts Treatment Procedure was not performed on the 11/20/2013 in Plant #1, and on 11/21/2013 Quality Control performed only two checks. HACCP Plan -Slaughter Plant 1- under step #37 states in part : (b)(4) Justification for decision. (b)(4) Supplements 2, 7, 17, 18, 56. HACCP Supplement #56, Salvage Parts Treatment: CP-19 under procedure #4 states in part '(B)(4)'. This is a noncompliance with the following regulatory requirements of regulation 9CFR 417.5(a)(2).</p>
5309	P6137A	NJN451411 1322N-1	11/21/2013	04A06	Poultry Finished Product Standards	C	<p>At approximately 0915 hours, while performing the finished product standards check on the reprocessing line, I found seven carcasses that were contaminated with ingesta on the crop area, two of them having bruises. The size of the contaminated areas varied from ½ inch to 1 inch. Also, I found one bird with excessive amounts of feathers on its back and the wings. I immediately stopped the reprocessing line and showed Mr (B)(6), and Mr (B)(6), my findings and informed them of the forthcoming noncompliance. The plant failed to keep the reprocessing line in compliance with the federal regulations. 9CFR 381.89 states: "Any part of a carcass which is badly bruised shall be condemned and, if the whole carcass is affected as a result of the bruise, the whole carcass shall be condemned. Parts of a carcass which show only slight reddening from a bruise may be passed for food." 9 CFR 381.91(b)(1) states: " Any carcass of poultry accidentally contaminated during slaughter with digestive tract contents shall not be condemned if promptly reprocessed under the supervision of an inspector and thereafter found not to be adulterated. Contaminated surfaces that are cut shall be removed only by trimming. Contaminated inner surfaces that are not cut may be cleaned by trimming alone, or at an approved reprocessing station away from the main processing line, by any method that will remove the contamination, such as vacuuming, washing, and trimming, singly or in combination. All visible specks of contamination must be removed, and if the inner surfaces are reprocessed other than solely by trimming, all surfaces of the carcass shall be treated with (b)(4) water containing 0.01 ppm available (B)(4) "</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH420511 2521N-1	11/21/2013	04B04	General Labeling	C	On the night shift of production that began on 11/20/2013, I was in room #1 Further Processing department at Est.33900 P to perform post chill requirements on product exiting the line #1 chill system. When I started to collect carcasses for the line #2 chill system check the chillers were stopped and no carcasses were exiting the system. I asked the (B)(6) , how long the system would be down. Mr. (B)(6) explained the system was turned off for up to thirty minutes to separate the small Halah birds from the large Halah birds. I asked for the moisture protocol procedures that would determine the amount of moisture that the carcasses would retain from this stoppage. Ms. (B)(6) could not produce the document so Inspection could not determine if the establishment had met the requirements of 9CFR Ch.III Part 441.10.
1325 7	P33900	NHH460311 0921N-1	11/21/2013	03J02	Slaughter HACCP	C	At approximately 0300 hours on 11/21/13 while completing a HACCP Slaughter task from 11/18/13 inspection noted the following noncompliance. The records for CCP-1 on 11/18/2013 indicated the interval between CCP 1 monitoring checks exceeded the frequency of “(b)(4)” specified in the HACCP plan. For line 1, CCP 1 was monitored at 0334 hours and again at 0439 hours for a total interval of 65 minutes. Production on line 1 was ongoing during this entire interval. The requirements of 9 CFR 417.2(c)(4) and 417.5(a)(3) were not met. (B)(6) was notified of the noncompliance and informed it would be documented on a NR. For a similar noncompliance refer to NR NHH4602110812N/1.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4103115 220N-1	11/20/2013	01802	Pre-Op SSOP Review and Observation	C	<p>At approximately 2140 hours while monitoring the establishments Pre-Operational Sanitation Standards in Plant #2, CSI (B)(7)(C) observed the following noncompliance. There was whole chicken foot floating in a brown cloudy puddle of water in the bottom of the stunner. Sanitation immediately removed the chicken paw and the stunner was cleaned restoring sanitary conditions by approximately 2145 hours. At approximately 2145 hours there was a heavy layer of brown UFM (Unidentified Foreign Material) on the fingers for Picker #5 on Line (B)(6). The UFM easily scraped off with a finger nail. The unit was cleaned and released by approximately 0115 hours. My findings indicate a noncompliance with the regulatory requirements of 9CFR 416.4(a), 9CFR 416.1, 9CFR 416.13(c) and 9CFR 416.4(d). On 11/19/2013, CSI (B)(7)(C) while monitoring the Establishments' Pre-Operational Sanitation standards in Plant #1 made the following observations. At approximately 2152 hours there was greasy product residue and feathers on the guide bars associated with the Line #1 Hock Nicker. There was also dried product residue with black UFM (Unidentified Foreign Material) that appeared to be mold on support bracket near the top of the chain housing. The unit was cleaned and released by approximately 2159 hours. At approximately 2212 hours there was heavy beaded condensation and over spray on the ceiling and equipment support brackets throughout the Line (B)(6) room. The ceiling was dried off with a sponge mop. The sponges had fat and tissue imbedded and were deteriorating with pieces of sponge loose. The sponges used caused the condensates to drip on the equipment throughout most of the room creating an insanitary condition. The equipment was given a through rinse and the space was released at approximately 2229 hours. There was several specks of black UFM that smeared like grease on the inside of Chiller #1 on the out flow side. There was also heavy beaded condensation on the ceiling over the out flow side of chillers 1 & 2. Sanitary conditions were restored by approximately 2250 hours. (B)(6) was informed of the noncompliance. In Packaging Area #1 at approximately 2345 hours there was black UFM along most of the tray belt associated with line (B)(4). The belt was recleaned and sanitary conditions were restored by approximately 0004 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.2(d), and 9 CFR 416.13(c).</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2515114 121N-1	11/19/2013	01D01	SPS Verification	C	On 11/19/13 around 11:15 Hrs while I was going around the plant I observed close to the osteo and salvage room one spray container lying with some chemical inside. There was no MSDS or ingredient label on it; and (B)(6) and (B)(6) were notified of the non compliance . This is a violation of 9CFR 416.4(c).
5112	M18909	JDD3504114 321N-1	11/19/2013	01B02	Pre-Op SSOP Review and Observation	C	On 11/19/2013 at approximately 1000Hrs while performing pre-operational sanitation of the plant's Evisceration; Raw Fabrication Grinding and Bagging Department's after the plant Q.C. and before start up of production. I observed the following noncompliance. (B)(6) was notified of the noncompliance and shown all incidents. I observed all of the plant's implemented corrective actions to the affected food contact surfaces. Mr. (B)(6) and Mr. (B)(6) verified the non food contact surfaces. 1.) Evisceration - Auto Kill blade had blood (food contact). b.) Chiller A end slide to chiller B- had many pieces of meat, skin and fat (food contact surface). c.) Trussing - had four (UFM) black grease drips on the food contact table. Also -The trussing belt had a broken belt section which was not trimmed. The maintenance was called and replaced the broken section. d.) Final Wash- had UFM black grease drips on the middle section (non food contact). e.) The white conveyor into chiller A- had four pieces of meat one feather and two areas of meat residues (food contact). f.) White incline exiting the Gizzard defatter- had UFM black grease drips (food contact). g.) Steel glove- one had meat (food contact). 2.) Raw Fabrication Grinding- The # 1 grinder dumper- had meat residues on the hand bar (food contact). b. (B)(4) injector- had meat residues (food contact). 3.) Bagging Department- The blue line belt was unraveling at the edge and was dragging onto the floor when the conveyor was moving (food contact). The maintenance was notified to trim. The observed incidents of food contact surfaces found with meat, meat residues, skin, fat, feathers, UFM and untrimmed belt's from previous days operations is in violation to 9 CFR 416.4(d); 416.13(c) and 416.4(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance is being linked to noncompliance (#161) JDD4803115918N/1 dated 11/16/2013; (#153) JDD2203112512N/1 dated 11/11/2013 and (#147) JDD411114204N/1 dated 11/4/2013 for the same cause respectively.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN020311 4419N-1	11/19/2013	01C02	Operational SSOP Review and Observation	C	On November 18, 2013 at approximately 1900 hours, while performing my Operational Sanitation Inspection in the Oven Room, Slice Pack Staging Room, and Coolers I observed the following noncompliance. Oven Room: (a) I observed 5 pieces of product on the floor (b) I observed no sanitizer in the hand dip station, and (c) I observed no inedible barrel in the oven room. I informed and showed Mr. (B)(6) the noncompliance, Immediate Corrective Action: Product was put into inedible barrel and hand dip station was filled with sanitizer.Slice Pack Staging Room: I observed 13 to 15 pieces of product (product code 6054) on the floor. Cook Pack Cooler: I observed two pieces of product on the floor. Slice Pack Cooler: I observed three pieces of product on the floor. Management Immediate Corrective Action: Product was condemn and floor cleaned and sanitized. At 1930 hours sanitary conditions was restored.This does not comply with Regulation 416.1; which states in part: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure product is not adulterated", and 416.13(c); which states in part: "Plant monitors implementation of SSOP procedures".This noncompliance report serves as written notification that failure to comply with regulatory requirement(s) of 9 CFR 416 could result in additional regulatory or administrative actions.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1307113 919N-1	11/19/2013	01C02	Operational SSOP Review and Observation	C	<p>On 11/19/2013 at approximately 0200 hours while conducting a Finished Product Standards check in Plant #1, I observed the following. There was condensation dripping from the ventilation ducting on to the QC Finished Product Standards(FPS) table on the line #1 side of the plant. The ducting extends from the QC FPS table over eviscerating lines 1 & 2 and ends at an exhaust vent on the line 2 side of the plant near the Cropping Machine. There was heavy beaded condensation along the entire length of the ducting. A second separate ventilation line extending from the entrance door to the employee break area to the exhaust duct between stations 4 & 8. The ducting passes over line 2 and also had beaded condensation along its entire length. I contacted (B)(6) and showed him the noncompliance. The condensation was wiped up but immediately came back. Paper towels were placed on the light fixture to catch the dripping condensates. A mechanic was called to adjust the ventilation. I checked back later and the condensation was again being wiped off by an establishment employee. Ventilation ducting is treated as a non-product contact surface which is seldom cleaned. The contaminants added by the dripping condensates is causing an insanitary condition. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(d).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2107112 419N-1	11/19/2013	03J02	Slaughter HACCP	C	<p>On 11/16/2013 at approximately 0525 hours while performing a direct observation task as part of the Verification Plan resulting from a Notice of Intended Enforcement (NOIE) dated October 7, 2013, I observed the following: I was observing the Establishments' (b)(4) monitor perform a scheduled check when we observed that the (b)(4) spray on overhead line going into Packaging was not working. Line (b)(4) was running and untreated carcasses were entering Packaging. The monitor called a Packaging Supervisor to stop the line and she called a mechanic to make repairs. With the line stopped (B)(6) arrived and QC hold tags were applied to a pallet of front halves at the Plant #2 Halvers, to a rack of legs and a rack of thighs at a location near Packaging lines (b)(4) & (b)(4). The product collected before the line stopped were tagged in my presence. I left assuming that corrective action was in progress. On 11/18/2013 at approximately 2030 hours I conducted a HACCP Slaughter records review of records filed from 11/16/2013. The CCP-7B (b)(4) for Plant #2 for 11/16/2013 showed the failure of the spray on overhead line at 0525 hours. The last good check was at 0435 hours. A Corrective Action Log for the HACCP Slaughter failure documented that 'Product was Involved' and that a pallet of front halves and two racks of legs and of thighs were held for treatment with (b)(4). When I left the area on 11/16/2013 there were approximately 600 carcasses hanging from the (b)(4) unit past the Halving machine all the way to the Leg Processers with most of the shackles full. This product is cut, separated and directed to Packaging lines (b)(4) & (b)(4). A like amount of product is arriving onto Packaging belts 8 & 9. The treated product arriving from plant #1 was contaminated by the untreated product arriving from plant #2. The Establishment on line (b)(4) was also packing leg and thighs from Packaging Lines (b)(4) & (b)(4) from the untreated product. There was a bin of thighs being collected adjacent to line (b)(4). A full bin normally weighs approximately 2000 pounds. The Establishments Corrective action Log for the HACCP Slaughter failure does not address any of this product. A review of the establishment HACCP Plan - Slaughter Plant #2 Step 27 (b)(4) lists (B) Pathogens: i.e. Salmonella and Is the Hazard Significant? YES. Under 'Justification for Decision' it states (b)(4) CCP-7B - Corrective action' lists Supplement #10 as a supporting document for their decision. Supplement 10 under #3. Corrective Action Procedure (Concentration failure, (b)(4) application) states under (f.) "If the line was not stopped at the time of the failure, product from the last passing check will be identified and placed on hold using the (b)(4) Corrective Action</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							Checklist." The establishment has no records of the affected product being used to pack the legs and thighs on lines [REDACTED] & into 'Picnic Packs' on line [REDACTED] the bin of thighs being collected near Packaging line [REDACTED] nor the 600 carcasses on the overhead line [REDACTED] from the inoperable (b)(4) spray cabinet to the Leg processors. This is a failure of the Establishments' Corrective Action procedure as outlined in Supplement #10 to prevent contaminated carcasses from entering commerce. My findings indicated a noncompliance with 9 CFR 417.3(c).
5308	M6137	BXL4520111 119N-1	11/19/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1335 hours, while performing direct observation on the Second Processing Rinse (mid-shift) at the Rotisserie Room, I observed the following; sanitation employees were washing the area and applying the sanitizer (b)(4). I observed when Quality Control did the (b)(4) sanitizer concentration check, at approximately 1344 hours. The SSOP Plan states in part under procedure that '(B)(4)'. The sanitation employees were almost finished with the application of the (b)(4) sanitizer when Quality Control measured the concentration.My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.13(b) and 9CFR 416.13 (c).I informed (B)(6) of the noncompliance.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1911114 318N-1	11/18/2013	03J02	Slaughter HACCP	C	<p>On 11/18/2013 at approximately 0616Hrs, I observed the collection barrels of Turkey Fries at line one and line two. The plant's attached tag&nbsp;#645935 &nbsp;36&nbsp;showed both barrels collection time was 0415Hrs. I was at the Line 2&nbsp;barrel&nbsp;filling out my U.S. Retain Tag NO:B39554891&nbsp;to&nbsp;apply to the barrel with temperature 98.6F. (B)(6) came up to me and was notified of the noncompliance and shown the temperature 98.6F. I also notified him that line one barrel of fries&nbsp;would be retained. The line one and line two Turkey fries had no&nbsp;ice or CO2.&nbsp;The establishment's CCP 2B requirement for fries had exceeded the time and temperature of 40F within 2 hours of harvesting. A plant employee took the line one barrel of fries and put them into the chilling tank. Mr. (B)(6) chose to plant condemn all of the&nbsp;fries. The line two barrel of fries approximately 40 pounds was immediately taken out side and condemned/denatured.&nbsp;The line one turkey fries&nbsp;(44 pounds) were plant condemned when they came out of the chilling tank at approximately 0650Hrs. This observed incident of Turkey fries found exceeding the two hour&nbsp;time limit and 40F temperature from harvesting is a violation to 9 CFR 381.66(c)(4) and&nbsp;the plant's monitoring of the turkey fries 9 CFR 417.5(a)(3).&nbsp;(B)(6) was also notified of the noncompliance.</p>
5308	M6137	BXL1314110 618N-1	11/18/2013	03C02	Raw Intact HACCP	C	<p>On 11/16/2013 while observing Quality Control personnel perform the CCP3B procedure in the Packaging Department at shift change,I observed the following noncompliance. Q.C. was measuring the sanitizer concentration on 5 contact surfaces in Packaging 1 Area. She was waiting for an employee to sanitize the halver machine that is located by the aged breast cooler and the&nbsp;deboning table. After the sanitizer was applied to the halver, Q.C. measured the (b)(4) sanitizer concentration on the halver chute and the concentration was zero on the test strip. She did not document the result on the CCP3B (b)(4) .&nbsp;Q.C. then checked the (b)(4) sanitizer coming out of the hose and it was also zero, she informed Supervision.&nbsp;Another Q.C. personnel came over and informed her that production would not be using the halver and then informed her which lines were going to be running. Both Q.C. personnel left the halver area, and sanitizer was not reapplied. The HACCP Plan states in part, (B)(4) , Further planned actions must be taken to ensure compliance with 9CFR 417.3. I informed (B)(6) of the noncompliance. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 417.2(c)(4), 9CFR 417.2(c)(5), 9CFR 417.2(c)(6), 9CFR 417.4(a)(2)(ii), 9CFR 417.5(a)(3), and 9CFR 417.5(b).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2020115 818N-1	11/18/2013	01B02	Pre-Op SSOP Review and Observation	C	While monitoring the Establishments' Pre-operational Sanitation Procedures in Plant #1, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 416.1, 9CFR 416.4(a) and 9CFR 416.13 (c).At approximately 0709 hours in the Area #4, Unit #16 Final Trim Station Line #1 and Line #2 and (b)(4) Cabinets, I found the drip pan for Line #2 that is going directly to the recycle water tank with chunks of dried and semi-dried fat from the previous day production. The drip pan from Line #1 that is attached to the (b)(4) cabinet had several spots of black material that appeared to be grease and also residue on the entire drip pan of the same material. I immediately attached a U.S. Retained/Rejected Tag #B31 406311 to the area and informed (B)(6) and (B)(6) about the noncompliance. They had an employee to scrub and rinse the area. Sanitary Conditions were restored at approximately 0717 hours, I then removed my tag.
5769	M6492	DIO0702110 018N-1	11/18/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 2300 hrs., I started my Pre-Operational Review and Observation task upon learning from (B)(6) that the area to be Pre-Oped is ready(Raw side). I noticed at kettle number 8 that there is a food residue(approximately 1"x3/4" in size) from previous production which is located at the connecting junction between pump and pipe that feeds the Burrito fillings down to the line. This surface is a Food Contact Surface. I notified Ms. (B)(6) and Sanitation personnel immediately cleaned and sanitized the affected surface and my reinspection revealed no trace of food residue. Had this contaminant not been found, it will potentially adulterate product that will be produced. This is in violation of Title 9CFR416.4(a) Sanitary Operations and 9CFR416.13(c) Implementation of SOP's 9CFR416.4(a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. 9CFR416.13(c) Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH370411 2419N-1	11/18/2013	01C01	Operational SSOP Record Review	C	On the night of production that began on November 18, 2013, while performing SSOP records review, I found the following noncompliance. There were three SSOP deviations documented by the establishment where the preventive measure for each deviation was an employee received instructions from a supervisor. There was no documentation that these instructions were given. Therefore the preventive measure could not be verified. For another deviation the preventive measure was an area check would be performed; however, the check was not documented. The preventive measure for another deviation was training would be provided by the warehouse. There was no documentation for this training. This training could not be verified. Mr. (B)(6) was notified the noncompliance would be documented on an NR. The requirements of 9 CFR 416.16(a) were not met. For a similar noncompliance refer to NR NHH1201100414N/1 dated October 13, 2013. The preventive measure for this noncompliance was 'Supervisor responsible for assuring Preliminary Response Forms will be answered by the end of the shift and retrained as such.' These measures may have been ineffective or implemented incorrectly.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3502114 518N-1	11/17/2013	04C05	Poultry Good Commercial Practices	C	<p>On 11/17/2013 at approximately 0715Hrs while giving a break to the line food inspector, I (B)(7)(C), CSI observed the following non-compliance. While providing a break, I hung back 2 cadavers for Dr. (B)(7)(C) SPHV to verify. Once the inspector returned from break, I immediately went outside to check Good Commercial Practices at the live hang/kill line area. Dr. (B)(7)(C) examined the cadavers and determined that birds were cadavers; one of the cadavers had a kill cut but did not bleed fully, and the other did not have a kill cut. Upon confirmation of the cadavers, Dr. (B)(7)(C) notified (B)(6), about the two cadavers so immediate corrective action could be done; this is the plant's standard practice. When birds are determined to be cadavers, the establishment implements immediate corrective actions. During this time, both evisceration lines one and two were running at the maximum allowable speed of (B)(4) per line with two line inspectors for birds 16 lbs or over. Outside at the live hang/kill line area, I observed that the establishment was running mixed heavy hens and heavy toms. At the entrance to the inside scald area, an establishment employee was using a knife to manually cut the necks of the birds that were not properly stunned and birds that were missed by the automatic kill blade. While he was trying to cut the turkeys, I observed the birds violently thrashing about, indicating improper stunning. A second plant employee stationed at the automatic kill blade was also using his knife to make manual cuts due to violent thrashing. These turkeys were missing the single line auto kill blade/knife because they were not sufficiently stunned. I also observed the employee at the automatic kill blade has to wipe blood from his face before attempting to make another cut. This employee at the auto kill did not stop the line. Due to the inadequate stunning, the thrashing birds, and the difficulty the plant employee was having in making the kill cut, I was concerned that the process was out of control and I proceeded to ask another employee on the kill floor to notify a Supervisor. The employee was unable to raise a supervisor, so I hurried to the USDA Office to notify Dr. (B)(7)(C) that the outside kill needed to be stopped. Upon arrival at the USDA office, I discovered that Dr. (B)(7)(C) had to go to the evisceration floor due to more cadavers. At this time, I also went to the scalding area at approximately 0725Hrs. I observed two heavy turkeys with their heads up (in an arched manner) looking at me as birds were going into pre-scald. Dr. (B)(7)(C) examined 11 cadavers between the two inspection lines; five of the cadavers did not have the kill cuts and six cadavers had kill cuts but did not bleed sufficiently. In total, the establishment had a total of 13 cadavers at the inspectors' station within an approximately 15-minute time frame. The last cadaver was noted at 0730 hours by line inspector (B)(7)(C). The neck and head of all of the 11 birds were collected and subsequently shown to Mr. (B)(6), in the USDA</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							office; the establishment did not dispute Dr. (B)(7)(C) findings that in this cluster of 11 cadavers, 5 were without a kill cut and 6 were with a kill cut but the birds were insufficiently bled, which made them also cadavers. (B)(6) notified me at approximately 0740Hrs that the issue was addressed. I notified Mr. (B)(6) that a noncompliance will be issued. Dr. (B)(7)(C) concurred that the plant was not following good commercial practice, as evidenced by birds dying other than by slaughter and not being bled out properly, which is in violation to 9 CFR 381.65(b) which states in part; "Poultry must be slaughtered in accordance with good commercial practice in a manner that will result in thorough bleeding of the carcasses and ensure that breathing has stopped prior to scalding."
5112	M18909	JDD0802115 218N-1	11/16/2013	04A03	MSS; MSP; PDBFT; PDPFT; PDCB; PDCP; AMRS	C	On 11/16/2013 at approximately 2150Hrs while performing my PHIS MSP task, I observed the (MSP) Mechanically Separated Poultry floor analyzer perform the bone content analysis. The bone content analyzer showed the bone content was (b)(4) This test was for Bin # 25 with time 2147Hrs. I saw the personnel take the MSP bin to the new shipping dock with the Bonning Room Scale attached Tag #T001812522 and time 2157Hrs. I went to the plant's Quality Control lab to verify if a recheck sample was performed. (B)(6) was in the lab and she had not been notified of a needed retest for Bin #25 with (b)(4) Bone. (B)(6) was notified of the noncompliance. Mr. (B)(6) went with me to the shipping dock and we collected a retest sample, per plant requirement. Ms. (B)(6) performed a retest on the sample in the Quality Control lab Analyzer. The bone content was (b)(4) The retest passed and the MSP Bin # 25 was released back to shipping at approximately 2200Hrs after verifying the establishment's implemented corrective actions. This observed incident of the plant not following their corrective action when the first test exceeded the (b)(4) bone content required is in violation to 9 CFR 381.173 and Directive 7160.1. This is also a violation to establishment's in place (b)(4) bone requirement and corrective action procedure for the MSP.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4803115 918N-1	11/16/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On 11/16/2013 at approximately 1110Hrs while performing pre-operational sanitation of the plant's Evisceration; Boning Room, Bagging and Raw Fabrication grinding Department's after the plant Q.C. and before start up of production. I observed the following noncompliance (B)(6) was notified of the noncompliance and shown all incidents. I observed all of the plant's implemented corrective actions to the affected food contact and non food contact surfaces. 1.) Evisceration - Scalding (middle) had many long feathers (food contact) surface. a.) Hock Cutters (hand held holder) had meat and meat residues on the entire inside (food contact) surface. b.) The blue incline conveyor to chiller A had meat, skin and fat on the bottom side (non direct food contact) surface. c.) Gizzard splitter had two long feathers (food contact) surface. d.) Chiller A end metal slide conveyor had many pieces of meat, fat, skin and meat residues (food contact) surface. 2.) Boning Room - Fillet conveyor had two pieces of meat (food contact) surface. a.) The fillet conveyor had two broken untrimmed belt pieces. The maintenance was called and replaced the two broken belt sections. b.) The stainless steel work table had two pieces of meat (food contact) surface. 3.) Raw Fabrication- had meat residues inside the #1 grinder (food contact) surface. a.) The #1 grinder screen had meat residues (food contact) surface. 4.) Bagging Department - had belt threads wrapped around the yellow conveyor roller under side (non food contact) surface. a.) The Top slide conveyor which enters the Roser had meat; rust, blue and black netting, metal clips and a piece of a turkey bag) (non direct food contact) surface when turkey bags are closed. The observed incidents of food contact surfaces found with meat, meat residues, skin, fat and feathers from previous days operations is a violation to 9 CFR 416.4(d); 416.13(c), and 416.4(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance is being linked to noncompliance (#157) JDD2203112512N/1 dated 11/11/2013; (147) JDD0411114204N/1 dated 11/4/2013 and (#145) JDD4511100430N/1 dated 10/30/2013 for the same cause respectively.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2512115 516N-1	11/16/2013	01C02	Operational SSOP Review and Observation	C	<p>On 11/16/2013 while observing the Second Processing Rinse Procedure and CCP3B Procedure at shift change in the Packaging Department, I observed the following noncompliance. Q.C. personnel were measuring the sanitizer concentration on 5 contact surfaces in Packaging 1 area. The (b)(4) sanitizer was measuring zero from the hose and (B)(6) was informed. Two employees started applying (b)(4) from the back pack sprayer to the fillet line. The (b)(4) concentration was within the acceptable range. Q.C. personnel was checking the contact surface on the saddlepack line and as I was standing there I noticed that on Line (b)(4) there were some wings already on the belt. I asked Q.C. if Line (b)(4) had been checked and she informed the employee with the back pack sprayer of (b)(4) to spray the belt. The wings were not removed from the belt before the sanitizer was applied. The Notice of Deferral Verification Plan #17 states in part that "Edible product will be removed from product contact surfaces. The establishment's SSOP Plan states in part, (B)(4) The wings were condemned and I informed (B)(6) of the noncompliance. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.13(c), 9CFR 416.13(b), and 9CFR 416.12(a).</p>
5308	M6137	BXL3203111 916N-1	11/16/2013	01D01	SPS Verification	C	<p>On 11/15/13 at approximately 0103 hours while performing SPS Verification checks in the Rotisserie Room I observed the following noncompliance. I observed heavy beaded condensation on the ceiling above the injector machine and metal detector and pvc pipe next to the injection machine. I immediately took regulatory control by applying U.S. Reject tag # B31408102 to the area and informing (B)(6) of my findings, Mr. Short immediately stopped production and informed (B)(6) of my findings. All condensation was wiped off to restore sanitary conditions. Regulatory control was relinquished at approximately 0112 hours and production was then resumed.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY431711 3616N-1	11/16/2013	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of November 16, 2013 (Saturday) at approximately 1522h while performing the Operational SSOP Review and Observation task, I observed the following noncompliance during change of shift from shift I to shift 2: 1, CS (B)(7)(C) (B)(6), observed multiple droplets of condensation located on the underside of 2 drip pans and several pipes that were directly above Line (B)(6) in the "IF" processing area. One of the drip pans was angled downward and water was dripping off the pan from the lowest corner of the pan every 3-5 seconds and landing on the plate freezer film used to transport raw poultry product to the freezer. This is a product contact area. At the time of the observation (1522h), no product was on the line due to the shift change. I immediately informed the lead person to call the shift I supervisor for the area. Mr. (B)(6) I arrived at approx. 1530h and was shown the dripping condensation that was landing on the product plate freezer film. In addition, he was shown the other drip pan and pipes directly above line (B)(6) that had multiple beads of condensation on them. I informed Mr. (B)(6) that there was SSOP non-compliance and the line was rejected with U. S. Tag #B29 699994. In order to restore sanitary conditions, Mr. (B)(6) had maintenance level the drip pan above line (B)(4). In addition, all drip pans and pipes were wiped down. He had the plate freezer film removed and new film placed on the line. There was a fan not operating by line (B)(6) which was unplugged. Mr. (B)(6) plugged it in and the fan began operating. As a preventive measure, Mr. (B)(6) stated he would retrain the employees for line (B)(6) concerning condensation. In addition, he asked the SSOP monitor for Shift II to do an extra SSOP monitoring check for line (B)(6) for 11/16/13. The regulatory control action (U. S. Tag B29 699994) was removed at approx. 1552h after the preventive measures were stated, sanitary conditions restored, and the product freezer film removed. The establishment's Standard Operating Procedures for Sanitation (Part 2; Section 1) states: (B)(4) . Lack of adequate ventilation and ineffective SSOP monitoring failed to prevent product contact equipment from contamination with condensation. In addition, regulatory requirement for 416.13(c), 416.2(d) and 416.1 were not met. For a similar SSOP noncompliance record with the same cause (inadequate ventilation to control condensation), which resulted in product contamination, refer to HAY1122111802/1 dated 11/2/13. In addition on 11/5/13 and 11/6/13, there were 2 SPS NRs documented due to the same cause (inadequate ventilation; see NRs HAY1516111505N/1 and HAY5107110607N/1).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1706115 717N-1	11/14/2013	01C02	Operational SSOP Review and Observation	C	<p>On 11/14/2013 at approximately 1008Hrs, I observed seven whole body packaged turkey's on the floor at the netting area. The bagged turkeys were at two employees feet and one was under a tank. At approximately 1012Hrs, I observed one employee pick up one of the whole body turkeys from the floor. He put it on to the food contact bag line. He then handed it to another employee which was on the other side of the line. The second employee put the turkey through the netting and then put it on to the line. The bagged turkey which was picked up from the floor was not rinsed. The two employees did not wash/sanitize their hands/gloves or the conveyor/table prior to or after putting the bagged turkey onto the line. (B)(6) and (B)(6) were immediately notified of the noncompliance. I showed Mr. (B)(6) the affected turkey which was traveling on the conveyor belt. Mr. (B)(6) immediately removed the turkey form the belt. He had the affected bagged turkey reconditioned by (b)(4) water spraying (b)(4) at the product wash cabinet. He had the affected food contact conveyor sanitized. He had all employees in the area sanitize their gloved hands. Sanitary conditions were restored. This observed incident of a packaged food product picked up from the non food contact floor and put back with clean packaged food products on a clean conveyor is in violation to 9 CFR 416.4(a); 416.5(a), 416.4(d). This is also a violation to the establishment's Operational Sanitation 11 - A # 7.) Establishment's methods for production; (b)(4)</p> <p>. " was not met.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3117115 314N-1	11/14/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 0910 hours, I was monitoring the second processing, rinse procedure (shift change) and I observed the following; Production employees were rinsing and applying the sanitizer (b)(4) as prescribed in the SSOP Plan on some of the product surfaces areas in Main Packaging.&nbsp;At approximately 0920 hours they finished. I observed that the blue conveyor belt that transfer product from the dumper to the saddle pack line was not rinsed and sanitized, the&nbsp;reconditioning station between Line #2 and Line (b)(4), two carts that were stationed there, one for dirty product and one for clean product were&nbsp;also not&nbsp;rinsed&nbsp;and sanitized.&nbsp;I tagged the area with U.S. Retained/ Rejected Tag # B31 406312I and contacted Department&nbsp;(B)(6) and (B)(6) and informed them about the noncompliance. The SSOP Plan states in part under Second Processing Rinse Procedure that (B)(4) .</p> <p>Supervisors' contacted sanitation employees from dayshift and night shift, and they rinsed and sanitized the area. I released the area at approximately 0930 hours. My findings indicated a noncompliance with the following regulatory requirements of regulations 9CFR 416.13 (b) and 9CFR 416.13 (c).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4206110 714N-1	11/14/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 11/13/13 at approximately 2320 hours while performing pre-operational sanitation verification in plant 1 rehang area, after the establishments pre-operational checks and before the start of operation CSI (B)(7)(C) and CSI (B)(7)(C) found the following non-compliances to 9CFR 416.4(b) and 9CFR 416.4(a). Fat and protein build up was found on the (b)(4) filtering/tumbler unit and piping. The support beams and the conveyor belts utilized in the rehang area of plant 1 was observed to be in unsanitary due to fat and protein build up. (B)(6) was notified of our findings. Effected area's were cleaned before start up to restore sanitary conditions</p> <p>At approximately 2332 hours while performing pre-operational verification after the establishments pre-operation checks and start of operation in plant 2 rehang area CSI (B)(7)(C) and CSI (B)(7)(C) found fat on line (b) loop belt and line (b) conveyor belt, Fat and fat build up was found on # 9 drop conveyor machine and chutes. The plastic curtain that hung over the exit of the chute was torn and cracked and unsanitary with small pieces of fat on all surfaces. The bed and conveyor belt beneath the chute was observed to be unsanitary due to small pieces of fat and protein buildup the the surface. Sanitation (B)(6) was notified of our findings Effected areas were cleaned before start up restore sanitary conditions</p> <p>At approximately 2350 hours while performing pre-operation verification after the establishments pre-operation checks and before the start of operation in the (b)(4) room CSI (B)(7)(C) and CSI (B)(7)(C) found fat and protein buildup on (b)(4) deboning 3 and 4 units and supporting frames, Fat was also found on the contact surfaces of the product transfer belts of the units unsanitary due to small pieces of fat . We also found fat and protein residue on the walls of the (b)(4) room. (B)(6) was notified of our findings. Effected areas were cleaned before start up to restore sanitary conditions.</p>
5308	M6137	BXL4523113 414N-1	11/14/2013	01D01	SPS Verification	C	<p>On 11/13/13 at approximately 0020 hours while performing the review and observation component of sanitation performance standard task code CSI (B)(7)(C) and CSI (B)(7)(C) observed the following noncompliance to 9CFR 416.2(b)(1). In plant one we observed the curtain next to the inside outside bird washer that sanitation uses for over spray protection to be poorly maintained. There were large tears and worn spots in the fabric. (B)(6) was informed of our observation and noncompliance.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2117112 613N-1	11/13/2013	06D02	Other Inspection Requirements	C	At approximately 1028 hours, while performing reprocessing procedures on Line (B)(7)(C) (Reprocessing Line) in Plant #2, I observed a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b). After I took my 10 bird sample for the reprocessing check, I observed that there was not enough light intensity. This area is being used to inspect CCP-1B (b)(4) as a critical control point and the reprocessing defects. SCS (B)(7)(C) measured the light intensity and it was 50 foot-candles. We asked (B)(6) to call an electrician. (B)(6) verified the light intensity and it was below 200 foot-candles. Electricians installed a temporary light, the light intensity was over 200 foot-candles. We informed (B)(6) of the noncompliance.
5308	M6137	BXL4706115 513N-1	11/13/2013	01B02	Pre-Op SSOP Review and Observation	C	On 11/12/13 at approximately 2142 Hours while performing pre-operational sanitation verification after the establishments pre-operational checks and before the start of production, CSI (B)(7)(C) and CS (B)(7)(C) observed the following noncompliance. In area 1, unit 25 live hanging table we observed fat and feathers from the previous days production on the hanging table and wall, U.S. Reject tag # B41800076 was applied to the table and informed (B)(6) of my findings. In area 2 feathers and fat was observed in picker # 2, line 1 and picker # 3 line 2, In area 4 we observed at inspection station # 7 fat from the previous days production. Fat residue was found floating in chiller # 2 by Dr (B)(7)(C) fat residue was removed before start of operation. At approximately 2250 hours while performing pre-operational sanitation verification after the establishments pre-operational checks and before the start of operation CS (B)(7)(C) and CS (B)(7)(C) the following noncompliance in the Rotisserie Room. Fat was found under the Packer product conveyor belt. (B)(6) was notified of our findings. Belt was cleaned to restore sanitary conditions. At approximately 2300 hours while performing pre-operational sanitation verification after the establishments pre-operational checks and the start of operation in the Paw room CSI (B)(7)(C) and CS (B)(7)(C) found a white plastic shovel in disrepair with pieces of plastic flaking off. Sanitation (B)(6) was notified of our findings. Shovel was removed and destroyed. At approximately 2325 hours while performing pre-operational sanitation verification after the establishments pre-operational checks and before the start of operation, the following noncompliance was observed in Packing department. At the front and back Leg Processers, Fat from the previous days production was observed on the leg processers (B)(6) was notified of our findings. Leg processers and area was cleaned before start of operation.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5014112 913N-1	11/13/2013	06D02	Other Inspection Requirements	C	On 11/04/2013, at approximately 0915 hours, I was ready to perform a Post-Chill Finished Product Standard Task. To start the process, I wanted to wash the FPS table adjacent to Chiller #2 in Plant #1 and no water was available from the hose. I informed (B)(6) and he informed me that he will called maintenance to fix it. I came back at approximately 1500 hours to perform a Post-Chill Task again at Chiller #2 and still no water was available. I informed (B)(6) of the noncompliance, he then called maintenance. At approximately 1540 hours maintenance fixed the pipe and water was available.This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (b).

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5206112 213N-1	11/13/2013	01C02	Operational SSOP Review and Observation	C	<p>On 11/12/13 at approximately 0007 hours while performing SSOP review and observation; verification in plant 1 cooler; CS (B)(7)(C) and CSI (B)(7)(C) observed the following non-compliance to 9CFR 416.4(d) and 9CFR 416.2(d). We observed heavy beaded condensation on the ceiling and pipes of plant 1 cooler, upon further inspection of the cooler I observed directly underneath a section of heavy beaded condensation; a full tank of whole body chickens that had its blue plastic tank covering partly exposing the product inside. The tank had a fully exposed chicken laying on top of the tank cover. We immediately took regulatory control action by applying U.S. Retain tag # B31407422 to the tank of chickens and informing (B)(6) of my findings. Mr (B)(6) took corrective action by removing all the tanks underneath the condensation and replacing the tank covers and condemning the chicken that was exposed and wiping all the condensation to restore sanitary conditions. Regulatory control was relinquished at approximately 0120 hours and U.S. Retain tag # B31407422 was removed. At approximately 0020 hours while checking plant 1 staging cooler for condensation; we observed heavy beaded condensation under the cooling unit of the staging cooler, Dripping condensation was observed falling onto a pallet with cardboard boxes of whole body chickens that were bagged and not exposed to the condensation. I immediately took regulatory control by applying U.S. Retain tag # B 31406172 to the pallet and informing Plant manager (B)(6) of my findings. Mr (B)(6) took corrective action by having the pallet removed from the area and having the condensation wiped off and replacing the boxes with new ones. Regulatory control was relinquished at approximately 0122 hours and U.S. Retain tag # B31406172 was removed. At approximately 0500 hours SCS (B)(7)(C) and CSI (B)(7)(C) observed beaded and dripping condensation from the lights above the (b)(4) room. Beaded condensation was observed above exposed product on the table and conveyers and cones. (B)(6) and (B)(6) was notified of the noncompliance. Production stopped and all condensation was removed from the lights, tables, conveyors and effected cones was washed. area was released at approximately 0523 hours.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5568	M20923	XUM592011 0413N-1	11/13/2013	01D01	SPS Verification	C	On 11/13/2013, at approximately 1838 hours, while performing a directed Sanitation Performance Standards (SPS) inspection task in response to a deficiency on the Cook Area Line (B)(6) Mezzanine, I observed the following noncompliance: a fire sprinkler attached to the overhead ceiling missing a cover plate causing a condition of exposed insulation directly over processing wing product creating insanitary conditions, a noncompliance per 9 CFR 416.1 and 416.2(b)(2). This condition was in the post lethality processing area and could lead to the spread of pathogens of a food safety concern and cross contaminate exposed product. I took regulatory control by stopping the Line (B)(6) production and rejected the area with US Tag 785927. I showed and informed Mr. (B)(6) of the forthcoming noncompliance. After corrective actions were performed by production and sanitary conditions were restored, I relinquished the US Tag at 1850 hours. The requirements of 9 CFR 416.1 and 416.2(b)(2) were not met.
1325 7	P33900	NHH151511 1213N-1	11/13/2013	01D01	SPS Verification	C	179A at 0814 hours while performing an operational sanitation observation and review task I came across combos of inedible product (livers) in the inedible section of the back cooler that did not have denaturant applied. Management was notified and shown the combos. All of the combos had denaturant applied to the liners but there was no visible denaturant on the product in at least 3 of the combos. Edible and inedible containers of product were stored together. CFR 381.95 states that denaturing shall be accomplished by liberally applying it to all of the carcasses and parts. CFR 416.2b states that inedible and edible must be separated by time or space. These requirements were not met; therefore, regulatory control action was taken and the product was retained and the cooler was rejected. The area was released after all requirements were met.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH252211 3213N-1	11/13/2013	01C02	Operational SSOP Review and Observation	O	On the calendar date of November 13, 2013 at approximately 0814 hours while in route to the pre-chill station to perform zero tolerance verification, the following noncompliance was observed: The establishment's SSOP states that (B)(4) (B)(4) I, CSI (B)(7)(C), observed that a plastic tote at the reprocessing station exhibited black foreign particles. The tote was positioned for use directly behind the reprocessing line. At this time, I randomly selected and inspected 4 totes from the nearby pallet. My inspection revealed black stains that smeared with touch, brown residue, and fat particles on the inner surface of 3 of the totes. The totes were rejected with U.S. REJECTED tag # B40172786 (B)(6) (B)(6) was shown the noncompliance, and she confirmed the findings. Ms. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record should be discussed during the next weekly meeting. A similar noncompliance record was documented on November 11, 2011; please reference NR # NHH5106115212N-1. The establishment's response to NR # NHH5106115212N-1 is pending.
1325 7	P33900	NHH291311 3913N-1	11/13/2013	01C02	Operational SSOP Review and Observation	C	#177On 11/12/13 while performing SPS tasks I observed that containers of product (inedible livers) staged in the designated "inedible " section of the cooler were not properly labeled as such.The establishment's SSOP states that (B)(4) (B)(4) " These requirements along with the requirements of CFR 381.95 were not met. Management was notified and as a corrective action denaturant was placed on the product and inedible stickers were placed on all combos.
1325 7	P33900	NHH471411 2713N-1	11/13/2013	01C02	Operational SSOP Review and Observation	C	178At 0814 while touring the giblet room I observed 3 grossly contaminated containers being prepared to place inedible livers in . The combos had not been washed prior to bringing them in the plant. They contained a black build up on the inside and outside. These contents were also seen in the deep embedded grooves on the lips of each container. Slots had been cut on either side of one of the containers.There was mildew and traces of old meat scraps inside all of the combos. The establishment's SSOP states that (B)(4) (B)(4) " Management was notified and shown the condition of the combos. The combos were retained. During the same tour I inspected the inedible section of the cooler where I found containers of product which had not been labeled as such. The establishment SSOP also states that (B)(4) (B)(4) " These requirements and the requirements of 415.11 were not met therefore official control action was taken. corrective actions were completed and as a preventive measure, a written procedure for handling inedible product and containers was written by Management.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3606113 812N-1	11/12/2013	04A06	Poultry Finished Product Standards	C	On 11/12/2013 at approximately 0202H, I observed a plant employee salvage a bird for airsacculitis. Plant employee did not wash bird prior to making the initial incision in the salvage procedure. Plant airsacculitis salvage procedures states that bird should be washed first before cuts are made for the salvaging of parts. This failure to wash the bird before the initial incision is a violation to 9 CFR 381.65(a): Processing, other handling or storing of poultry product must be strictly in accord with clean and sanitary practices and must be conducted in a manner that will result in sanitary processing, proper inspection, and the production of poultry and poultry products that are not adulterated. When birds are hanged in the USDA inspection hang back rail, fecal contaminated birds and birds for salvage are intermixed. Sometimes, the birds for salvage are also contaminated with feces and so it is very important that birds are washed thoroughly before birds are cut for salvage. Washing of the birds prior to the initial cut was not observed in this noncomplianc. Mr. (B)(6) was informed about this noncompliance and tag number B39554830 was applied to tag the birds. Plant did an immediate corrective action by having another employee wash the bird and had parts salvaged.
1325 7	P33900	NHH281611 0412N-1	11/12/2013	01D01	SPS Verification	C	On the calendar date of November 12, 2013 at approximately 1451 hours while verifying Finished Product Standards at the post chill station, the following noncompliance was observed: Item D under Personal Conduct on page 5 of the establishment's GMP's states that "Spitting in the plant is prohibited." I, CSI (B)(7)(C), observed maintenance personnel spit into a drain (between the hang line and chiller areas) as he walk through room 1 of the further processing department towards the paw harvest area. (B)(6) and (B)(6), were notified of my observation. Mr. (B)(6) questioned the employee involved at which time the employee stated that he "may have" spit into the drain. Mr. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting.
1325 7	P33900	NHH291011 4712N-1	11/12/2013	01D01	SPS Verification	C	(173)On 11/12/13 at 1010 hours while performing an operational sanitation observation and review task I came across three combos of inedible product (livers) in the inedible section of the back cooler that did not have denaturant applied. Management was notified and shown the combos. These combos were commingled with with combos of livers that that were not labeled as inedible containers. CFR 381.95 states that inedible product shall be in rooms or compartments separate from those used for the preparation of edible products and that denaturing shall be accomplished by liberally applying it to all of the carcasses and parts. These requirements were not met; therefore, the product was retained and the area was rejected.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH460211 0812N-1	11/12/2013	03J02	Slaughter HACCP	C	On the night of production which began on 11/11/2013, Inspection checked the HACCP Records for the Production Shift beginning on 11/10/2013 for the Slaughter HACCP CCP's (Zero-tolerance for Whole Birds and Cut-up Parts and Pre-Shipment Review). In the Amendment Section of the Establishment's Slaughter HACCP Plan an entry was made on 10/31/2013 concerning two Fecal Finds at the Post-chill Station on 09/13/2013 and 10/03/2013 respectively. It stated that a Reassessment of the Plan would be done by 11/08/2013. The QA Department was unable to produce Documentation of the Reassessment of the HACCP Plan. The Requirement's of 9CFR 417.4(a)(3)(ii) were not met and (B)(6) was informed that a Non-compliance Record would be issued. Refer to NR #NHH1222094216N/1 (#136) dated 09/16/2013 for a similar Non-compliance.
5112	M18909	JDD2203112 512N-1	11/11/2013	01B02	Pre-Op SSOP Review and Observation	C	On 11/11/2013 at approximately 1150Hrs while performing pre-operational sanitation of the plant's Evisceration; Boning Room, Raw Fabrication Grinding and the Bagging Department's after the plant Q.C. and before start up of production, I observed the following noncompliance. (B)(6) and/or (B)(6) were notified of the noncompliance and shown all incidents. I observed all implemented corrective actions to food contact and non food contact surfaces. Evisceration- Outside kill area many feathers on the non food contact floor. b.) White conveyor which carries the turkey's into chiller A had too many to count pieces of meat, fat and skin (food contact). (c) Small gizzard table had three pieces of meat (food contact). d) Gib chiller had three meat pieces and meat residues (food contact). 2.) Boning Room - Drum (b)(4) had meat and meat residues (food contact) on a white piece which is attached. Thigh (b)(4) - had meat and meat residues on a white piece which is attached; also meat and meat residues on the top left wheel (food contact). c.) The white thigh conveyor table had two pieces of meat (food contact). Raw Fabrication grinding room had meat and meat residues inside # 1 grinder (food contact). b.) The #1 grinder screen had meat residues (food contact). Bagging Roser Exit - lower belt had blue netting wrapped and jammed on the bottom side of the end roller (non food). b.) Second and third roser conveyor belt also had blue netting jammed in the rollers and one torn turkey bag (non food). The observed incidents of food contact surfaces found with meat, meat residues, fat and skin from previous days operations is in violation to 9 CFR 416.4(d); 416.13(c) and 416.4(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance is being linked to noncompliance (#147) JDD0411114204N/1 dated 11/4/2013; (#145) JDD4511100430N/1 dated 10/30/2013 and (#143) JDD3811102726N/1 dated 10/26/2013 for the same cause respectively.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4808112 212N-1	11/11/2013	01C02	Operational SSOP Review and Observation	C	<p>On 11/11/2013 at approximately 0125Hrs, I observed a plant employee bring a Osteo Bird to the blue incline chiller belt. The employee put the Osteo bird on the incline in front of me and walked away. The incline was carrying birds into the chiller at this time. I removed the bird from the conveyor because I could see debris on the carcass. The carcass breast skin was pushed back, I observed 3 black specks; one brown speck and one brownish piece, approximately 3/8" x 2mm in size of floor debris on the turkey. The debris were attached to the fascia. The HACCP personnel who was assisting me with my task at the pre chill USDA table call the employee back and ask him where he had collected the Osteo carcass. The employee showed us where the bird had fallen from the overhead conveyor belt onto the floor near the ladder. The personnel gave the carcass to an personnel working at the product wash cabinet for reconditioned. Then he put the carcass on the chiller conveyer. Dr. (B)(7)(C) and (B)(6) were notified of the noncompliance and shown the floor debris on the carcass. Mr. (B)(6) immediately implemented the plant's appropriate corrective action. He had the affected carcass reconditioning by trimming and (b)(4) water spraying. The carcass was reinspected and released back to production flow at approximately 0135Hrs after verifying the plant's corrective actions. This observed incident of food product adulteration by UFM (floor debris) not removed is in violation to the establishment's Operational Sanitation 11 Objective which states: (B)(4) " Sub - #7.) Dropped edible product will be picked up in a timely manner. Whole body or part - Rinsed and trimmed as needed." The needed trimming was not done. This is also in violation to the relevent regulations cited above.</p>
5112	M18909	JDD5219114 611N-1	11/11/2013	01D01	SPS Verification	O	<p>At 0459 H PST, 11/11/2013 at the Carcass Dumper in the Boning Area, I observed several overhead Ceiling Panel missing and or loose. Ms (B)(6) and Mr. (B)(6) were shown the noncompliance and advised of Documentation of the same. Q.C. paerwork did not reflect this noncompliance prior to my notification of the same. This is a violation of the above 9 CFR's. This was written before (SAME ROOT CAUSE) on PRE-OP Noncompliance report 0107-2013, Dated 08/26/2013, JDD1010082526N/1 and Five other associated JDD Numbers and is linked. The repairs has proven inadequate or ineffective.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5604112 312N-1	11/11/2013	03C02	Raw Intact HACCP	C	<p>On 11/11/2013 at approximately 2222Hrs, I performed a physical verification check of the Raw Not Ground Turkey Breast and Drum meat which was weighed/scanned/loaded for shipping to the establishment's Plant #2. Using a company calibrated thermometer, I took the temperature of three Turkey Breast 1 Bl SL W/O Flt Hen and one Turkey Drum SO container which was loaded in trailer #3901 at the new Shipping Dock.&nbsp;The temperatures were (B)(4) &(B)(4) U.S. Retain Tag NO's:B43241034; (B)(4) were applied to the loaded affected Breast & Drum meat for temperatures above (B)(4) at shipping. (B)(6) ; (B)(6) and (B)(6) were notified of the noncompliance and verified my temperature findings at shipping. The (B)(4) appeared not to be evenly dispersed over the turkey meat. The establishment chose to add more (B)(4) and put the affected (2046, 2097,&nbsp;2132) pounds of Breast and (2327) pounds of turkey drum meat products into the P-157 blast. At approximately 0230Hrs on 11/12/13 all of the Turkey Breast and Drum meat were released back to shipping after verifying that all of the food products was (B)(4) and below. This observed incident of turkey products being shipped above (B)(4) is in violation to 9 CFR 381.66 (b) and 417.2(c)(4) monitoring at the critical limit. The establishment's supporting documentation for Salmonella Initiative Program (SIP) states; (b)(4)</p> <p>(b)(4)</p> <p>The establishment's HACCP Plan at shipping states; (B)(4) . Product will be maintained at or below (B)(4). Since the supporting documentation for your SIP waiver states that the establishment will (b)(4) and the SIP is used as justification in your HACCP plan, a violation of 417.5(a)(2) also exists.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH040711 2312N-1	11/11/2013	01D01	SPS Verification	C	On the calendar date of November 11, 2013 at approximately 1626 hours while performing the Operational SSOP Review and Observation task, the following facility noncompliance was observed: The Operational Sanitation section of the establishment's SSOP's states that (B)(4) . I, CS(B)(7)(C), observed multiple droplets of condensation on the overhead white piping (parallel to the hang line) in room 1 of the further processing department. The condensate covered approximately 25 ft. of the piping. At the time of the findings, whole birds were being processed in the area. Also, the area of the ceiling in which the piping begins exhibited heavy moisture as well. (B)(6) , was shown the noncompliance, and he confirmed the findings. Mr.(B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on October 30, 2013; please reference NR # NHH4602102430N-1. The establishment's response to NR # NHH4602102430N-1 of, "The condensation was removed." - failed to prevent recurrence.
1325 7	P33900	NHH510611 5212N-1	11/11/2013	01C02	Operational SSOP Review and Observation	C	On the calendar date of November 11, 2013 at approximately 1642 hours while performing the Operational SSOP Review and Observation task, the following noncompliances were observed: The establishment's SSOP states that (B)(4) . I, CS(B)(7)(C), observed blood specs, fat particles, and greasy residue on the inside of 9 plastic tubs near the front half drop conveyor. The tubs were pulled from a pallet labeled "Clean". I randomly selected and inspected 6 additional tubs from the pallet and 4 of the tubs exhibited an orange residue which was greasy to the touch. The outside of 2 of the tubs exhibited the same residue. The tubs were rejected with U.S. REJECTED tag # B40172782. (B)(6) , was shown the noncompliance and he agreed to the findings. Mr.(B)(6) was informed that a noncompliance record would be issued. A similar noncompliance record was documented on October 29, 2013; please reference NR # NHH3405104029N-1. The establishment's response to NR # NHH3405104029N-1 of, "The affected tools were rinsed and sanitized." - failed to prevent recurrence.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH492311 3310N-1	11/10/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At 2133 hours on the night of production which began on 11/10/2013, while performing required PHIS Poultry Zero-Tolerance task at the designated Line #2 Pre-chill station at est. 33900 P, after randomly selecting 10 slaughtered and eviscerated and chilled chicken carcasses for the subgroup test and having begun the test at 2133 hours, Inspection found fecal material on the 1st bird in the set. The fecal material was a dark green color and of a pasty consistency which would easily smear to the touch. It consisted of one piece 1/4" in diameter and measuring approximately 1/16" in width, located inside the carcass in the Kidney Crypt area.</p> <p>(B)(6) was shown the carcass and he concurred that the material in question was indeed feces. Upon investigation, it was found that the cause of the fecal find was "High Pressure tripped out causing (b)(4) to be clogged up resulting in fecal failure". Plant Management's Measure to prevent recurrence was "Turned 2nd High Pressure Pump on and replaced clogged Spray Nozzle on (b)(4) The requirements of 9CFR381.65(e) and 417.2(c)(4) were not met and Mr. (B)(6) was advised that the incident would be documented on a Noncompliance Record.&nbsp;Refer to NR #NHH0412112308N/1 dated 11/08/2013 for a similar Noncompliance. Plant Management's measure to prevent recurrence was: "The height was raised on the (b)(4) Machine and will be monitored for the duration of the day." To date all preventive measures may not have been implemented as described or were ineffective in preventing recurrence.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5310	M6137B	FFA3419110 109N-1	11/09/2013	01C02	Operational SSOP Review and Observation	C	<p>On November 9, 2013 at approximately 1635 hours while performing my Operational Sanitation Inspection in the "Raw Side Blending Room" I observed noncompliance with SSOP regulatory requirement 416.13(c) and SPS 416.1, 416.4(d).Raw Side Blending Room:&nbsp; I observed one damaged&nbsp;bin of Chicken MDP&nbsp;staged in the blending room ready to be used.&nbsp; The bin was damaged at the bottom leg area and the plastic liner was torn exposing the Chicken MDP. &nbsp;U.S. Retain Tag NO B38934390 was applied to this bin of MDP.&nbsp; (B)(6) and Ms. (B)(6), was informed and showed the noncompliance.&nbsp; Immediate corrective action was implemented by management.&nbsp; At 1755 hours the bin of Chicken MDP was condemn and denatured in my presence. With the establishment back into compliance, U.S. Retain Tag NO B38934390 was removed.This does not comply with the establishment written SSOP Program which states in part:&nbsp; Objective; (B)(4) ".&nbsp; This is also a violation of Regulatory Requirement(s) which states in part: 416.1; "Operate in a manner to prevent insanitary conditions", 416.4(d); which states in part: "Product must be protected during processing, handling, and storage", and 416.3(c) which states in part: "Plant monitors implementation of SSOP Procedures".This noncompliance report serves as written notification that failure to comply with regulatory requirement(s) of 9 CFR 416 could result in additional regulatory or administrative actions.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN032211 1408N-1	11/08/2013	01C02	Operational SSOP Review and Observation	C	<p>On November 8, 2013 while performing my operational sanitation inspection in the Raw Side Warehouse I observed the following noncompliance.&nbsp; At approximately 1745 hours I observed a plant employee taking his bags of spices to the production area.&nbsp; &nbsp; On his cart was two bags of brown sugar.&nbsp; &nbsp; The bags of brown sugar had round holes along the side of the bags and the brown sugar was exposed.&nbsp; U.S. Retain Tag B38934387 was applied to the damaged bags of brown sugar.&nbsp; I informed and showed (B)(6) and (B)(6) the noncompliance.Upon further investigation three more bags of brown sugar was found damaged with holes in the bags.&nbsp; Immediate Corrective Action was implemented by management all five bags of brown sugar was condemn by management in my presence.&nbsp; This does not comply with Regulatory Requirement 416.1 which states in part: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated", and 416.4(d) which states in part: "Product must be protected from adulteration during processing, handling, storage, loading, and unloading".&nbsp; &nbsp; Upon review of the establishment's written SSOP Program on page #3 Part II Operational Sanitation:&nbsp; (B)(4). This NR serves as written notification that failure to comply with the regulatory requirement(s) of 9 CFR 416 could result in additional regulatory or administrative actions".</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN311511 5508N-1	11/08/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1305 while performing Operational Sanitation Review and Observation on the Raw side, I observed a small white edible roll around barrel in the Raw Oven area by the salt (B)(4) mixing tank. The white barrel had a yellow liquid like substance roughly 3 1/2 inches deep in it that was slippery to the touch. No noticeable odor was smelled. I also observed multiple (8) black like specks (1/16in.) in size on the inside surface of the barrel. There was no identification on the white barrel indicating what the yellow substance is. This is a noncompliance of Regulation 416.4(c) and a failure of the Plant Operational Sanitation Plan. U.S. Retained Tag NO. B39554790 was applied to the small white barrel with the yellow liquid (B)(6) and (B)(6) were notified and observed the white barrel with the yellow liquid in it. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
5129	M210	LQN480311 5908N-1	11/08/2013	01D01	SPS Verification	C	On November 7, 2013 while walking through Raw Side Cooler #4 I observed noncompliance with SPS regulatory requirement(s) 416.1 and 416.4(d). At approximately 2340 hours I observed dripping condensation on the overhead roll up door entering raw side cooler #4. U.S. Reject Tag NO. B38937094 was applied to Cooler #4 door. I informed and showed (B)(6) and (B)(6) the noncompliance. This is a product traffic area but at the time of my observation no product was being taken into Cooler #4. Immediate Corrective action was implemented by management: Cooler #4 Door was completely wiped down in my presence. At approximately 2350 hours sanitary conditions were restored and U.S. Reject Tag NO. B38937094 was removed. This does not comply with Regulatory Requirement 416.1 which states in part: "Each official establishment must be operated in a manner to prevent insanitary conditions and to ensure product is not adulterated", and Regulatory Requirement 416.4(d) which states in part: "Product must be protected from adulteration during processing, handling, and storage". This document serves as written notification that failure to comply with regulatory requirement(s) of 9 CFR 416 could result in additional regulatory action as described in 9 CFR 500.4.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN150511 5908N-1	11/08/2013	04A06	Poultry Finished Product Standards	C	At 0300 hours while I was performing Finished Product Standards (FPS) check on the reprocessing line of the evisceration department; I observed one split tail carcass, out of a ten carcass sample, which had one side with kidney tissues still inside the pelvic cavity. Carcasses are marked with split tails to identify that vacuuming is required to remove and condemn all affected tissues including the kidneys. I performed a recheck at 0307 hours and observed two out of the ten split tail carcasses with, again, one side of the kidney tissue not removed from the inside of the pelvic cavity. I immediately informed (B)(6); and (B)(6) representative of my findings and forthcoming noncompliance report. Immediately, Mr. (B)(6) and Mr. (B)(6) started the establishments' corrective actions as prescribed in the establishment's vacuum procedure. The requirements of 9 CFR 381.84, 9 CFR 381.76 table 1 #7 and Plant Standard Criteria for air sac were not met. This document serves as notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
1325 7	P33900	NHH041211 2308N-1	11/08/2013	03J02	Slaughter HACCP	C	On November 08, 2013 while performing a routine pre-chill task at approximately 0829 hours on evisceration line #2, I observed fecal material on the right wing tip of the seventh bird of a ten bird sample. It was greenish gray in color, approximately an 1/8 inch in diameter and located in the hollow of the inside wing tip. The findings indicated a deviation from the critical limit, no visible feces at CCP 1, as prescribed in the establishment's HACCP plan. There were no adequate interventions between this step and the chilling tanks when I performed this check. Therefore it is reasonable to assume that the feces would have entered the chilling tanks in violation of Regulation 9 CFR 381.65(e). Mr. (B)(6) informed me that the cause of the noncompliance was equipment failure. The height was raised on the vent machine and will be monitored for the duration of the day. Mr. (B)(6), and (B)(6), were shown the noncompliance and they confirmed the findings. A similar noncompliance record was documented on 10/17/13, please reference NR # NHH1812105817N/1.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0504114 307N-1	11/07/2013	01B01	Pre-Op SSOP Record Review	C	<p>On 11/05/2013 at approximately 2130 hours while performing a records verification procedure required by the establishments' (NOIE) issued on October 7, 2013, I observed the following. The establishments' Pre-Operational Sanitation - Bio Trace Sampling Log-Evisceration/Packaging for 11/02/2013 registered a failure in Area 3 (b)(4) Room Line 1 on 10/28/2013 with a reading of 584 Relative Light Units (RLU's). The 'Corrective Action' section on the form has not been updated with the new requirements outlined under the Establishments' 'Notice of Deferral Verification Plan of October 13, 2013. Which states under the Sanitation Standard Operating Procedures (SSOP) and Sanitation Performance Standards (SPS) section, Item 16, in part (b) (4) [REDACTED];" I contacted (B)(6) who performs the Bio Trace Testing on the AM shift and asked her who does the rechecks for the PM shift. She said she did but was not aware of the failure. A review of the Bio-Trace Log for the week of 11/4 revealed that no checks were done on the failed item as part of the randomly selected items and that no required rechecks had been performed. I informed her that a noncompliance would be issued and she stated that correcting action for the noncompliance would address starting that night by adding the recheck to the randomly selected items. My findings indicated a noncompliance with 9 CFR 416.12(a), 9 CFR 416.(a),(b) & (c), and 9 CFR 416.16(a).</p>
5308	M6137	BXL1004115 607N-1	11/07/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 11/6/2013 at approximately 0010 hours while monitoring the Establishments' Pre-Operational Sanitation Standards in Packaging Area #1, I observed the following. There were several specks to approximately 1/16" of black UFM (Unidentified Foreign Material) that smeared like grease on the top and product contact side of the white nylon wheel for Leg Processors 7 & 8. The white wheels hold the product during cutting then drops the cut portion onto a collection belt that takes it to the packaging point. There was a piece of semi-dried tissue to approximately 3" on the under side of Leg Processor #7 and another piece of similar size on Leg Processor #9 near the chain. There was approximately 5 pieces of fat each several square inches in size on the drum associated with the collection belt under Leg Processors 7-9. The Leg processors were cleaned and sanitized then released at approximately 0025 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(a) & (b) and 9 CFR 416.13(c).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1804112 007N-1	11/07/2013	01D01	SPS Verification	C	On 11/06/2013 at approximately 2215 hours while monitoring the Establishments' Pre-Operation Sanitation Standards in Plant #1, I observed the following. There was a piece of stainless steel approximately 3" long by 1mm thick; peeling off; a guide bar associated with the (b)(4) for Line #1. The affected guide bar is on the out flow side of the unit. The guide bar is directly above the carcasses that is being opened at this point in the process. Flaking metal is creating an insanitary condition. This is a reoccurring issue caused by metal to metal contact between the guide bars and the carcass shackles. I contacted (B)(6) who called a mechanic. A piece of emery cloth was used to smooth the affected area. A review of the Establishments' HACCP Plan -Slaughter Plant #1 under (P) Physical Hazards states 'None Identified'. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).
5309	P6137A	NJN291211 3007N-1	11/07/2013	01D01	SPS Verification	C	Tuesday, November 5, 2013, at approximately 1940 hours, while in the fillet department I observed, in area six (section "C"), that the (singulators, cabinet, transfer and twin scale belt # 5) drip pan hose was missing. Due to this there was a continuous dripping of water onto the north side cross feeder belt # 2. The plant failed to comply with the regulations 9 CFR 416.4(d) and 9 CFR 416.1.9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated." 9 CFR 416.4(d) states: "Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments." I immediately tagged the drip pan with USDA tag # B43303939 and informed Mr. (B)(6), of the noncompliance. Mr. (B)(6) stopped the north side cross feeder belt, until they fixed the drip pan hose, and sanitized feeder belt #2. I brought Mr. (B)(6) and maintenance attention to the north side & south side cross feeder belts running over each other with no drip pans underneath the upper and middle belts, causing the dripping of water and an accumulation of small pieces of muscle and fat on the lower belts and surrounding structures. On Friday November 8th I checked the area, after they had completed the installation of the drip pans, and the area was found acceptable. Mr. (B)(6) informed me that the maintenance well change the drainage hoses of the five singulators, cabinet drip pans for effective drainage. On Monday, November 11th I checked the singulators cabinet drip pan hoses and they were found acceptable.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH001511 3007N-1	11/07/2013	01C02	Operational SSOP Review and Observation	C	At 0839 hours I observed insanitary conditions and cross contamination of cut-up product in the reprocessing area of the evisceration department. The first four stands in the reprocessing area were being used to salvage cut-up product. Cut-up table #4 contained 5-6 carcasses piled together. Cut up table #3 had 6-8 frames piled at one end, removed parts stacked in the middle and 6-7 birds piled at the other end and scattered over the grate which was partly submerged in water due to the catch basin under the grill being stopped up. Water from the basin had also spilled over on the table area leaving all the product on the table in standing water. Cut-up table #2 had carcasses stacked on each end of the table area. The operations at those tables were stopped and (B)(6) was notified and shown the conditions of the salvage stations. US Reject/Retain tag #B38075589 was assigned. The establishment's approved reprocessing procedure for cut-up salvage states that birds will be removed from the reprocessing line at the station(s) labeled Cut-up and handled individually until reconditioned. This is done because the carcass has already been designated as contaminated. First, there weren't any signs on any of the reprocessing stations. Second, salvage product prior to conditioning and reconditioned product were comingled at all of the stations. (Example: piling removed parts on the table allowing them to accumulate and be oversprayed and recontaminated by other carcasses before placing them in the designated totes.) At 1003 hours same conditions were observed at the IP salvage station. There were 8 unprocessed carcasses piled on the grate and the table. There is a statement in your Air Sac and IP salvage procedure that allows more than one bird on the salvage table as long as they are not being piled on top of each other. However, these requirements also were not met also.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1229 92	V941	000341211 5307N-1	11/07/2013	01D04	SPS Verification (V)	C	<p>At around 1800 H PST, Dr. (B)(7)(C), SPHV and I went to V941 to review the facilities and the following was observed. 1: In Mr. (B)(6) area was observed a crushed vector trap, spider cobwebs, too numerous to count on ceilings, large uncovered roll of plastic on floor. Also noted ceiling&nbsp;light electrical socket exposed, not with bulb or cover. 2: Mr. (B)(6) area, the bathroom exhaust fan has a thick coating of&nbsp;grey black UFM on it. One wall urinal had paper towels in it. The papers on file, as done by Me. (B)(6) did not reflect the condition of the facility. Mr.(B)(6) was notified and he viewed the issues. I notified Ms (B)(6) at 00157&nbsp;P/2 of the the noncompliances. Mr. (B)(6) and Mr. (B)(6) notified by e-mail. This is linked to NR 05-2013, Dated 07/18/2013, 0004122074318N/1</p> <p>§416.1&nbsp;&nbsp;&nbsp;General rules. Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated.</p> <p>§416.2&nbsp;&nbsp;&nbsp;Establishment grounds and facilities. (a) Grounds and pest control. The grounds about an establishment must be maintained to prevent conditions that could lead to insanitary conditions, adulteration of product, or interfere with inspection by FSIS program employees. Establishments must have in place a pest management program to prevent the harborage and breeding of pests on the grounds and within establishment facilities. Pest control substances used must be safe and effective under the conditions of use and not be applied or stored in a manner that will result in the adulteration of product or the creation of insanitary conditions. (b) Construction. (1) Establishment buildings, including their structures, rooms, and compartments must be of sound construction, be kept in good repair, and be of sufficient size to allow for processing, handling, and storage of product in a manner that does not result in product adulteration or the creation of insanitary conditions. (2) Walls, floors, and ceilings within establishments must be built of durable materials impervious to moisture and be cleaned and sanitized as necessary to prevent adulteration of product or the creation of insanitary conditions. (h) Dressing rooms, lavatories, and toilets. (1) Dressing rooms, toilet rooms, and urinals must be sufficient in number, ample in size, conveniently located, and maintained in a sanitary condition and in good repair at all times to ensure cleanliness of all persons handling any product. They must be separate from the rooms and compartments in which products are processed, stored, or handled. (2) Lavatories with running hot and cold water, soap, and towels, must be placed in or near toilet and urinal rooms and at such other places in the establishment as necessary to ensure cleanliness of all persons handling any product. </p> <p>§416.4&nbsp;&nbsp;&nbsp;Sanitary Operations (b) Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1623115 706N-1	11/06/2013	01C01	Operational SSOP Record Review	O	<p>On the 7th during the PM hours, I notified Ms. (B)(6) that the Blue Incline Belt Bottom Door was open and allowing carcasses to go on the floor. She informed the Maintenance Leadperson. It still did not get fixed. Ms. (B)(6) mentioned that Maintenance was aware of this issue on the 6th. There was not any interventions in place to keep carcasses from getting on floor. I observed several carcasses get on the floor and were reconditioned. This is a violation of the Establishment's written SSOP Program which states in part: " (B)(4) [REDACTED] bsp; This substance of this quote was not met. This is also a violation of the following 9 CFR's: §416.4 Sanitary operations. (d) Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments. §416.13 Implementation of SOP's. (b) Each official establishment shall conduct all other procedures in the Sanitation SOP's at the frequencies specified. (c) Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's. This is linked to the following Noncompliance 151-2013, Dated 11/02/2013.</p>
5129	M210	LQN562111 2706N-1	11/06/2013	01D01	SPS Verification	C	<p>On November 6, 2013 at 1555 hours when I walked up to wash my hands at the hand wash sink in the raws side Catering Department I observed noncompliance with SPS Regulatory Requirement(s) 416.1; and 416.4(b). Raw Side Hand Wash Sink: I observed that the hand wash sink in the Catering Department was plugged up with meat and water. Inside the hand wash sink was two sausage trays that is used for the D Shape products. U.S. Reject Tag NO. B38937091 was applied to the hand wash sinks and sausage trays. (B)(6) and QC Rep Mr. (B)(6) was informed and showed the noncompliance. At 1615 hours after sanitary condition was restored (hand wash sink and sausage trays washed and sanitized) U.S. Reject Tag NO. B38937091 was removed. This does not comply with Regulatory Requirement(s) 416.1 which states in part: "Each official establishment must operate in a manner to prevent insanitary conditions and to ensure product is not adulterated", and 416.4(b); which states in part: "Non-Food-Contact surfaces of facilities, equipment and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product". This document serves as written notification that failure to comply with the regulatory requirement(s) of 9 CFR 416 could result in additional regulatory action as described in 9 CFR 500.4.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0820110 406N-1	11/06/2013	01C01	Operational SSOP Record Review	C	On 11/05/2013 at approximately 1500 hours, I went to review the Establishments' Pre-Operational and Operational Sanitation Records (Daily Monitoring Logs) for the previous days. The SSOP Monitoring Log for Loading Dock for Day shift dated on 11/02/2013 was missing. I asked (B)(6) about the SSOP Daily Implementation and Monitoring Log for the Loading Dock. She informed me later that the SSOP Log in Loading Dock was performed but she can not find the Log. This is a noncompliance with the following regulatory requirements with regulation 9CFR 416.16 (a).
5308	M6137	BXL5117111 006N-1	11/06/2013	03J02	Slaughter HACCP	C	While performing Finished Product Standards Task, I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2(c)(4). At approximately 1233 hours, I randomly removed a 10 bird sample from Line #1 in Plant #1, I found one out of the ten birds with visible fecal contamination inside the bird at the right side, under the leaf fat area. The fecal material was a smear measuring approximately 5/16" diameter in size, green and white in color and pasty in texture. This exceeded the limit of (b)(4) for the process to be in control. I informed (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control did a recheck at approximately 1245 hours and it passed. This is a violation of the critical limits of CCP-2B (b)(4) of the Plant's HACCP Plan for Slaughter.
1326 1	M33901	HAY470711 5907N-1	11/06/2013	01C02	Operational SSOP Review and Observation	C	On the calendar date of November 6, 2012 at approximately 0739 hours while performing the Operational SSOP Review and Observation task, the following noncompliance was observed: I, CS (B)(7)(C), observed beaded condensation and what appeared to be sud-like foam steadily dripping from underneath the grinder (near the X-Ray machine) into a combo of ground chicken. The combo was retained with U.S. RETAINED tag # B40172783 (B)(6), was shown the noncompliance and he confirmed the findings. Mr. (B)(6) stated that the sud-like foam was actually sanitizer used by the sanitation crew, and since the sanitizing solution was diluted, that no product adulteration existed. I requested to review information on the sanitizer and was presented with the MSDS for (b)(4) Sanitizer, which is the common name for the sanitizer. The information stated that "Before use as a sanitizer, food products & packaging material must be removed from the room or carefully protected." The MSDS also states "Allow sanitized surfaces to adequately drain before contact with food and then air." Mr. (B)(6) was informed that a noncompliance record would be issued. This non compliance record will be discussed during the next weekly meeting.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY510711 0607N-1	11/06/2013	01D01	SPS Verification	C	<p>On the calendar date of November 6, 2013 at approximately 0705 hours while performing the Operational SSOP Review and Observation task, I, CS (B)(7)(C), observed the following facility noncompliances: 1) Droplets of condensation on the ledge above the air curtain between the shipping cooler and the IF department. 2) Beaded condensation on a pipe directly above a stainless lug containing chicken breast on line 2 -zone 3. Condensation was also observed on a pipe above the conveyor leading into the breeding area where chicken patties were being processed. 3) Multiple beads of condensation on the underside of the cooling unit above the hopper to the Ex-Ray machine. At the time of the findings, boneless skinless chicken breast were inside the hopper. Please be advised that employees in these areas were shown the condensation, and corrective actions were initiated. No product adulteration was observed. Also, at approximately 0836 hour while walking through the shipping cooler, I observed condensation dripping from the underside of a catch pan. At the time of the findings, water splatter was observed on one bag of batter, which was staged on a pallet below the drip pan. No contamination occurred, as the bag was sealed. (B)(6), was shown the noncompliance and corrective actions were initiated. Mr. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on November 5, 2013; please reference NR # HAY1516111505N/1. The establishment's response to NR # HAY1516111505N/1 is pending.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4323113 105N-1	11/05/2013	01C02	Operational SSOP Review and Observation	O	<p>&nbsp;On 11/05/2013, I observed a Blue Tub, Designated by the Establishment's Color Coding System&nbsp;for edible use. It&nbsp;had a Ink Pen in it. Ink Pen not a product contact surface. This was on the Offal Wrapping Machine. I notified Ms. (B)(6) and Ms (B)(6). Additionally this morning, 11/07/2013, I observed Gray Tote/Tub with scissors in it and the Establishment's color code (Gray) for inedible. Ms.(B)(6) and Ms.(B)(6) notified as was Ms. (B)(6) and Mr (B)(6) by the phone. This is linked to 0148-2013. Dated 11/04/2013, JDD123111704N/1. This is a violation of the Establishment's written SSOP program stating in part: (B)(4)</p> <p>" was not met. This ia also a violation of the following 9 CFR's: §416.4&nbsp;&nbsp; Sanitary operations. (a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. §416.13&nbsp;&nbsp; Implementation of SSOP Procedures (c) Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's. §416.14&nbsp;&nbsp; Maintenance of Sanitation SOP's. Each official establishment shall routinely evaluate the effectiveness of the Sanitation SOP's and the procedures therein in preventing direct contamination or adulteration of product(s) and shall revise both as necessary to keep them effective and current with respect to changes in facilities, equipment, utensils, operations, or personnel.</p>
5309	P6137A	NJN510611 2005N-1	11/05/2013	01C02	Operational SSOP Review and Observation	C	<p>At 0705 hrs. I was observing an employee in the packaging department between the chiller exit and (b)(4) #4, knife salvaging one legged carcasses by hand.&nbsp;The employee was using a movable wheeled stainless steel salvage table.&nbsp;On this table there where several carcasses piled on top that where in the process of being salvaged.&nbsp;I observed that the&nbsp;employee had a steel, used for sharpening his knife, that had rust formation down the entire length of the steel.&nbsp;This steel was on top of the table, coming into contact with the carcasses that where piled on the table. I contacted (B)(6) and (B)(6).&nbsp;I informed them of the non compliance to the regulations cited above.&nbsp;The steel was removed from production.&nbsp;The product involved was sent to the reprocessing process.The establishment's Sanitation Standard Operating Procedures, Part 2, Section 2 states (B)(4)</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN542011 2805N-1	11/05/2013	01D01	SPS Verification	C	<p>At approximately 1042 hours, I was in the MDP room when I observed a plant employee lifting a wooden pallet from the wet dirty floor, laying its bottom on his smock while moving it. Being that the bottom of the pallet was dirty and wet from the floor, it soiled the employees smock. After moving the pallet, the employee proceeded to work with his soiled smock. I immediately stopped him and called the (B)(6), and informed him of the noncompliance. Mr. (B)(6), without delay, asked the employee to change his sock. I, also noticed that all the employees working in the DMP room were all not wearing sleeve coverings, which is a requirement in this circumstance because they were handling exposed product. I explained this to Ms. (B)(6), and asked her if they can wear aprons to be easy to wash and sanitize and provide them with sleeve covers. Ms. (B)(6) brought aprons and sleeve covers to all the DMP room employees to wear. The plant failed to comply with the regulations 9 CFR 416.1, 416.5(a) & (b), and their SSOP modification which states that: (B)(4)</p> <p>"</p>
1326 1	M33901	HAY061611 2905N-1	11/05/2013	01C02	Operational SSOP Review and Observation	C	<p>&nbsp;On the calendar date of November 5, 2013 at approximately 0933 hours while performing the Operational SSOP Review and Observation task, the following noncompliance was observed: I, CSI (B)(7)(C), observed an employee near the mega jet line handling cardboard boxes and frozen meat blocks of Ground Chicken Breasts simultaneously. A close examination of the box lids revealed foreign particles, which were gritty to the touch, and wood pieces from damaged pallets. At the time of the findings, 4 meat blocks were in a combo ready for processing. I observed as the employee remove lids from 2 additional boxes and then proceeded to remove the frozen meat blocks with the same gloves that came in contact with the insanitary lids without washing or sanitizing his hands. I took regulatory control as delineated in 9 CFR 416.6 and asked the employee to cease operations. The product was retained with U.S. RETAINED tag # B38464348. (B)(6), and (B)(6), were shown the noncompliance and they confirmed the findings. Mr. (B)(6) was notified that a noncompliance record would be issued. Please be advised that approximately 300 lbs of frozen Ground Chicken Breast Meat was denatured and condemned. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on 11/2/2013; please reference NR # HAY1122111802N/1. The establishment's response to NR # HAY1122111802N/1 is pending.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0411114 204N-1	11/04/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On 11/4/2013 at approximately 1030Hrs while performing pre-operational sanitation of the plant's Evisceration; MSP, Boning, Cooler 9, Raw Fabrication grinding, Tray Pack, Box Out and Bagging Departments, after the plant Q.C. and before start up of production, I observed the following noncompliance.</p> <p>(B)(6) and/or (B)(6) were notified of the noncompliance and shown all incidents. I observed all corrective action to food contact and non food contact surfaces. Evisceration - NE Scaldler (food contact) had many feathers in the scald water. b.) Straddle picker & tail puller (food contact) both had meat, meat residues and feathers. c.) neck conveyor - had one blood and two meat pieces (food contact). d.) Retrussing table - had two feathers on the top side (food contact) and had one meat piece and feathers on the underside (non food contact). e.) Gizzard splitter - had two meat pieces, meat residues and four feathers (food contact). f.) Three steel gloves - had meat. g.) Chiller A - 1st. section - had many pieces of meat and fat on the screens and meat residues on one paddle (food contact). h.) Chiller B - exit 1st section had four meat pieces and one Esophagus (food contact). 2.) Raw Fabrication grinder - (B)(4) needle injector - had one 2" x 1/4" blue hard plastic tie up which was laying on the food contact injector. 3.) MSP - Beehive screen had two meat pieces and meat residues (food contact). b.) Contherm # 2 had meat residues (food contact). 4.) Boning - White cutting board - had three pieces of meat. b.) Blade Saw - had meat residues (food contact). 5.) Bagging - Product wash cabinet (inside) had one piece of meat. b.) One piece (8" x 1/8") of belt trimmings on the underside (non food contact). The observed incidents of food contact surfaces found with meat, meat residues, feathers, plastic tie up from previous days operations is in violation to 9 CFR 416.4(d); 416.13(c) and 416.4(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance is being linked to noncompliance (#145) JDD4511100430N/1 dated 10/30/2013; (#143) JDD3811102726N/1 dated 10/26/2013 and (#136) JDD1711103122N/1 dated 10/22/2013 for the same cause respectively.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5910114 705N-1	11/04/2013	03J02	Slaughter HACCP	C	<p>On 11/04/2013 at approximately 0920 & 0930Hrs and again at approximately 2225Hrs, I found the plant failed to meet the established Boning Department Chilling CCP 5B requirement of (B)(4) or less within 8Hrs from slaughter. Using a company calibrated thermometer, I performed a physical verification check of the Whole Body Heavy Tom Turkeys (Lot# 7988) which were at the Chiller B exit. My findings were (B)(4) & (B)(4) & (B)(4). U.S. Retain Tag NO's: B31 390407 & 08 were attached to two combo bin, approximately 4000 pounds, with temperatures above (B)(4). The attached plant's tags showed the combo bins exiting the chiller at 0320Hrs & 0321Hrs. (B)(6) was notified of the noncompliance and verified my findings. Mr. (B)(6) chose to add more ice to the affected turkeys. (B)(6) was called and she also applied her retain tags. At approximately 1130Hrs the affected product was rechecked and the temperature was (B)(4) and below. 2.) At approximately 2225 to 2331Hrs on 11/4/2013, I found Turkey Brst 1 B/L S/L W/O Fit Tom and Turkey Trim A.K. white with temperatures exceeding the time and temperature requirement of (B)(4) within 8Hrs from slaughter. The affected food products was on the New Shipping Dock for shipping. U.S. Retain Tag NO's: B39554693; (B)(4) & (B)(4) where applied to turkey product with temperatures exceeding (B)(4). The plant's attached tags showed the turkey breast and white trim leaving the Boning Room at 0810; 0941, 1035, 1043, 0956, 0824 & 1042Hrs. Using a company calibrated thermometer. My temperature findings were (B)(4) & (B)(6) and (B)(6) were notified of the noncompliance and verified my temperature findings. Mr. (B)(6) had the affected product put into the P-157 blast (B)(6) . also added her retain tags. On 11/5/2013 at approximately 1120Hrs (3 released) and 2320Hrs (4 released). The (11535 total pounds) of turkey breast and one bin of white trim was released back to production after verifying all of the affected product was at or below (B)(4). The establishment chose to run the University of Wisconsin PMP calculation and it showed no Salmonella outgrowth using the 1100pm dated 11/4/2013 to 1100am on 11/5/2013. The establishment has Salmonella Initiative Program (SIP), a waiver to 9 CFR 381.66(b). This waiver allows the establishment chill whole birds/parts to (B)(4) in 8Hrs from slaughter. This observed incident of product temperatures above (B)(4) exceeding the 8Hrs from slaughter is in violation to the plant's HACCP Plan at the Boning Department monitoring of CCP 5B which states in part; (B)(4)</p> <p>(B)(4)</p> <p>The plant's CCP 5B established company</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							critical limit which states; (B)(4) was not sufficient in preventing temperatures above 45F. This noncompliance is being linked to noncompliance (#108)JDD2323083626N/1 dated 08/26/2013 for the same cause respectively.
5129	M210	LQN300011 2504N-1	11/04/2013	01B02	Pre-Op SSOP Review and Observation	C	<p>On November 3, 2013 at approximately 2150 hours while performing my Pre-Operational Sanitation inspection in the HPP Department I observed noncompliance with SPS regulatory requirements 416.4(b).&nbsp;HPP Packaged/Box Out Area:&nbsp;After the packaged product received it's lethality step and exit the HPP Department into the Packaged Box Out Area I&nbsp;observed &nbsp;both Chutes where bags of product come in contact with prior to being boxed&nbsp;out had a build up of black unidentifiable foreign material on the top surface of the chutes, which may create insanitary conditions. I immediately informed and showed Ms (B)(6) the noncompliance.&nbsp;Immediate Corrective Action was implemented to restore sanitary conditions in my presence.&nbsp;The HPP Department is address in the establishment written SSOP.&nbsp;1.&nbsp;Pre-Operational Sanitation Objective:&nbsp;(b) (4)</p> <p>This does not comply with Regulatory Requirements 416.4(b); which states in part: "Non-food-contact surfaces must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions".&nbsp;This NR is linked to NR#LQN1600102214N/1 dated 10/14/13, for a similar NR on Pre-op Inspection in the HPP Department.&nbsp;Management response to NR#LQN1600102214N/1; "Immediately after USDA rejected the boards they were removed and disposed of in the presence of USDA.</p>
5308	M6137	BXL2219112 804N-1	11/04/2013	01D01	SPS Verification	C	<p>At approximately&nbsp;1625 hours, Line Food Inspector (B)(7)(C) observed a live juvenile cockroach when she was applying sanitizer to her gloves from the sanitizer dispenser box that is located between Line (B)(4) and Line (B)(4) attached to the wall in front of the ice machine. She caught the cockroach and contacted CSI (B)(7)(C) and CSI (B)(7)(C) and showed them her findings. We contacted (B)(6) and showed him our findings. (B)(6) contacted (B)(6).&nbsp;The area was washed.This is a noncompliance with the following regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.2 (a).</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2709113 904N-1	11/04/2013	01B02	Pre-Op SSOP Review and Observation	C	On 11/04/2013 at approximately 0652 hours while monitoring the establishments Pre-Operational Sanitation procedures in Plant #2, I observed the following. In Area #2, Unit # 9, 1/2 of Picker #1 Line (B)(6), there were numerous feathers, too many to count, from the last production day which was 11/02/2013, inside the picker. I informed (B)(6) of the noncompliance. I continued with the Pre-Operational Sanitation procedure and I observed also in Area #2, Unit # 22, 1/2 of Picker #4 Line (B)(6) also had numerous feathers inside the picker. I again informed (B)(6). Sanitation rewashed both pickers, restoring sanitary conditions. I reinspected and released the pickers at approximately 0704 hours. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.1, 9CFR 416.14, 9CFR 416.4(a), and 9CFR 416.13(c).
5309	P6137A	NJN441411 4904N-1	11/04/2013	04A06	Poultry Finished Product Standards	C	At approximately 0911 hours, while performing the finished product standards check on the reprocessing line, I found six carcasses with trim defects. Four of them had cellulitis lesions on the breast and flab areas ranging from three to one square inches, one carcass had a large mutilated area about two square inches on the breast, and another had part of the cloacae and intestine still attached (approximately one inch long). Also, I found a carcass that was contaminated with ingesta on the crop area. I immediately stopped the reprocessing line and showed Mr. (B)(6), and Mr. (B)(6) my findings and informed them of the forthcoming noncompliance. The plant failed to keep the reprocessing line in compliance with the federal regulations. 9 CFR 381.86 states: "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole carcass shall be condemned." 9 CFR 381.91(b)(1) states: "Any carcass of poultry accidentally contaminated during slaughter with digestive tract contents shall not be condemned if promptly reprocessed under the supervision of an inspector and thereafter found not to be adulterated. Contaminated surfaces that are cut shall be removed only by trimming. Contaminated inner surfaces that are not cut may be cleaned by trimming alone, or at an approved reprocessing station away from the main processing line, by any method that will remove the contamination, such as vacuuming, washing, and trimming, singly or in combination. All visible specks of contamination must be removed, and if the inner surfaces are reprocessed other than solely by trimming, all surfaces of the carcass shall be treated with (b)(4) water containing (b)(4) ppm available (B)(4) "

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH280211 3904N-1	11/04/2013	01C01	Operational SSOP Record Review	C	At approximately 0100 hours on 11/4/13 Inspection observed the following noncompliance. While a performing scheduled SSOP Records Review task for the night of production that began on 10/31/13, a SSOP deficiency was noted for 11/1/13 at 0257 hours. The deficiency involved 90 lbs of WOGS on the floor. The establishment determined the chiller exit belt diverter gate was at fault. The establishment gave a preventive measure of (B)(4) There was no notation/documentation in the SSOP Record that this preventive measure was performed. This is a noncompliance of section 9CFR 416.15(b) and 9CFR 416.16(a). (B)(6) was notified of this noncompliance. Refer to NR#NHH1201100414N for a similar noncompliance.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1326 1	M33901	HAY112211 1802N-1	11/02/2013	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of November 2, 2013 (Saturday) at approximately 2055h while performing the Operational SSOP Review and Observation task, I observed the following noncompliance: I, CS(B)(7)(C), observed 5-10 droplets of condensation located on the underside of a drip pan &nbsp;directly above Line¹⁶ product.&nbsp;Raw, unfrozen wing poultry product was being processed on line¹⁶ when I observed the condensation droplets.&nbsp;I immediately informed the lead person for the line (Mr. (B)(6)) to stop the line.&nbsp;He had the line stopped and proceeded to find some plastic to cover the product, but before he could return with the plastic I observed it drip onto product located on the stopped line.&nbsp;I immediately informed management (Ms (B)(6)) that product on the line had been contaminated with the dripping condensate from the drip pan.&nbsp;She condemned about 5 lbs of wing product and removed several feet of the plate freezer film the product was on to restore sanitary conditions.&nbsp;As a preventive measure, she informed me that someone had turned the fan off that was used for adequate ventilation above line¹⁶ &nbsp;She immediately turned it on and informed me she would retrain her employees to keep the fan on.&nbsp;After this preventive measure was stated, &nbsp;sanitary conditions restored and the product involved condemned, I allowed production to resume.&nbsp;As a regulatory action, I had the line stopped, but a U. S. tag was unnecessary since I remained until all corrective actions were taken that met 416.15. &nbsp;Production resumed at approx. 2100h. The establishment's Standard Operating Procedures for Sanitation (Part 2; Section 1) states: (B)(4)</p> <p>.&nbsp;&nbsp; Lack of adequate ventilation and ineffective SSOP monitoring failed to prevent product and product contact equipment from contamination with condensation.&nbsp;In addition, regulatory requirement for 416.13(c), 416.2(d) and 416.1 were not met. For a similar noncompliance record with the same cause (inadequate ventilation to control condensation) please refer to HAY0614093509N/1 dated 9/9/13.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4201114 502N-1	11/01/2013	03J02	Slaughter HACCP	C	<p>On 11/01/2013 at approximately 0819Hrs, I observed that the establishment failed to remove the WIP (work in process) tag prior to putting the reprocessed whole body turkeys into production flow. I saw two plant employees taking whole body turkeys out of a barrel and putting them into a tank containing whole body turkeys. The barrel was tagged with a WIP (work in process) red tag. The tank of whole body turkeys had been released by the HACCP Monitor. One employee was putting the whole body turkeys from the tank onto the blue incline which was taking the birds into the chiller. U.S. Retain Tag NO: B39554900 was applied to the tank containing the WIP birds from the barrel. Ms. (B)(6) was near by and was notified of the noncompliance. She called (B)(6) to come to the chiller incline. Mr. (B)(6) was notified of the noncompliance and showed the WIP tagged empty barrel. I notified Mr. (B)(6) that the employees had put the bird from the barrel into the tank. He questioned the employees. He took immediate corrective actions. He had all of the birds in the tank reconditioned bird by bird with (b)(4) ppm (b)(4) water spraying. The whole body reprocessed birds were released back to production flow at approximately 0848Hrs after verifying the plant's appropriate corrective actions and reinspection. This observed incident of personnel not following the establishment's Reprocessing Whole body Turkey's WIP procedure is in violation to the Reprocessing Whole body turkeys HACCP Plan monitoring for CCP 1B. The in place CCP 1B is to comply with 9 CFR 381.65(e) zero tolerance for feces and the plant's in place monitoring 9 CFR 417.2(c)(4). This noncompliance is being linked to noncompliance (#118) JDD2321092618N/1 dated 9/18/2013 for the same cause respectively.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN511911 0401N-1	11/01/2013	04A06	Poultry Finished Product Standards	C	<p>At&nbsp;1545 hours, I was performing a zero tolerance verification task on the tubs of salvaged parts in the evisceration department.&nbsp;I randomly selected 5 pieces of salvaged parts from each tub.&nbsp;I found one piece of drum stick contaminated with unidentified black foreign material in a tub identified from A-line. &nbsp;The size of the foreign material was approximately ½ centimeter by ¼ of centimeter, I tagged the tub with the USDA retain tag # B43303858, and showed my finding to (B)(6), and (B)(6).&nbsp;The product was released after the corrective actions were proffered,&nbsp;which involved reworking the tub of product.&nbsp;I also informed&nbsp;(B)(6),&nbsp;of the non compliance with 9 CFR 381.65(a) which states: "Operations and procedures involving the processing, other handling, or storing of any poultry product must be strictly in accord with clean and sanitary practices and must be conducted in a manner that will result in sanitary processing, proper inspection, and the production of poultry and poultry products that are not adulterated."</p>
5310	M6137B	FFA0713113 901N-1	11/01/2013	01D01	SPS Verification	C	<p>On November 1, 2013 while making a routine patrol of the establishment's raw production department; (kitchen) I observed noncompliance with SPS regulatory requirement(s) 416.2(d), 416.1, 416.4(d) and 416.2(b)(1). At 10:44 hours I observed beaded dripping condensation on the bottom side of the gray beams and iron rails between oven #1 & #2 loading areas in front of stuffer #6; no product affected. As well there was a brass valve leaking water onto the walls and the white pvc pipes behind the small blender. (B)(6) were notified and shown the condensation and (B)(6) was notified and shown the leaking valve. This NR represents SPS noncompliance of the regulations cited above; as well as written notification that failure to comply with regulatory requirement(s) may result in additional regulatory or administrative actions as described in 9 CFR 500.4.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD4511100 430N-1	10/30/2013	01B01	Pre-Op SSOP Record Review	C	On 10/30/2013 at approximately 0050Hrs while performing pre-operational sanitation of the plant's Chiller B; MSP, Boning Room and Raw Fabrication Grinding Departments, after the plant Q.C. and before start up of production, I observed the following noncompliance. (B)(6) were notified of the noncompliance and shown all incidents. I observed all corrective actions to food contact surfaces. 1.) Evisceration - Chiller B- The 6th. bays section had 4 pieces of meat and one meat residue. 2.) MSP and Boning Room - The # 4 cylinder had meat on the inside. B.) The grey thigh trim belt on the top side had meat residues. 3.) Raw Fabrication Grinding Room - The (B)(4) (injector) had meat and meat residues. This observed incidents of food contact surface found with meat and meat residues from previous days operations is in violation to 9 CFR 416.4(a); 416.4(d) and 416.13(c). This noncompliance is being linked to noncompliance (#143) JDD3811102726N/1 dated 10/26/2013; (#136) JDD1711103122N/1 dated 10/22/2013, and (#135) JDD1507102418N/1 dated 10/18/2013 for the same cause respectively.
5129	M210	LQN160910 0730N-1	10/30/2013	01D01	SPS Verification	C	At approximately 0615 while performing hands on Pre-Operational Sanitation, on October 30th, 2013, after company Pre-Operational Sanitation and before the start of production in Zone E, I observed a non compliance with the (b) (4) Blenders.I requested that both of the chain drive cabinets (5' wide X 6' tall) for the (b) (4) Blenders be opened up for inspection. Maintenance has the tool to open the cabinets. Once the cabinets for the (b) (4) Blenders were opened, I observed the inside of the cabinets, the gears and chains were covered in a red like substance that was slick and smeared at the touch. I observed meat tissue pieces, to numerous to count, ranging in size from 1/4 inch to 2 inches from the previous days production on the inside of the cabinet doors and thru out the intire cabinet. The inside of the gear drive cabinet is a non product contact surface, but could create crosscontamination from liquid draining out the bottom of the cabinet onto the floor.This is a noncompliance of Regulation 416.1 and 416.4(b) and a failure of the company SSOP Plan Pg. 2. I (B)(6) observed the noncompliance. (B)(6) was notified and observed noncompliance (B)(6) for nights was notified and observed the cabinets. inspection was informed that sanitation does not have access to the cabinets for daily cleaning.This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5102104 030N-1	10/30/2013	04A06	Poultry Finished Product Standards	C	On 10/30/2013 at approximately 0006 hours while performing a Pre-Chill Finished Product Standards check on line (B)(6) in Plant #2, I observed the following. After taking a standard random 10 bird sample, I accumulated 45 nonconformance points. 7 of the 10 birds had crops. This exceeded the subgroup absolute limit of (B)(6) points. I contacted (B)(6) and informed him of the failure. A QC recheck failed at 0016 hours with 37 nonconformance points. 5 of the 10 birds had crops. At this point the process is judged to be out of control. Pre-Chill rechecks at 0046 and 0117 hours brought the process back into control. Post-Chill checks at 0028 hours and for every 30 minutes until 0200 hours passed. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv)(d)(4).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN230210 0430N-1	10/30/2013	01C02	Operational SSOP Review and Observation	C	<p>On Sunday October 27th, at the beginning of the night shift, CS (B)(7)(C) observed the following on the first process area: At approximately 2315 hours while walking through the slaughter area, she observed birds falling from the auto re- hang equipment on to the floor. During approximately 5 to 8 minutes the birds were consistently falling on the floor making two piles of approximately 200 birds each. Some of the birds were directly falling inside of the drain blocking the flow of water in the drain, which started to rise almost reaching the surface of the floor. (B)(6), started picking up the bird from the drain and by doing so, her boot came into direct contact with the pile of birds on the floor. As she removed the carcasses from the drain, she was holding and swinging them on top of the pile of birds on the floor. These carcasses were heavily dripping causing cross contamination on the rest of the birds. The water from the drain is loaded with contaminants including feces, which may increase bacteria growth on contaminated carcasses. She condemned the birds from the drain but proceeded to grab the hose with the intention to rinse the rest of cross contaminated birds. CSI (B)(7)(C) immediately approached her and explained to her that those birds had been cross contaminated with water from the drain. (B)(6) then proceeded to condemn the rest of the birds on the pile. Approximately a full inedible barrel was filled with condemned carcasses. There was a second employee that came to the area and grabbed the hose and started to wash the birds on the other pile. He was spraying each carcass and placing them on the re- hang conveyor. At approximately 2330 hours, CS (B)(7)(C) requested (B)(6) to perform a (B)(4) check on the hose being utilized to rinse the birds from the floor. There was no (B)(4) being supplied through this hose. She then, notified (B)(6) and proceeded to place a Rejected /Retained hold tag N0 B43303847 on the hose. This hose was not connected to the main (B)(4) piping system and therefore removed by maintenance. Another hose was connected directly from the (b)(4) piping system and brought above the auto re hang equipment and down onto the area where birds fall on the floor and are to be rinsed. The (B)(4) level on this new hose was 48 PPM. CSI (B)(7)(C) released the US hold tag, after sanitary conditions were restored. This is a failure to implement the establishment's SSOP program as written. As stated on the SSOP Part 2- Operational Sanitation, Section 1 for Evisceration, under Description of Sanitation Procedures states: (B)(4)</p> <p>(B)(6) was notified of the non compliance the morning of 10/28/2013 at approximately 0530 hours. This represents non compliance with regulatory requirements of regulations 9 CFR 416.4(d) and 416.13(c)</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH460210 2430N-1	10/30/2013	01D01	SPS Verification	C	<p>On the night shift that began on 10/29/2013, at approximately 2310, I was in the further processing department at Establishment 33900&nbsp;P. &nbsp;I was in Room 1, further processing when I observed heavily beaded condensation on the yellow hose and the electrical conduit pipes in the overhead.&nbsp;This condensation was actively dripping on the floor.&nbsp;This area has a product drop-slide and the establishment has a floor salvage procedure in the area so I was about to reject the area.&nbsp;A QA Tech in the area told me she would have the condensation dried and the floor re-washed, which she did in a timely manner so no Regulatory Control Action was taken.&nbsp;When this was done I continued monitoring the area. &nbsp;The establishment's SSOP plan objective states: &nbsp; (B)(4) ."&nbsp; &nbsp;The SSOP plan also states on page 10, paragraph 4, (B)(4) &nbsp;Regulation 416.2 (d) states "Ventilation. Ventilation adequate to control odors, vapors, and condensation to the extent necessary to prevent adulteration of product and the creation of insanitary conditions must be provided. &nbsp;The requirements of 9 CFR 416.2(d)&nbsp;was not met. &nbsp;Refer to NR #NHH4604103809N / 1, dated 10/09/2013 for similar non-compliance of dripping condensation. &nbsp;&nbsp;&nbsp; To date all measures to prevent recurrence by management may not have been implemented properly or were ineffective.</p>
5308	M6137	BXL3608105 329N-1	10/29/2013	03J02	Slaughter HACCP	C	<p>On 10/29/2013 at approximately 0046 hours while monitoring Post-Chill Finished Product Standards in Plant #1 from product exiting Chiller #2, I observed the following. After taking a standard 10 bird sample, I observed one bird with visible fecal contamination. There was a&nbsp;cloacae&nbsp;with approximately 2" of intestine attached inside at the tail.&nbsp;The &nbsp;fecal material was inside the carcass&nbsp;on tissue under the left side fat flap. The fecal material was light brown in color, pasty in texture and measured approximately 1/4" by 1/4". This exceeded the limit of (b)(4) for the process to be in control. I had the hanging of product going into Packaging stopped. There were no QC personnel available so I performed a recheck that passed at approximately 0049 hours. (B)(6) was informed. The procedure for a Post-Chill&nbsp;fecal failure was implemented. My findings indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the CCP-2B Zero Fecal Contamination of the Plant's HACCP Plan for Slaughter.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH340510 4029N-1	10/29/2013	01C02	Operational SSOP Review and Observation	C	<p>On the night of production that began on October 28, 2013 at approximately 2340 hours in Room 1 Further Processing I observed two stainless steel scoops and two stainless steel shovels on the roller belt used to transport boxed product to the cooler.&nbsp;This belt is not considered a product contact surface and the scoops and shovels were thereby contaminated.&nbsp;When asked what the utensils were used for, Mr. (B)(6), stated the scoops and shovels were used to place ice onto product.&nbsp;The utensils were rejected with US tag B38075687.&nbsp;Mr. (B)(6) was notified the noncompliance would be documented on a noncompliance record.&nbsp;Mr. (B)(6) restored sanitary condition to the utensils and as a verbal preventive measure, stated the responsible employee would be retrained to properly handle the scoops and shovels.&nbsp;The regulatory control action was then released.&nbsp;At approximately 2345 hours at the end of the grade A wog line, boxes with plastic liners were stacked on each other such that the outer surface of the box contacted the inner surface of the liner, a product contact surface, thereby contaminating the liners.&nbsp;Six boxes and liners were rejected with US tag B38075683.&nbsp;Mr. (B)(6), was notified of the noncompliance and informed it would be documented on a noncompliance record.&nbsp;Inspection observed as Mr. (B)(6) discarded the packaging material.&nbsp;As a preventive measure, Mr. (B)(6) stated the responsible employees would be retrained.&nbsp;The regulatory control action was then released. The establishment's SSOP plan states (B)(4) " The requirements of 9 CFR 416.13(c) were not met. For a similar noncompliance refer to NR NHH5113102621N/1 dated October 21, 2013.&nbsp;The preventive measure for this noncompliance was employees would wash their hands prior to handling product.&nbsp;These measures may have been implemented incorrectly or may have been ineffective at preventing recurrence.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2815101 226N-1	10/26/2013	01C02	Operational SSOP Review and Observation	O	On 10/26/13 at approximately 1251 Hours while performing Operational SSOP Review and Observation task in cooler # 1. I observed the following non-compliance . I observed a stainless tank containing approximately 1652 pounds of edible necks with a tank liner that was torn along the top sides of the liner. Brown and black grease was observed along side the non food contact surface of the liner near the tears in the liner. No grease came into contact with product. I immediately took regulatory control by applying U.S. Retain tag # B39554887 to the tank and informing (B)(6) of my findings. Mr. (B)(6) took immediate corrective action in my presence by removing effected part of the liner and replacing the tank with a new cover. Sanitary conditions were restored and regulatory control was relinquished.
5112	M18909	JDD3811102 726N-1	10/26/2013	01B02	Pre-Op SSOP Review and Observation	C	On 10/26/2013 at approximately 1220Hrs while performing pre-operational sanitation of the plant's Evisceration, Raw Fabrication, MSP and Bag Line Departments, after the plant Q.C. and before start up of production, I observed the following noncompliance. (B)(6) and (B)(6) were notified of the noncompliance and shown all incidents. I observed all corrective actions to food contact surfaces and non food contact surfaces. 1.) Evisceration - Trussing table (food contact) had UFM (rail type) dripping from the overhead line. One was flake black pieces and One was black liquid dripping. b.) Gizzard Splitter and Gizzard Defatter (food contact) - both had meat pieces; gizzard peel and feathers. c.) Chiller Transfer A to B - 3 pieces of meat. 2.) Bag Line- Yellow line had one meat and one trachea on bottom side of conveyor (non food contact). The Red line had two pieces of meat on bottom side of conveyor (non food contact). The Blue line conveyor (food contact) had UFM flakes (brown & black) which fell from the ceiling when the employee was removing condensation. 3.) Raw Fabrication - Poss Machine (food contact) had meat on 2 of the parts and one piece of meat on the metal detector (inside). 4.) MSP - Beehive screen (food contact) had 2 pieces of meat. One part had meat residues; One long pipe had 2 pieces of meat. The observed incidents of food contact surface found with meat, meat residues, feathers and black & brown UFM from previous days operations is in violation to 9 CFR 416.4(d); 416.13(c) and 416.4(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance is being linked to noncompliance (#136) JDD1711103122N/1 dated 10/22/2013 and (#135) JDD1507102418N/1 dated 10/18/2013 for the same cause respectively.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4507103 926N-1	10/26/2013	03J02	Slaughter HACCP	C	On 10/25/2013 at approximately 2200 hours while reviewing a previously requested copy of the establishments' computer records, I observed the following. It appeared that since 10/16/2013 when red water readings in chiller #3 at 2316 hours that the establishment has been adding (B)(4) to Chiller #3 while 'Organic' product was being processed. After startup for slaughter; kill date 10/26/13 at approximately 0100 hours; I checked the computer records and found entries at 12:14 PM that 'Makeup water' was 34ppm and at 2301 hours that the red water was 3.9ppm. A review of the establishments' HACCP Plant for Slaughter for Plant #2-Organic" Step 24 'Carcass Chilling' under Potential Hazards Introduced, Controlled, or Reduced at this point (c): Chemical has "NONE Identified". I contacted (B)(6) and asked him about the (B)(4) being used in Chiller #3. I read him the section from the HACCP Plan for Slaughter -Organics which does not include a reference for the use of (B)(4) as a processing aid and informed him of the noncompliance for an inadequate hazard analysis. My findings indicated a noncompliance with 9 CFR 417.2(a)(1), 9 CFR 417.2(c)(1), 9 CFR 417.2(c)(2)(i), 9 CFR 417.2(c)(3), 9 CFR 417.4(a)(3)(i), 9 CFR 417.5(a)(1) and 9 CFR 417.5(a)(2).
5308	M6137	BXL4716100 426N-1	10/26/2013	01C01	Operational SSOP Record Review	C	On 10/25/2013 while performing an Operational Sanitation Records Review Task, I observed that there was no SSOP Log for the Loading Dock on 10/20/2013, A.M. shift. I asked (B)(6) about the missing SSOP Log and she informed me that she would investigate the matter as it was the A.M. shift Log. The next day, 10/26/2013, (B)(6) informed me that no SSOP Log for the "Dock" on 10/20/2013 had been documented. The SSOP Plan states in part, that QA Inspector or designee (B)(4) I informed (B)(6) of the noncompliance. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.13(b), 9CFR 416.16(a), and 9CFR 416.13(c).

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2403101 426N-1	10/25/2013	01D01	SPS Verification	O	<p>On 10/25/2013 at approximately 0517Hrs, I observed heavily beaded condensation on the bottom side of the approximately 2" wide grey beam (non food contact) which runs parallel to the white (food contact) large cooler units drip pan at the boning room rehang table. The beam is directly over the turkey processing line and processing table. The line was full of whole body turkeys at this time of my observation. I immediately notified Ms (B)(6) and showed her the beaded condensation/water. I ask for a supervisor. (B)(6) came and implemented appropriate corrective action. He had the hanging line stopped. He covered the line with plastic. He was also shown heavily beaded condensation/water which was on a grey beam over the line and also on the ceiling at the overhead turn wheel. He had the condensation removed by wiping. He restarted the line at approximately 0521Hrs. I did not observe any direct food products adulteration at this time. This observed incident of heavily beaded condensation over food products and processing line during production was creating insanitary conditions and a potential food products adulteration. This is in violation to the relevant regulation cited above. This noncompliance is being linked to noncompliance (#111) JDD4522091103N/1 dated 9/3/2013 and (#92) JDD2523074126N/1 dated 7/26/2013 for the same cause respectively. Mr. (B)(6) were notified of the noncompliance.</p>
5112	M18909	JDD2511100 026N-1	10/25/2013	06D02	Other Inspection Requirements	C	<p>On 10/25/2013 at approximately 0830Hrs, I found the establishment failed to meet the regulatory requirements to 9 CFR 381.68(b). When I looked at the plant's (presentation/line speed) checks for line One and line two. I found the speed was 42 birds per minute at 709Hrs on line two and 42 birds per minute on line One at 705Hrs. The Evisceration at this time (655 to 739Hrs) was running Consumer Tom Turkeys with scheduled weight 25 pounds each bird. The line speed was exceeded on line one and line two. This is in violation to the Maximum inspection rates for (NTIS) New Turkey Inspection System regulation chart which states in part..maximum line speed for birds weighting 16 pounds are more for two inspector on one line is 41 birds per minute. (B)(6) was immediately notified and Ms (B)(6) notified (B)(6) that a noncompliance will be issued. This noncompliance is being linked to noncompliance JDD2521095525N/1 for the same cause respectively.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3420102 525N-1	10/25/2013	01D01	SPS Verification	C	On 10/25/13 at approximately 1810 Hours while performing SPS Verification check in cooler # 4. I observed beaded condensation on the overhead beams and pipes above covered tanks of product. No product was contaminated by the condensation. I immediately took regulatory control by applying U.S. Reject tag # B39554888 to the area and informing (B)(6) of my findings. Mr (B)(6) took immediate corrective action in my presence by removing the tanks of product from the area and removing the condensation from the beams and pipes to restore sanitary conditions. U.S. Reject tag # B39554888 was removed and regulatory control was relinquished at approximately 1835 Hours.
5308	M6137	BXL0521105 625N-1	10/25/2013	03B02	Raw Non-Intact HACCP	C	At approximately 1520 hours while performing a HACCP Raw-Non Intact Records Review task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.2 (c)(4).The HACCP Monitoring Log -CCP3B- Sanitizer Concentration Verification Raw-Non Intact, dated on 10/23/2013 for AM shift, had Monitoring, Direct Observation and Records Review with the same initials. I asked (B)(6) if it was the same Quality Control or designee person that signed the HACCP Raw-Non Intact Log. She informed me later that the Direct Observation was performed by the same person that performed the monitoring of activities and Records Review. I explained that Quality Control or designee can not perform Direct Observation on their own monitoring activities. I informed (B)(6) about the noncompliance.
5308	M6137	BXL1121102 425N-1	10/25/2013	03J02	Slaughter HACCP	C	At approximately 1500 hours while performing a HACCP Slaughter Records review task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.2 (c)(4).The HACCP monitoring Log -CCP2B- Final Bird Washer, Plant #2 (Line (B)(4) and (B)(4)) AM shift had the following Zero Tolerance checks times: Line (B)(4), 0333 hours and 0440 hours. Line (B)(4), 0340 hours and 0447 hours. The gap between the two checks on Line (B)(4) was one hour and seven minutes and on Line (B)(4) was one hour and seven minutes also.The HACCP Plan states in part under monitor procedures that "(B)(4) (B)(4)". I informed (B)(6) of the noncompliance.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5023105 525N-1	10/25/2013	01B01	Pre-Op SSOP Record Review	C	<p>On 10/24/2013 at approximately 2200 hours while performing a records verification procedure required by the establishments' (NOIE) issued on October 7, 2013, I observed the following. The establishments' Pre-Operational Sanitation - Bio Trace Sampling Log - Evisceration/Packaging for the week of 10/18/2013 registered a failure of ss (stainless steel) tanks in Area #5 on 10/18 with a reading of 1514 measured in Relative Light Units (RLU's). The unit was recleaned and a retest registered 43. The 'Corrective Action' section on the form has not been updated with the new requirements outlined under the Establishments' 'Notice of Deferral Verification Plan of October 13, 2013. Which states under the Sanitation Standard Operating Procedures (SSOP) and Sanitation Performance Standards (SPS) section, item 16, in part (B)(4)</p> <p>(b) (4)</p> <p>"The required 5 rechecks are not documented because (B)(6) was not aware of the new requirements. I discussed the noncompliance with (B)(6) and made her aware of the new requirements. My findings indicated a noncompliance with 9 CFR 416.12(a), 9 CFR 416.(a),(b) & (c), and 9 CFR 416.16(a).</p>
5309	P6137A	NJN020510 4125N-1	10/25/2013	04C05	Poultry Good Commercial Practices	C	<p>At 0230 AM on October 25, 2013 during the night shift at Est. P 6137A, I observed the following non compliance: A carcass, which clearly showed signs of having died by means other than slaughter, was found coming down evisceration line B. The carcass was congested on one side, with large areas of icthemia on the breast. The viscera was very congested, and the liver was very dark, congested, and friable. I showed the carcass to (B)(6) and (B)(6). Regulations not met include 9 CFR 381.65(b) which states that poultry must be slaughtered in a manner which will result in thorough bleeding of the carcass, 9 CFR 381.71 which states that carcasses showing on antemortem any disease or condition that would cause condemnation on post-mortem inspection shall be condemned, 9 CFR 381.83-Carcasses showing evidence of septicemia or toxemia, or evidence of an abnormal physiological condition shall be condemned. This would include dying chickens as well as those dead on arrival.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
4630	M7322	AOA321110 3924N-1	10/24/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On 10/24/13 while performing Sanitation Standard Pre-operational Inspection. The following deficiencies were observed after the establishment's Q. C. Technician had informed me that the establishment's inspection was complete. 1. At approximately 0418 hours I observed a roll of blue plastic liners that were wet with an unidentified type of liquid, laying directly on top of a wooden pallet that had approximately 9 bags of uncovered evaporated salt stored on it. The blue liners have been observed in used to cover combos that contain edible product. The manner that the blue combo liners (product contact surfaces) were stored could have cause insanitary condition to the product. (B)(6) was notified. No reject tag was applied as I observed immediate corrective actions. The area was release at approximately 0425. 2. At approximately 0501 hours, before FSIS had completed the inspection of the peel room area to determine the sanitary conditions, I observed an employee attempting to enter the peel room area with a pallet that contained a roll of blue combo liners (product contact surface) and dry ingredients. The outer layer of the liner had a misty looking liquid covering the surface and the liners were observed lying directly on top of the bags of dry ingredients with undetermined sanitary conditions. The employee's actions to enter the area with product before pre-op inspection was completed and the condition of the blue combo liners (product contact surfaces), did not meet the requirements outlined in, FSIS-PHIS Directive 5000.1 "Verifying an Establishment's Food Safety System", Chapter 2 part III "Sanitation Standard Operating Procedures (Sanitation SOPs) (B)(6) was notified. 3. At approximately 0520 hours I observed 2 batter pumps that had some thick whitest liquid looking material coming out of the bell areas while maintenance was attempting to prepare them for my inspection, while inspecting the pumps I observed some highly visible creamy whitish looking material build up inside the metal portion of the pump and around the inside rubber seal area. The whitish material appeared to be product batter left from the previous day's production. Official control action was taken. (B)(6) was notified. U.S. retain tag #B22393369 was applied. Q.C. informed me that the area had been cleaned and was ready for re-inspection. While I was re-inspecting the pumps, I observed some whitish dry crusty looking substance around the entire edge of the inside seal of one of the pumps. (B)(6) was notified. The area was released at approximately 0558 when corrective measures were verified by FSIS. 4. At approximately 0534 hours while inspecting the frank product wash sinks located at the end of each fryer in the frying room, I observed some sticky, gluey material at the top right hand corner on 3 sinks (at fryers #s 2, 3 & 7). The material was covering an area approximately 6X4 square inches. The material appeared to be the glue or tape left as a result of removing the equipment label signs (Frank Wash Sink). The (B)(6) was notified. No reject tags were applied as I observed immediate corrective action by</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							the establishment. The area was released at approx. 0608 hours. -The deficiencies describe on this noncompliance record did not met all the requirement of 9CFR 416.13(c), 416.1, 416.4(a) 416.4(d).-This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).
5112	M18909	JDD0402105 225N-1	10/24/2013	03C02	Raw Intact HACCP	C	<p>On 10/23/2013 at approximately 0900Hrs, Dr. (B)(7)(C) and I reviewed the 10/18/2013 (Chicken (B)(4) Monitoring Log) during our records review. We found that the plant failed to document what was done to the product as part of the plant's corrective action when the (B)(4) level was 2300ppm which is above the recommended level of use. The plant's Quality Control Raw Fabrication (b)(4) (b)(4) Log for Chicken (B)(4) showed that on 10/18/2013 at 1606Hrs, the Boneless Chicken Breast with Rib Meat concentrations were 2300ppm. As part of the plant's corrective action for (b)(4) the maintenance was informed. The record did not show what happened to the product. The plant's HACCP Plan identified (b)(4) chemical contamination as "not likely to occur" because of an established (B)(4) Monitoring program (Attachment # 7) (FTP1 (B)(4) Monitoring T1.1/090 Revision # 2 page 2 of 2 date 12/16/11). The (b)(4) procedure states, (b)(4)</p> <p>"&nbsp;&nbsp;&nbsp;The 2300ppm is above the recommended use by the supplier. The Plant Chicken (B)(4) Monitoring Record did not document the corrective action done to the product when the (b)(4) level was at 2300ppm.&nbsp;&nbsp;&nbsp;This failure to document the corrective action done to the Chicken Breast food products is a recordkeeping violation to 9 CFR 417.3(c) which states, "All corrective actions taken in accordance with this section shall be documented in records that are subject to verification in accordance with 417.4(a)(2)(iii) and the recordkeeping requirements of 417.5(a)(3) of this part" and 5000.1 (B)(6) and (B)(6) were notified of the noncompliance.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1301100 125N-1	10/24/2013	01C02	Operational SSOP Review and Observation	O	<p>On 10/24/2013 at approximately 0841Hrs, Dr. (B)(7)(C) observed a plant Boning Room personnel using a inedible red labeled stainless steel hook/rod (hand tool) to scoop together 16 pieces of drumsticks that fell on the floor underneath the drumstick conveyor belt prior to the feeding of drumstick to be deboned in the drumstick (B)(4). The floor is a non food contact surface and the plant employee tried to scoop the product towards her by using a red labeled hook which is used for inedible product only according to Plant Good Commercial Practice. By scooping the products towards her, she further contaminated the product by allowing drumsticks to brush against the floor, a nonfood contact surface. She placed the drumsticks in a white edible barrel for reconditioning. U.S. Retain Tag NO: B39554834 was applied to the edible barrel containing the affected 16 drumsticks. (B)(6) was immediately notified of the noncompliance and showed the drumsticks in the edible barrel and inedible hook used on the product. Mr. (B)(6) chose to plant condemn the affected drumsticks. This observed incident of an employee using a inedible hand tool to scoop up dropped edible product which she put into an edible barrel for reconditioning is a violation to the relevant regulation cited above. This is also in violation to the establishment's in place Operational Sanitation 11-A.) # 2.) (B)(4)</p> <p>" B." (B)(4)</p> <p>was not met. Also the establishment's in place GMP (good manufacturing practices) "Production tools: Stainless rod/hook with red tape - inedible use or inedible product." was not implemented.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0405101 824N-1	10/24/2013	01D01	SPS Verification	C	On 10/23/2013 at approximately 2225 hours while monitoring Pre-Operational Sanitation in Plant #1, I observed the following. There were metal splinters on a guide bar associated with the bird drop assembly at the point where carcasses enter chiller #2. The splinters measured approximately 4mm to 10mm in size. The guide bar is worn with the edges raised and flattened. The splinters were flaking off from the flattened edges. The loose splinters were removed. (B)(6) will have maintenance remove the flattened edges after production. At this point in the process carcasses are being removed from the evisceration line and dropped into the chiller. With the affected guide bar directly above the carcasses the metal splinters will end up in the carcasses or in the chiller. At approximately 0025 hours in Packaging Area #2 there was a small flake measuring less than 1/4" that appeared to be red paint on an overhead product belt near the entrance to the (b)(4) room. The fire fighting piping throughout the (b)(4) room has deteriorated with rust and loose peeling flaking red paint throughout. I informed (B)(6) of the noncompliance. A work order will be submitted. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(2).
5308	M6137	BXL0813105 024N-1	10/24/2013	03J02	Slaughter HACCP	C	On 10/23/2013 at approximately 1008 hours while conducting a Post-Chill Finished Products Standards procedure on product exiting Chiller #4 in Plant #2, I observed the following. After collecting a standard 10 bird sample, I observed one carcass with a shiny piece of metal approximately 3mm in size attached to the connective tissue by the neck area. I informed (B)(6) and (B)(6) of the noncompliance. According to PDD, FSIS considers metal of any size on a carcass to be an unacceptable contaminant that should be addressed by the establishments' Hazard Analysis. The Establishments' HACCP Plan - Slaughter Plant #2 under (P) Physical Hazards states (B)(4). The product was on a chiller exit conveyor belt just prior to hanging for final microbial intervention and packaging. The issue of metal contamination has been discussed at previous morning meetings with the establishment. One tank of whole birds was retained by Quality Control. The birds were reworked and released by Quality Control. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.4(d), 9CFR 417.3(b)(1), 9CFR 417.3(b)(2), 9CFR 417.3(b)(3), and 9CFR 417.3(b)(4).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH210310 4123N-1	10/23/2013	01B02	Pre-Op SSOP Review and Observation	C	On the night of production which began on 10/22/2013, inspection performed; PHIS procedure; SSOP Review and Observation in the 2nd Processing Department of 33900 P. This was after Sanitation had finished cleaning the equipment and QA had finished their Pre-operational inspection of the equipment and released the area to production. There are no additional Sanitation or Pre-operational steps prior to the start of production. The following noncompliance was observed: At 2318 hours while waiting for the birds to exit the chiller for a Post chill testing of line 1, I noticed grease residue on the shackles. I proceeded on to the hang line where I found the shackles (Product contact surface) in an unsanitary condition with grease residue, and debris particles. Inspection took Regulatory Control Action by applying US Reject Tag #B38075587 to the hangline until it was recleaned and reinspected, and was released at 2338 Hours. (B)(6) was shown the noncompliance. To date, all Preventive Measures may not have been implemented as described or were ineffective in preventing recurrence.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH442310 5223N-1	10/23/2013	01B02	Pre-Op SSOP Review and Observation	C	On the night of production which began on 10/23/2013, Inspection performed scheduled PHIS procedure Pre-op SSOP Review and Observation in the Evisceration Department of 33900 P. This was after Sanitation had finished cleaning the equipment and QA had finished their Pre-operational inspection of the equipment and released the area for USDA inspection. There are no additional Sanitation or Pre-operational steps prior to the start of production. The following noncompliance was observed: At 2037 hours while checking Line #1 Paw Unloader (Unit #1/Zone #2), Inspection found the Picker Fingers (Product contact surface) in an unsanitary condition with a greasy black residue which would easily rub off onto the hand. Inspection took Regulatory Control Action by applying US Reject Tag #B29699073 to the Unit until it could be recleaned and reinspected, and was released at 2104 Hours. The Requirements of 9CFR 416.13(c) were not being met and (B)(6) was shown the noncompliance and advised that a Noncompliance Record would be issued. This item of Equipment was randomly selected for Inspection as required. For a similar noncompliance refer to NR #NHH4900083727N/1 dated 08/26/2013. To date, all Preventive Measures may not have been implemented as described or were ineffective in preventing recurrence.
4630	M7322	AOA580710 3722N-1	10/22/2013	01B02	Pre-Op SSOP Review and Observation	C	On 10/22/13, while performing Pre-Operational Sanitation Standard Operational Procedures Inspection, after the Establishment's Quality Control Technician informed me that her inspection was complete and the areas were ready for processing, the following deficiencies were observed: 1. At 0539 hours I observed what appeared to be bread crumbs (to numerous to count) on the product contact surface of the retail line incline conveyor belt that is located immediately after the retail line wide pack out belt. Official control action was taken. (B)(6) was notified. US reject tag #B23922689 was applied. I released the area at approximately 0556 hours when correct measures were verified. 2. At 0552 hours I observe the freezer product decline belt and stainless steel slide pan at the retail processing line area had what appeared to be very visible dry and wet bread crumbs to numerous to count (over 20) on the open left area of slide pan and randomly scattered throughout the product conveyor belt. There were what appeared to be loose bread crumbs, product grease and scum build up on bottom product conveyor guide rails and turn wheels. Official control action was taken. (B)(6) and (B)(6) was notified. US retain tag #B8541730 was applied. The area was released at approximately 0615 hours when corrective measures were verified. -The listed deficiencies did not meet the requirements of 9 CFR 416.13(c) & 9 CFR 416.4(a).-This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0711105 822N-1	10/22/2013	03J02	Slaughter HACCP	C	On 10/22/2013 at approximately 1325Hrs, I observed the collection barrels of Turkey Fries at both lines. The plant's attached tags showed the time of collection was 1100Hrs (2300). U.S. Retain Tag NO's: B39554883 & 84 were applied to the barrels of fries with temperatures 95.7F & 92.6F. The establishment's CCP 2B requirement for fries had exceeded the time and temperature of 40F within 2 hours of harvesting. The turkey fries did not have any ice or CO2. When I presented this to management, (B)(6) informed me that they did not start collection until 1130Hrs. This observed incident is a record keeping violation to 9 CFR 417.5(a)(3) since the plants recorded time on the barrels and what Mr. (B)(6) said that the collection started time is not the same. Mr. (B)(6) chose to plant condemn the 92 pounds of turkey fries. Mr. (B)(6) was notified of the noncompliance.
5112	M18909	JDD1711103 122N-1	10/22/2013	01B02	Pre-Op SSOP Review and Observation	C	On 10/22/2013 at approximately 1020Hrs while performing pre-operational sanitation of the plant's Evisceration, Boning Room, Raw Fabrication and Cooler 9 Departments, after the Q.C. and before start up of production, I observed the following noncompliance. (B)(6) and (B)(6) were notified of the noncompliance and shown all incidents. I observed all corrective actions to food contact surfaces and non food contact surfaces except the solution screen. No retain tags were applied. 1.) Evisceration-SK5 Kill machine had dried blood on knife and feathers on (non food contact)-overhead shackles. b.) Quill Puller-had meat and feathers. c.) NE Main Scalding had feathers in the scald water and on the (non food contact) shackles (too many to count on both). d.) Picker # 4 had fat residues and feathers. e.) (b)(4) Hock Cutter had meat residues, fat and feathers. f.) Osteo room had meat, blood on the racks and feathers on the (non food contact) floor. g.) Chiller A (1st part) screens full of meat and fat. 2.) Boning Room-Thigh Deboner (B)(4) had meat and fat. b.) Drum Deboner (B)(4) had meat, fat and black UFM. 3.) Raw Fabrication Grinding- (b)(4) (injector) had meat. b.) Injection solution tank-The small screen had meat and was torn. The torn screen was taken to maintenance for repair. 4.) Cooler 9 (Raw Fabrication further processing)- The patty machine (form plate) had meat. The observed incidents of food contact surface found with meat, blood, fat, meat residues, black UFM and feathers from previous days operations is in violation to 9 CFR 416.4(d); 416.13(c) and 416.4(a). The small screen is in violation to 9 CFR 416.3(a). The non food contact surfaces not cleaned is in violation to 9 CFR 416.4(b). This noncompliance JDD1711103122N/1 is being linked to noncompliance (#135) JDD1507102418N/1 dated 10/18/2013 for the same cause respectively.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3118101 022N-1	10/22/2013	03J04	Poultry Zero Tolerance Verification	C	While performing a Zero Tolerance Fecal Task, I observed noncompliance with the following regulatory requirements of regulations 9CFR 381.65 (e) and 9CFR 417.2 (c)(4).At approximately 1447 hours, I randomly removed a 10 bird sample from Line #2 in Plant #1, I found one out the ten birds with visible fecal contamination outside of the bird on the skin of the neck. The fecal material was approximately 1/4" diameter in size, green in color and pasty in texture. This exceed the limit of (b)(4) for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance. The protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 1510 hours and it passed.This is a violation of the critical limits of CCP-2B (b)(4) of the Plant's HACCP Plan for Slaughter.
5308	M6137	BXL3614103 721N-1	10/21/2013	01C02	Operational SSOP Review and Observation	C	On 10/21/2013 at approximately 0909 hours, I observed birds coming out of Chiller #3 in Plant #2. I noticed that there were no production or Quality Control Supervisors monitoring the birds as they exited the chiller.The establishments SSOP Correcting Action Logs under 'What actions were taken or are being taken to prevent recurrence...' has consistently stated "Product will continue to be monitored by Supervision prior to being put into production". I started inspecting the birds coming out of Chiller #3 and I observed several birds with black/brown UFM on them. The employees that hang the birds coming out of Chiller #3, started arriving at the re-hang belt and I informed them not to hang the birds as I went to inform a Supervisor. I saw (B)(6) come over to the re-hang area and I showed him one of the birds with black UFM on it. He started tanking the birds and I tagged the tank with U.S. Rejected/U.S. Retained tag # B31408109. Quality Control applied their Red Hold tag on the tank and I removed my tag. I informed (B)(6) of the noncompliance.Quality Control retained ten tanks of whole birds, four pallets of front breast halves and 26 lbs. of drums, thighs, and leg quarters. The whole birds were reconditioned, the breasts were reworked, and the drums, thighs, and leg quarters were condemned. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.14, 9CFR 416.12(a), 9CFR 416.15(b) and 9CFR 416.4(d).

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN131410 2921N-1	10/21/2013	03J04	Poultry Zero Tolerance Verification	C	<p>At approximately 1140 hours, while performing PHIS Zero-tolerance task, in the Evisceration Department on the reprocessing off-line, prior to the birds entering the chiller, I observed one carcass in the ten (10) carcasses random sample contaminated with visible fecal material approximately one inch by half inch in diameter, brown in color, paste-like consistency, and located on the top of the hock joint, also there was another two pieces of fecal material on the leg approximately half inch by half inch in diameter, greenish in color pasty in consistency. I took regulatory control action by stopping the reprocessing line and applied US retain tag # B43303652 on the affected carcass. The findings were shown to (B)(6), and (B)(6). At approximately 1110 hours, the reprocessing line and the affected carcasses were released to the establishment allowing QC representative to perform the plant corrective actions. Mr. (B)(6) was informed of the forthcoming NR. The findings of fecal material on a carcass passed the final wash cabinet en route to the chilling system represents a zero tolerance failure as outlined in the establishment's HACCP and in accordance with the regulations 9 CFR 381.65(e) which states: "poultry carcasses contaminated with visible fecal material shall be prevented from entering the chilling tank". 9 CFR 417.2(c) (4) states: "List the procedures, and the frequency with which those procedures will be performed, that will be used to monitor each of the critical control points to ensure compliance with the critical limits". The establishment's written HACCP Plan dated 4/18/2013 states (b)(4).</p> <p>A similar NR was documented on 09/30/2013 # NJN2416091630N/1, no plant response. PHIS slaughter HACCP task performed to verify that all corrective and preventive measures were completed. The plant determined that the cause of the deviation was a sprayer found in wrong position not spraying the top part of the hock. The chiller overflow was turned up to ¼ gallon of water per bird, and the chiller was marked to identify the end of the effected lot. Post chill checks were performed (b)(4) until the murk came out at 1317 hours. All post chill checks were found acceptable.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN300710 5421N-1	10/21/2013	01D01	SPS Verification	C	At approximately 0249, while I was passing through the evisceration department employee break room, I observed the following non compliances: the floor had stagnant water, used paper towels and debris everywhere. I proceeded to live hang rest room I observed the floor filled with used paper towels and filthy tissues. Also the rest room had no running hot water. Mr. (B)(6) was informed and he took corrective actions to restore sanitary condition and also notified of the forthcoming non-compliance record. The Requirements of 9 CFR 416.1, 9 CFR 416.2(b) (2), 9 CFR 416.2(h) (1) and 9 CFR 416.2(h) (2) were not met. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action(s) as described in 9 CFR 500.4.
5309	P6137A	NJN560110 2321N-1	10/21/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 2252 hours, and after sanitation and QC performed preoperational sanitation and released the New Products Room for operations. I performed PHIS task, preoperational sanitation, in the area 5, Section C: IQF # 2 I observed the following noncompliance: In unit # 16 (product incline conveyor), I observed numerous pieces of fat and muscle from previous shift of production ranges from 1/8 inch to 1/2 inch in diameter. The product incline conveyor is direct product contact surface. I immediately applied U.S. Rejected tag NO. B43303520 notified and showed Mr. (B)(6), of my findings and the forthcoming NR. The unit was re-washed, sanitized, re-inspected found acceptable and released at 2300 hours. At approximately 2356 hours. CSI (B)(7) was performing pre-operation inspection in the food service area, when he observed a piece of fat, approximately four inches by one inch inside of a blue drip pan hose that is located adjacent to unit # 21 (multicut # 1) according to the pre-op schematics. Mr. (B)(6) was present during this inspection. The hose was re-washed and found acceptable. The area was released at 0003 hrs. The requirements of 9 CFR 416.1, 9 CFR 416.4(a) and 9 CFR 416.4(b) were not met. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action as described in 9 CFR 500.4.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH511310 2621N-1	10/21/2013	01C02	Operational SSOP Review and Observation	C	#160At approximately 1001 as I entered room one second processing I observed cross contamination of product at the first tray pack line. There were at least four employees were handling trays of product that had already gone through the (b)(4) wrapping and sealing machine and restyling the trayed product simultaneously and placing them back on the conveyor. Inside the (b)(4) there is a stained cloth textured belt that does not appear to be properly cleaned or sanitized daily. The wire conveyor inside the (b)(4) also accumulates a rust like buildup during operations. The blue belt at the end of the line also has a brownish buildup inside the links. These surfaces cannot be considered as product contact surfaces; therefore, once the bottom of the trays and wrappers contact these surfaces they should be handled in a manner that prevents cross contamination of the product. These requirements were not met. Us tag #B36322947 was applied to the operation and the affected product. (B)(6) and (B)(6) were shown the condition of the belts. As a preventive measure, Management stated that when reworking trayed, the employee handling and opening the trays will not handle product prior to washing/sanitizing their hands. The affected product (~35 trays) was taken to the product wash station. The area was released after sanitary conditions were restored.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0309103 919N-1	10/19/2013	03J02	Slaughter HACCP	C	<p>On 10/18/2013 at approximately 2250 hours while monitoring the Establishments' computer records for CP-5 (B)(4) pH and (B)(4) Monitoring, I observed the following. An establishment employee at 0219 hours on 10/15/2013 recorded that the 'Red Water' (B)(4) in Chiller #4 was at 8.3 ppm (parts per million). At 0651 hours also on 10/15/2013 the recorded value of the 'Red Water' (B)(4) was (b)(4) ppm in Chiller #3. At 23:01 hours on 10/16/2013 for Chiller #3 the recorded value was (b)(4) ppm. On 10/17/2013 at 0.09 hours the Red Water (B)(4) in Chiller #3 was recorded as being at (b)(4) ppm. At 0229 hours on 10/17/2013 the red water (B)(4) was (b)(4) ppm in Chiller #4. At 0608 hours on 10/17/2013 the red water (B)(4) in chiller #3 was recorded as being (b)(4) ppm. At 2252 hours on 10/17/2013 the red water (B)(4) was recorded as being at 16.3 ppm for chiller #3. At 2346 hours on 10/17/2013 the red water from chiller #3 was recorded as being at 11.8 ppm. A review of the establishments' HACCP Plan - Slaughter plant, Step 24 Carcass Chiller under Hazards lists (C) Chemical then is the hazard significant. NO. Under 'Justification for Decision' it states (b)(4) ree (B)(4) concentration for the recirculated water and the chiller water is monitored as part of a plant program. Supplement 7 CP-5 (B)(4) pH, and (B)(4) monitoring under (B)(4) Monitoring' states that (b)(4) for carcass chiller red water and that (b)(4) is the operating limit. Under 'Corrective Action' it states "Notify maintenance/production. Perform a recheck once notified by maintenance that adjustments has been made." Item 7 on the Establishments Action Plan resulting from an NOIE dated October 13, 2013 is for (B)(4) and (B)(4) lists 'Carcass Chiller Red Water and states "The operating limits are <math>0</math> ppm free (B)(4) and ph (b)(4). Even after being informed of the noncompliance as of 10/24/2013 the establishment continues to fail on a nightly basis. My findings indicated a noncompliance with 9 CFR 417.5(a)(1).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1507102 418N-1	10/18/2013	01B02	Pre-Op SSOP Review and Observation	C	On 10/18/13 at approximately 0423 hours while performing Pre-Operational sanitation after the establishments Pre-Operations checks and before the start of production in the Raw Fab # 9 cooler room I observed the following non-compliances. In the Raw Fab # 9 cooler room. I observed fat and muscle residue on the walls of entrance to the room from the previous days production, this is a non-compliance to 416.2(b)(2). Fat and muscle tissue and residue was observed on the exterior non product contact surfaces and interior product contact surfaces of the (b)(4) and (b)(4) machines from the previous days production, This is a non-compliance to 416.13(a) , 416.4(a) and 416.4(b). I immediately took regulatory control by applying U.S. Reject tag # B31390666 to the machines and room and informing (B)(6) and (B)(6) of my findings. Mr. (B)(6) and Mr. (B)(6) took immediate corrective action in my presence cleaning and sanitizing the room and machines to restore sanitary conditions.
5308	M6137	BXL0315104 718N-1	10/18/2013	03J02	Slaughter HACCP	C	On 10/18/2013 at approximately 0907 hours while performing Finished Product Standards task, I reviewed the HACCP Monitoring Log - CCP 2B- (b)(4) (Plant #2) on PM shift, Line (b)(4) and I found that one check was missing. I asked (B)(6) about the missing check because I saw the Quality Control performing a check. She informed me later that the Zero Tolerance check was performed at 0847 hours by Quality Control but not annotated in the HACCP Log at the time performed. This is a noncompliance with the following regulatory requirements of regulation 9CFR 417.5 (b).
5308	M6137	BXL1205103 018N-1	10/18/2013	01C01	Operational SSOP Record Review	C	On 10/16/2013 at approximately 2310 hours while verifying corrective action by the Establishment in response to the Notice of Intended Enforcement action dated October 7, 2013, I observed the following. The Establishments Action Plan Item 16 refers to an ATP Bio-trace procedure that was to be addressed in the Establishments' SSOP beginning October 14, 2013. The record review revealed no entry in the Establishments SSOP that addresses the ATP-Bio-trace procedure. My findings indicated a noncompliance with 9 CFR 416.12(a).

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN451610 2218N-1	10/18/2013	01D01	SPS Verification	C	<p>While in the packaging area, at approximately 10 28 hours, I noticed an employee heading towards the door of the cooler, which is located beside the spice room. He was wearing a freezer suit and stacker gloves and dragging a red trash receptacle. The trash receptacle was empty but, heavily soiled with filth. I immediately stopped him from entering the cooler with the soiled trash receptacle. Without a response, he head towards the hose in the packaging area, picked up the hose, and started to wash it down. Again, I stopped him and informed him that he is not to wash nor enter into the production area at all with any filthy contaminants. He then left the trash receptacle and headed to enter the cooler. I, once more, stopped him and told him that again his gloves were now contaminated from the trash can and he cannot enter nor touch anything in the production area, so he took them off and throw them down into the filthy trash can that he had left in front of me. I tagged the trash receptacle with the USDA reject tag # B43303655 and, since there were no supervisors at the time, I had one of the lead persons call a supervisor over. Mr. (B)(6) came to me in the packaging area and I inform him of the events and the forthcoming noncompliance. The plant failed to comply with the regulations sited. 9 CFR 416.2(h)(3) states: "Refuse receptacles must be constructed and maintained in a manner that protects against the creation of insanitary conditions and the adulteration of product." 9 CFR 416.4(b) states: "Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product." 9 CFR 416.5 states: "All persons working in contact with product, food-contact surfaces, and product-packaging materials must adhere to hygienic practices while on duty to prevent adulteration of product and the creation of insanitary conditions."</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ2416101 418N-1	10/18/2013	04A06	Poultry Finished Product Standards	C	<p>On October 18, 2013 I, CS (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is 200 points. My test at 1233 resulted in 47 points. At 1245 a retest was performed by (B)(6) using a tighten criteria of 25 points which failed with 31 points. I verbally notified (B)(6) of the noncompliance and that I would be issuing a NR. The plant implemented the required procedures for FPs failure. The Prechill nonconformances I observed at 0706 were: 3 ingesta &lt; 1/16" (3 pts), 5 partial oil glands (5 pts), 2 whole oil glands (4 pts), 2 partial lungs (2 pts), 4 whole lungs (8 pts), 1 cloaca (5 pts), 1 bursa (2 pts), 4 small feathers (4 pts), 8 large feathers (8 pts), and 3 long hocks (6 pts). On October 16, 2013, NR # OIJ151610191N (#79) was issued for processing noncompliance. The written response given is that Maintenance made adjustments to bring the process under control. This noncompliance is linked to NR # OIJ151610191N (#79) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the October 17, 2013 meeting.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5821101 818N-1	10/17/2013	03J02	Slaughter HACCP	O	<p>On 10/17/2013 at approximately 1100Hrs during my (Finish Product Standard)&nbsp;random 10 necks per sample check, I observed one turkey neck with visible fecal material out of the ten. The fecal material was found on two sites close to the base of the neck. The thick and mucoid fecal materials were medium to dark olive green with a brownish tinge which is consistent with fecal material. &nbsp;Both of the fecal materials were approximately 2" x 1/4" x 2mm thick. U.S. Retain Tag NO:B39554626 was applied to the tank which had the affected neck. I requested the sanitation personnel, who was at the turkey pickers, to notify (B)(6) to come to the neck removal and chilling area. Ms.(B)(6) was shown the fecal material on the neck. I notified (B)(6), and Dr. (B)(7)(C) SPHV&nbsp;of the noncompliance and showed them the fecal material which was still attached to the turkey neck. Dr.(B)(7)(C) concurred that it was fecal material. Ms.(B)(6) said it appears to be bile. She kept the neck. Ms.(B)(6) had all&nbsp;of the necks in the tank&nbsp;(one by one) reconditioned with (b)(4) water spraying (b)(4) ppm/trimming and reinspected. The necks approximately 1800 pounds were released back to production flow at approximately 1555Hrs after verifying the plant's implemented corrective action and reinspection by&nbsp;Ms. (B)(6). The establishment does not monitor the necks for&nbsp;fecal&nbsp;at the neck collection/ ice&nbsp;chilling tanks. The plant's HACCP Plan does not identify feces as a hazard in the neck collection/chilling. I asked (B)(6), and he said to use the CCP 3B (b)(4).&nbsp;The necks collected&nbsp;from reprocessed birds are monitored for feces at the establishment's (CCP 3B) check and when found free of feces are added to the neck chilling tank. This observed incident of visible fecal material not removed is a noncompliance to the establishment's&nbsp;CCP 3B (b)(4)s critical limit per 9 CFR 381.65(e) and 417.2(c)(4) monitoring at the critical control point prior to entering&nbsp;into the chilling tank. This noncompliance JDD5821101818N/1 is being linked to noncompliance (#112) JDD1623092204N/1 dated 9/4/2013 for the same cause respectively.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1205100 417N-1	10/17/2013	04A06	Poultry Finished Product Standards	C	On 10/16/2013 at approximately 0334 hours while monitoring Post-Chill Finished Product Standards from product exiting the Chillers in Plant #2, I observed the following. The last of the carcasses were coming out of Chiller #3. The Post-Chill Finished Product Standards log for the shift had an establishment entry for product exiting Chiller #3 at 0032 hours. No further checks were made by the establishment for the shift for chiller #3. Periods between checks at the post-chill are not to exceed (b)(4). I contacted (B)(6) and informed him of the noncompliance. I checked with live hang and they finished hanging 'Organic' at 0152 hours. My findings indicated a noncompliance with 9 CFR 381.76(e)(1)(i).
5308	M6137	BXL4620105 417N-1	10/17/2013	01C02	Operational SSOP Review and Observation	C	On 10/17/2013 at approximately 1735 hours, while walking pass the Re-hang area in Plant #1, I observed the following noncompliance. There was a tank of whole birds, approximately 1/4 full next to the chick weight line #1. Directly above the tank was a drip pan that was dripping water into the tank of birds. I tagged the tank with U.S. Rejected/U.S. Retained tag #B31408104 and I informed (B)(6) and he called (B)(6) who I informed of the noncompliance. The birds were washed at approximately 1800 hours, I removed the tag and the tank was washed, restoring sanitary conditions. My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.1 and 9CFR 416.4(d).
5310	M6137B	FFA5601105 717N-1	10/17/2013	04B04	General Labeling	C	On October 16, 2013 at approximately 2200 hours, while performing Operational Sanitation in Cooler #2, I observed five white edible barrels full of franks with no identification or labels. I immediately tagged the product with U.S. Retain Tag NO. B34377191, B31408670, B31408539, B31408537, B31408662. Ms. (B)(6) and Ms. (B)(6) was informed and showed the noncompliance. Immediate Corrective Action was implemented by Management: All five barrels of franks was condemn in my presence. After product was condemn and denatured U.S. Retain Tags were removed. This does not comply with CFR 9 381.116 which states in part: "Wording on labels of immediate containers". This noncompliance is linked to NR# FFA5218091320N/1 dated 09/20/13, for a similar noncompliance. As of today 10/16/13, Management has not given a written response to this NR. This NR serves as written notification of a labeling noncompliance. Continue failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH081310 4417N-1	10/17/2013	01C02	Operational SSOP Review and Observation	C	On Thursday, October 17, 2013 while leaving the Evisceration Department at approximately 1110 hours I observed the following noncompliance. At the Reprocessing Area in evisceration there were totes and lids staged to be used for parts on a dollie. There was two stacks that had ten each in them. The top two totes were found to be in an insanitary condition. There was black specks inside the totes. I removed the top two totes and checked three more totes they had black specks in them too. One of the totes had some dried fat inside of it. The totes (20) were rejected with US Reject Tag # B 29 699853. Mr. (B)(6), was notified and informed the noncompliance would be documented on a noncompliance report. Mr. (B)(6) had the totes taken back to the tub wash room to be rewashed. As a preventive measure, Mr. (B)(6), said "the employee that is responsible for getting the totes for reprocessing would check each tote before they bring it to the Reprocessing Area". The requirements of 9 CFR 416.13(c) were not met. The establishments SSOP plan states (B)(4) "There has not been a similar noncompliance written in the last thirty days.
1325 7	P33900	NHH181210 5817N-1	10/17/2013	03J02	Slaughter HACCP	C	On Thursday, October 17, 2013, at approximately 1101 hours, while performing Poultry Finished Product Standards (Prechill) on Evisceration Line #1, I observed fecal contamination on the outside of the tenth carcass randomly selected for the ten bird sample. The fecal material was located on the back of the carcass underneath the oil gland. There was two pieces of fecal, both approximately 1/8 inch in size and light brown in color. It had a watery texture to the touch. There were no plant employees between me and the chilling tanks when I performed this check. Therefore, it is reasonable to assume that the feces would have entered the chilling tanks in violation of Regulation 9 CFR 381.65(e). Ms (B)(6), was notified of the deviation for the Critical Control Point CCP-1, (b)(4) at CCP-1, and she was shown the carcass. She immediately implemented the establishment's corrective action for visible feces at CCP-1. At 1115 hours, Mr. (B)(6), notified me that the cause of the noncompliance was equipment malfunction. Mr. (B)(6) stated, "that the Bird Brush was turning in the wrong direction". Maintenance corrected the direction of the motor. The preventive measure that was given was that production will perform two checks on the Bird Brush two times for the rest of the shift. A similar noncompliance was documented on NR NHH4602090526N/1 dated 09/26/2013. The further planned action may not have been implemented or was ineffective in preventing the reoccurrence of this similar noncompliance.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD0123100 616N-1	10/16/2013	01C02	Operational SSOP Review and Observation	C	On 10/16/2013 at approximately 1140Hrs, I observed UFM (unidentified foreign material) on the Chiller B exit food contact belt. The UFM was very black in color; thick/smear grease type when touched/rubbed. The thick UFM was smeared approximately 1" x 10" in size on the food contact belt. The UFM appeared to be a drip/chunk and then smeared. The food contact chiller belt was full of whole body heavy tom turkeys at this time. I saw (B)(6) near the Bagging Area. I notified her of the UFM on the belt. She called (B)(6). U.S. Retain Tag NO:B39554696 was applied to the affected food contact belt. I showed the UFM to Mr. (B)(6) and Ms.(B)(6). Mr. (B)(6) stopped the belt and removed the UFM from the belt using sanitized towels. The belt was released for operations at approximately 1142Hrs after verifying the restored sanitary conditions. U.S. Retain Tag No's: B39554115 & B39554424 were applied to one and 3/4 tanks of whole body turkeys which were on the affected conveyor belt. At approximately 1230Hrs the (2800 pounds) of heavy tom turkeys were released back to production flow after verifying the plant's implemented reconditioning by (b)(4) ppm (b)(4) water spraying/trimming and reinspection. One Turkey was found with UFM. Mr. (B)(6) was notified of the noncompliance. This observed incident of UFM on a food contact surface during food production operations is in violation to 9 CFR 416.4(a); 416.4(d) and monitoring of the plant's operational sanitation 9 CFR 416.13(c). This noncompliance JDD0123100616N/1 is being linked to noncompliance (#130) JDD2422102710N/1 dated 10/10/2013; (#119) JDD1922091518N/1 dated 9/17/2013 for the same cause respectively.
5112	M18909	JDD3123104 616N-1	10/16/2013	01C02	Operational SSOP Review and Observation	C	On 10/16/2013 at approximately 1304Hrs, I was notified by (B)(7)(C), line one inspector, that she had just observed a live fly land on 3 turkeys in front of her. The live fly landed on one turkey's tail. The fly flew to another turkey and landed on the turkey's tail. The fly flew to another turkey and landed on its leg. Ms.(B)(7)(C) stopped the line and had her trimmer removed the three affected turkeys from the line for reconditioning. Ms.(B)(7)(C) was able to terminate the fly when it landed on the turkey's leg. The Evisceration line was full of whole body turkey's at this time. This observed incident of a live fly landing on food products during food products operation is in violation to 9 CFR 416.2(a); 416.4(d) and the establishment's monitoring of their operational sanitation 9 CFR 416.13(c). The establishment does have in place a outside pest management service. The three affected turkey's were reconditioned by (b)(4) water spraying (b)(4) ppm and reinspection off line. The turkey's were returned to production flow. This noncompliance JDD3123104616N/1 is being linked to noncompliance (#116) JDD4809095216N/1 dated 9/16/2013. (B)(6) and (B)(6) were notified of the noncompliance.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1117104 116N-1	10/16/2013	01C01	Operational SSOP Record Review	C	On 10/16/2013 at approximately 1100 hours while performing Operational Sanitation Records Review Task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 416.13 (b) and 9CFR 416.13 (c). The SSOP Daily Implementation and Monitoring Log dated on 10/15/2013 AM shift for WP Rewrap Room, under Operational SSOP monitoring had only two checks, one at 0212 hours and the other at 0606 hours. Operational Sanitation procedures states in part under monitoring frequency of action (minimum four times per shift) by QA inspector or designee. Observations are recorded on the SSOP daily implementation and monitoring log for operations. I informed (B)(6) of the noncompliance.
6036	P6164A	OIJ1516101 916N-1	10/16/2013	04A06	Poultry Finished Product Standards	C	On October 16, 2013 I, CS (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is 100 points. My test at 1330 resulted in 34 points. Plant records showed a failure within the last 5 tests and a CuSum above the start number of 11. Specifically the test at 0936 resulted in a CuSum of 11. The plant implemented the required procedures for FPS failure. I verbally notified (B)(6) that I would be issuing a NR. Plant records show no failures occurred at Post chill and the plant achieved two passing tests at Prechill at 1408. No further failures occurred for the remainder of the shift. The Prechill nonconformances I observed were: 6 partial oil glands (6 pts), 5 partial lungs (5 pts), 4 whole lungs (8 pts), 1 cloaca (5 pts), 1 partial crop (2 pts), 3 small feathers (3 pts), 3 large feathers (3 pts), and 1 long hocks (2 pts). On this same day NR # OIJ2213103616N (#78) was issued for processing noncompliance. This noncompliance is linked to NR # OIJ2213103616N (#78) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the October 10, 2013 meeting.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ2213103 616N-1	10/16/2013	04A06	Poultry Finished Product Standards	C	On October 16, 2013 I, CSI (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is (b)(4) points. My test at 0850 resulted in 45 points. At 0923 a retest was performed by (B)(6) using a tighten criteria of 25 points which failed with (b)(4) points. I verbally notified (B)(6) of the noncompliance and that I would be issuing a NR. The plant implemented the required procedures for FPs failure. Plant records show 2 passing tests were achieved at 0943 and no failures occurred at Postchill. The Prechill nonconformances I observed at 0706 were: 3 ingesta < 1/16" (3 pts), 5 partial oil glands (5 pts), 5 partial lungs (5 pts), 5 whole lungs (10 pts), 2 bursa (4 pts), 2 partial crop (4 pts), 1 trachea < 1" (1 pt), 6 small feathers (6 pts), 5 large feathers (5 pts), and 1 long hocks (2 pts). On October 9, 2013, NR # OIJ3522102109N (#74) was issued for processing noncompliance. No response is available at this time. This noncompliance is linked to NR # OIJ3522102109N (#74) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the October 10, 2013 meeting.
1325 7	P33900	NHH220610 5017N-1	10/16/2013	01D01	SPS Verification	C	On the calendar date of October 16, 2013 at approximately 2358 hours while performing the Operational SSOP Review and Observation task, the following facility noncompliances were observed: I, CSI (B)(7)(C), accompanied by (B)(6), observed an excessive amount of water on the underside of several stainless drip pans, piping, and overhead structures above bird shackles in rooms 1, 2, and 3 in the further processing areas. Please be advised that product adulteration was observed and the findings were documented on a separate noncompliance record; please reference NR # NHH3605100717N/1. In addition, 6 live spiders and several spider webs were observed in various areas of the ceiling in the small bird box room. No packaging material or boxes were affected. Mr. (B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on July 16, 2013; please reference NR # NHH1203071216N-1. The establishment's response to NR # NHH1203071216N-1 of, - "The spider webs were taken down and spiders were killed." - failed to prevent recurrence.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH360510 0717N-1	10/16/2013	01C02	Operational SSOP Review and Observation	C	<p>On the calendar date of October 16, 2013 at approximately 2358 hours while performing the Operational SSOP Review and Observation task, the following noncompliances were observed in further processing: Part 2 of the SSOP's states tha (B)(4) (B)(4) I, CS(B)(7)(C), accompanied by (B)(6) (B)(6), observed water dripping from the box chute (in the Rotisserie area) into a combo of WOGs. Water was also observed dripping from the underside of a stainless drip pan into a combo of ice (that was being collected to apply to product) in room 1. Mr.(B)(6) immediately retained the WOGs and Ice, and the combos were removed from the processing area. Please be advised that corrective actions were performed in my presence. In addition, Part 2 of the SSOP's states that (B)(4) (B)(4). At approximately 0104 hours (10/17/13) while observing operations in rooms 2 and 3, I observed&nbsp;blood specs and residue, fat particles, a black greasy substance, rust, and various debris on the inside and outside of several brown baskets used to hold bagged product. At the time of the findings, several baskets contained bagged product and visible stains were observed on the outside of the bags. The baskets were rejected with U.S. REJECTED tag #'s B40172390 and B40172389. Mr.(B)(6) was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting.A similar noncompliance record was documented on October 15, 2013; please reference NR # NHH5005105216N-1. The establishment's response to NR # NHH5005105216N-1 is pending.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN280510 1815N-1	10/15/2013	03J02	Slaughter HACCP	C	I noted the following non compliance during a verification check of the establishment's off-line reprocessing process. At 0101 hours I randomly selected ten carcasses from the off line after the final wash cabinet. Two of the ten carcasses had visible ingesta material, one at the inside of the tail area, the other carcass at the crop area. I stopped the reprocessing line and showed these findings to (B)(6). The Line was restarted at which time production personnel instituted corrective actions of adding two additional employees to the reprocessing line, one to conduct knife trimming and one to wash the carcasses. I performed a recheck at 0111 hours. During the ten random carcass verification I noted one carcass with visible ingesta material on the inside of the tail area. I stopped the line showed this finding to (B)(6). Mr. (B)(6) initiated the written corrective actions procedures for an off line contamination failure. These procedures included diverting carcasses off the line and then performing rechecks on the affected carcasses. (B)(6) performed the rechecks and then marked the chiller with a red net to identify the affected lot and initiated post chill checks on the affected lot. (B)(6) and (B)(6) were informed of the issuance of this non compliance report of the failure to meet the regulation cited above.
1325 7	P33900	NHH500510 5216N-1	10/15/2013	01C02	Operational SSOP Review and Observation	C	On the calendar date of October 15, 2013 at approximately 2340 hours while observing operations in room 2 of the further processing area, the following noncompliance was observed: Part 2 of the Sanitation SOP's states that (B)(4) I, CS(B)(7)(C), observed condensation dripping from the upper portion (toward the ceiling) of the stainless steel ice chute directly into a combo of ice. Employees in the area confirmed that the ice was going to be used in the packing of product, and the ice was immediately discarded. In addition, another part of the ceiling in close proximity to the ice chute exhibited a steady drip of water (which fell onto the floor), and corrective actions were immediately implemented. (B)(6) was shown the noncompliance as well and informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on July 25, 2013; please reference NR # NHH4717074025N-1. The establishment's response to NR # NHH4717074025N-1 failed to prevent recurrence.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN160010 2214N-1	10/14/2013	01D01	SPS Verification	C	On 10/13/13 while performing pre-operational sanitation in the HPP department I observed noncompliance with SPS regulatory requirements 416.2(b)(1) & 416.4(b). At approximately 21:50 hours I observed two white hard plastic cuttings boards placed on a metal rack on the floor at the beginning of the HPP package boxing area; these two cutting boards are used to catch packages after they exit the HPP machines and the packaged product has received its lethality step; both cutting boards, (Non food contact surfaces) had cuts and crevices on the boards' surfaces; upon closer observation it was determined that the boards may create an insanitary condition due to black unidentifiable foreign material in cuts/crevices; that may harbor bacteria which could in turn affect the cleaning and sanitizing of the cutting boards. (B)(6) and (B)(6) were shown and notified of the establishment's noncompliance with 9 CFR sections: 416.2(b)(1) & 416.4(b). This document serves as written notification of an SPS noncompliance; and also as a notification that failure to meet regulatory requirements can lead to enforcement actions as described in 9 CFR 500.4.
5308	M6137	BXL4516101 214N-1	10/14/2013	04A06	Poultry Finished Product Standards	C	On 10/11/2013 at approximately 1510 hours, a review of the Records for Post Chill Finished Product Standards, while writing down the check that I performed, I observed the following checks performed by Quality Control were: the first check performed was at 0855 hours (chiller 1) and 0858 hours (chiller 2). The second check was performed at 1004 hours (chiller 1) and 1005 hours (chiller 2). The third check was at 1306 hours (chiller 1) and 1308 hours (chiller 2), the last check was at 1505 hours (chiller 1) and 1501 hours (chiller 2). The birds finished coming out from the chiller that day at approximately 1850 hours. The gap between the second check and the third check was approximately three hours. The gap from the last check to the end of the shift was approximately three hours and fifty minutes. I also found while reviewing the records, that on 10/09/2013 the checks were performed as follows: (chiller 1) 0902 hours and 1127 hours and (chiller 2) 0858 hours and 1125 hours. The birds finished coming out from the chiller that day at approximately 1500 hours. The gap from the last check to the end of the shift was approximately three hours and thirty minutes. This is a noncompliance with the following regulatory requirements of regulation 9CFR 381.76 (e)(1)(i). I informed (B)(6) of the noncompliance.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN441110 2114N-1	10/14/2013	01D01	SPS Verification	C	<p>&nbsp; On 10/14/13 at approximately 825 hours I observed the following while performing the SPS task in the packaging room . Observing the reprocessing station I noticed the nut and surrounding area on the handle were oxidized the&nbsp;fittings&nbsp;used to connected the brass shut off valve showed signs of oxidization (rust) also .Taking a regulatory control action I immediately applied US REJECTED/RETAINED tag # B43 303643 and contacted (B)(6) who was near . (B)(6) placed the establishments QC hold tag on the reprocessing station and contacted (B)(6) . (B)(6) notified maintenance immediately . The maintenance worker disassembled the plumbing on the&nbsp;back portion of the reprocessing station a new shut off valve was installed teflon tape was used on the smaller&nbsp;fittings&nbsp;. &nbsp;The unit was&nbsp;reassembled&nbsp;and rinsed with (b)(4) water .&nbsp;Sanitary conditions were restored at approximately 1030 hours and the area was released&nbsp;. (B)(6) was informed of the non-compliance. &nbsp;My findings indicate non-compliance with the following regulations 9CFR 416.1 Which states that each official establishment must be operated and maintained in a manner sufficient to prevent the creations of insanitary conditions and to ensure that product is not adulterated and 9CFR 416.4(d) which States that product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments .</p>
5309	P6137A	NJN090610 3813N-1	10/13/2013	03C02	Raw Intact HACCP	C	<p>At approximately 0322 hours; I asked (B)(6) , to check the temperature of twelve brown tubs of product, in the fillet cooler room. His thermometer (# 464) registered (B)(4) . I took regulatory control action and applied a U.S. Retention tag NO43303527 to the pallet containing the twelve brown tubs filled with tender breast and salvaged thigh. Mr (B)(6) , was notified of the noncompliance. The U.S. Retention tag was removed at 0335 hours and the product was released to production due to the plant’s validation study on time and temperatures. The plant failed to maintain the product temperature constantly at (B)(4) ; that the product being staged on the cooler exceeded (B)(4) represent a noncompliance with 9 CFR 381.66 (c) (3). The establishment is required to comply with the chilling temperature requirements in 9 CFR 381.66(C) (3). &nbsp; The establishment HACCP plan II, Raw Not Ground for the 2nd Processing Department, process step Refrigerated Storage: (b)(4) (b)(4) . &nbsp; (B)(4) . &nbsp;</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN500610 4813N-1	10/13/2013	04B04	General Labeling	C	At approximately 0322 hour, while monitoring the temperature on fillet cooler, I observed a staged product of salvaged thigh mixed with tender breast in twelve brown tubs. The pallet had empty yellow label stamped Wednesday, and on the back a different date, 10/12/13, and the name (b)(6) was hand written in. The label did not identify the kind of poultry nor did it even have a code. Mr. (B)(6), and (B)(6), were notified of the noncompliance.
5568	M20923	XUM090010 1513N-1	10/13/2013	01D01	SPS Verification	C	On 10/12/2013 at approximately 2100 hours, while performing a routine Sanitation Performance Standards (SPS) inspection on the Raw Side Department on Line #2, the following noncompliance was noted: water and batter mixture flooding the drain which runs east to west adjacent to Line #2 creating insanitary conditions. At the time of my observation Line #2 was sorting breast meat. I took regulatory control by stopping the line and informing (B)(6) of the insanitary conditions and the forthcoming noncompliance. 3 combo bins of chicken breasts were removed from the area until the drain was cleared and sanitary conditions were restored and the line was released. During this task I also observed the floor drain next to Line #1 was flooded as well, no product was being processed in this area. The requirements of 9 CFR 416.1, 416.2(e)(4), 416.2(b)(2), and the establishments SSOP plan were not met. 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary condition and to ensure that product is not adulterated". 9 CFR 416.2(e)(4) states: "Plumbing system must be installed and maintained to provide adequate floor drainage in all areas where floors are subject to flooding type cleaning or where normal operations release or discharge water of other liquid waste to the floor". 9 CFR 416.2(b)(2) states: "Walls floors, and ceilings within establishments must be built of durable materials impervious to moisture and be cleaned and sanitized as necessary to prevent adulteration of product or the creation of insanitary conditions". The establishments SSOP plan, Part 2 Operation Sanitation, Section 1 Raw Area, Subsection D Equipment and Facilities, Step #3 states: (B)(4).

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH120110 0414N-1	10/13/2013	01C01	Operational SSOP Record Review	C	On the night of production which began on 10/13/2013, Inspection reviewed the SSOP Records generated for the night of production beginning on 10/10/2013 (Prod. Date 10/11/2013) and found them out of compliance. On that shift, Management had documented cardboard boxes in the SB (South Cooler) containing product with overspray on them and the Preventive Measure on the establishment's deficiency form stated that "Employee would be retrained not to overspray on 10/11/2013." No documentation was available for review by Inspection that this retraining was done, thus not meeting requirement's of 9CFR 416.16(a). (B)(6) was notified that a Noncompliance Record would be issued. Refer to NR #NHH2904083119N/1 (#125) dated 08/19/2013 for a similar Noncompliance.
1325 7	P33900	NHH510410 5014N-1	10/13/2013	03J02	Slaughter HACCP	C	On the night of production that began on October 13, 2103 while observing the start of operations in the evisceration department I noticed a new spray bar at the exit end of the PNT. Mr. (B)(6), informed me that the spray bar had been installed over the weekend to deliver acidified (B)(4) to the product. He also informed me that the acidified (B)(4) was in use at multiple other locations in the evisceration department. I proceeded to the HACCP office and asked Ms (B)(6), if the slaughter HACCP plan had been amended to show the use of acidified (B)(4) in the evisceration department. Ms (B)(6) informed me the HACCP plan had not been amended and that the acidified (B)(4) was not supposed to be in use until later in the week. Plant management elected to discontinue use of the acidified (B)(4) until the HACCP plan could be modified. The affected product, two combos of wogs, was retained with US tag B38075686. Ms. (B)(6) modified the HACCP plan and provided the necessary supporting documentation and proposed the affected product be rinsed with potable water. Inspection reviewed the HACCP plan changes and supporting documentation and concluded the establishment was in compliance and that the proposed corrective actions were reasonable. The regulatory control action was released after the product had been rinsed. Ms. (B)(6), was informed the noncompliance would be documented on a noncompliance record. The requirements of 9 CFR 417.5(a)(1) were not met.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1405100 812N-1	10/12/2013	01C02	Operational SSOP Review and Observation	C	<p>On 10/12/2013 at approximately 0035 hours while monitoring Operational Sanitation procedures at the rehang area of Plant #1 for product going into Packaging, I observed the following. There was product collecting on a rehang belt for birds going to the bag fryer line (b)(4) in Packaging. The carcasses at this point have already received their final microbial intervention. The carcasses at the end of the belt had varying amounts of a dark brown UFM(Unidentified Foreign Material) collecting on the carcass where the skin was in contact with the flexible belt. I contacted an employee who called (B)(6). Product was redirected to the cutup line. The line was stopped. A partial tank of carcasses were collected that were on the belt. The belt was sprayed with a sanitizer and rinsed with (b)(4) water. A review of the Establishments' SSOP Section 11-Operational Sanitation under Corrective Action: states (B)(4)</p> <p>There is no cleaning process described in the Operational Sanitation SSOP to be used to restore sanitary conditions. The dirtiest carcasses were condemned by production. I observed the reconditioning of the affected carcasses which were rinsed with (b)(4) water per establishment policy. A recheck was acceptable and the product was released at approximately 0130 hours. My findings indicated a noncompliance with 9 CFR 416.1, 9 CFR 416.4(d) and 9 CFR 416.14.</p>
5308	M6137	BXL5211100 612N-1	10/12/2013	01C01	Operational SSOP Record Review	C	<p>On 10/10/2013 while performing an Operational Sanitation Records Review Task, I made this observation on the SSOP Daily Implementation and Monitoring Log for Packaging on 10/08/2013. There was no check documented on the Glove/Utensil Check at Start-up (if applicable). I asked (B)(6) on 10/11/2013 about the missing check and she informed me that it was the night shifts SSOP Log and she would send (B)(6) an e-mail asking him about it. On 10/12/2013 I spoke with (b)(6) and he informed me that the Glove/Utensil Check at Start-up had been done and written down. However, the check was done by one Quality Control person and when a different Quality Control person did an SSOP monitoring check in packaging, she used a different SSOP Log. (B)(6) and the Quality Control employees were unable to find the SSOP Log that contained the Glove/Utensil Check at Start-up on 10/08/2013. My findings indicate a noncompliance with the following regulatory requirements of regulations 9CFR 416.13(b) and 9CFR 416.13(c).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN421810 3112N-1	10/12/2013	01D01	SPS Verification	C	At approximately 0940 hours, in the packaging area, I noticed that the cooler door was covered with ice on its side and bottom. I immediately contacted Mr. (B)(6) [REDACTED], and showed him the ice that was built-up on the door. Mr. (B)(6) checked the door and informed me that he will order some parts to fix the door. Also I informed him that the cooler door open into Fillet Department does not close properly. Later on, while performing an operational sanitation task in the packaging area, I noticed that the cooler door beside the spice room was open. So, I waited almost three minutes for some one to close it but, nobody came to close it. I went inside the cooler and noticed that the plastic curtain had heavy condensation to the point that it was dripping water. I showed Mr. (B)(6) [REDACTED], the condensation and informed Mr. (B)(6) [REDACTED], of the forthcoming noncompliance. Mr. (B)(6) then assigned an employee to wipe the condensation and to keep the door close. 9 CFR 416.2(d) states: "Ventilation adequate to control odors, vapors, and condensation to the extent necessary to prevent adulteration of product and the creation of insanitary conditions must be provided." 9 CFR 416.2(b)(1) states:"their structures, rooms, and compartments must be of sound construction, be kept in good repair." 9 CFR 416.1 states: "Each official establishment must be operated and maintained in a manner sufficient to prevent the creation of insanitary conditions and to ensure that product is not adulterated."
5308	M6137	BXL1918104 811N-1	10/11/2013	03J02	Slaughter HACCP	C	On 10/11/2013 while performing a Pre-Chill Finished Products Standards Task in Plant #2 on Line (B)(4) [REDACTED], I observed a noncompliance with the following regulatory requirements of regulations 9CFR 381.65(e) and 9CFR 417.2(c)(4). At approximately 1533 hours, I randomly removed a 10 bird sample from Line (B)(4) [REDACTED]. I found one out of the ten birds with visible fecal contamination below the right hock. The fecal material was approximately 7/16" in diameter in size, olive green in color and pasty in texture. I informed (B)(6) [REDACTED] and the protocol for fecal failure was implemented. At approximately 1557 hours, Quality Control performed a recheck and passed. This is a violation of the critical limits of CCP-2B, (b)(4) [REDACTED] of the Plant's HACCP Plan for Slaughter.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2207100 611N-1	10/11/2013	01C02	Operational SSOP Review and Observation	C	<p>At approximately 2000 hours while monitoring Operational Sanitation in the Plant #1 Cooler, I observed the following: A partial pallet of giblets with a white Dolly Tag marked Night Shift had a puddle of very dark brown blood on top of the lid. I opened the lid to see the condition of the giblets inside and found 3 uncut gibzards full of ingesta and several feet of intestines full of fecal material mixed in with the livers near the top of the product. The partial pallet of 5 tubs was placed under USDA Retained. At approximately 0030 hours I contacted (B)(6) and showed him the uncut gibzards and intestine in the livers. The 5 tubs on the pallet were from a previous days production and were condemned by Production. At approximately 0335 hours I observed the giblets that had come out of the giblet chiller just before lunch. The brown product tubs collecting the edible giblets were filled with a froth making it difficult to examine the contents. Moving the froth aside there were uncut gibzards full of ingesta and several feet of intestine full of fecal material in the livers. There was also a neck that was collected in the product container with the hearts that was coated with a thick layer of brown UFM (Unidentified Foreign Material). The giblets had already received their final microbial intervention. Giblets are placed back into the whole fryer carcasses as part of an unwrapped giblet pack. I contacted (B)(6) and showed him the product. All three tubs of product was condemned and placed into a gray inedible barrel. In the future (B)(6) will turn off the giblet collection conveyor belt during wash downs to prevent unsorted product from entering the giblet chiller. The UFM coated neck was provided to the establishment to aid in determining the content and source of the UFM. Ingesta and fecal material from the uncut gibzards and intestines will leach into the edible product during storage and handling contaminating the giblets. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.4(d).</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2907100 711N-1	10/11/2013	01802	Pre-Op SSOP Review and Observation	C	<p>At approximately 1945 hours while monitoring Pre-Operational Sanitation processes in the Rotisserie Room, I observed the following. Sanitation personnel were starting to clean the room after PM shift production was completed. At approximately 2035 hours I returned and the (b)(4) Injection machine was being cleaned using the establishments' clean in place procedure. The machine is operated recirculating a cleaning solution. I returned at approximately 2100 hours the machine was stopped. At approximately 2145 hours the injection machine internal and external surfaces were being cleaned. At approximately 2230 hours the top of the Injection Machine was open and a sanitation employee was removing the needles that had been cleaned with the machine during the clean in place procedure. The top of the machine was rinsed and a second set of needles that are soaked in a solution of vinegar and water over night were inserted into the machine. I checked the injector needles that were removed after being cleaned with the clean in place procedure and observed that most of the needles were covered with a froth of product from the previous days production. The needles were rinsed with potable water and the water/vinegar solution was added. At approximately 2300 hours (B)(6) was starting her SSOP Pre-Operational Sanitation check in Rotisserie. I asked her how she inspected the injector needles listed on the form. She said that only the external surfaces of the injector needles installed in the machine were checked. At approximately 2345 hours I selected the Injection Machine for my Pre-Operational Sanitation Verification procedure in the Rotisserie Room. I spoke with (B)(6) about the frothy residue on the needles that were cleaned with the machine then asked for the Operators Manual with the manufactures recommended cleaning procedures. The manual was located in the Packaging Department Repair Office. The manual dedicated a chapter to the cleaning of the machine covering each piece i.e. piping, belts, screens etc. A note in the manual stated that the recommended cleaning procedure was to be used to address production for a shift. I told (B)(6) to fill the machine and run it so I could see if it was clean. Upon running the machine numerous pieces of fat, tissue, and coagulated blood from very small to approximately 1/2" in size came out of the drain line from the upper collection tank under the injection needles. The fluids drains into a lower tank that filters the fluid and returns it to the injection needles. The unit was drained, recleaned and released at approximately 0020 hours after a steady stream of water flowed from the injection needles and the water flowing into the collection tank was clear.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
6036	P6164A	OIJ2118103 815N-1	10/11/2013	03J02	Slaughter HACCP	C	<p>At 2042 I, Dr. (B)(7)(C), began performing a routine Pre-Chill Finished Product Standards PHIS task. At 2053 I identified fecal material on the eighth bird located on the internal surface of the right ventral body cavity just medial to the ventral fat pad and approximately 1.5 inches (4cm) inside the bird. It was light brown, semi-solid, creamy consistency with no plant material contained therein and was approximately ¼ inch (6mm) diameter. There were no establishment employees between the final wash cabinet and the carcass chiller therefore it is reasonable to believe the carcass would have entered the chill system (B)(6) was immediately notified and observed the noncompliance at 2054. Dr. (B)(7)(C), confirmed it was fecal matter at 2057. At 2058 the establishment implemented its written fecal failure procedure including a five minute live hang skip beginning at 2058. The cause of the zero tolerance fecal failure was identified by (B)(6) and (B)(6) at 2140 during scheduled establishment break. It was determined that on the (b)(4) In/Out bird wash two nozzles were not working properly and on the (b)(4) In/Out bird wash two leaf fat lifters had two nozzles that were missing extenders to increase the opening of the birds. Preventative measures implemented included maintenance on the offending machines (all lifters on the (b)(4) were changed by maintenance at break) and increased monitoring of the (b)(4) and (b)(4) three times per shift during company breaks and lunch. To verify the process was back under control after prevenative measures were taken, the establishment completed a succesful zero tolerance at 2120. This was followed by tests done every thirty minutes for the next two hours totalling four tests without any documented visible fecal contamination. To verify all possibly affected carcasses entering the chiller system were not contaminated by visible fecal material the establishment began a series of zero tolerance tests of carcasses exiting the chiller. The tests began at 2130, consisting of 32 birds for each rake (approximately five minutes) of the chiller system, ending at 2245 with last of the affected group exiting the chiller. There was no documented visible fecal contamination Post Chill. All affected carcasses were sprayed with (b)(4). This NR is linked to NR# OIJ3522085229N issued on swing shift 8/29/13. Including this NR there are three linked NRs issued in the last ninety days. Zero tolerance NRs were most recently discussed and documented during an Establishment meeting on 9/5/13.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2422102 710N-1	10/10/2013	01C02	Operational SSOP Review and Observation	C	<p>On 10/10/2013 at approximately 1005Hrs, I observed UFM (unidentified foreign material) on the Chiller B exit food contact belt. The UFM was very black in color; thick/smear grease type when touched/rubbed. The thick UFM was smeared approximately 8" x 3" in size on the belt. The food contact chiller belt was full of whole body heavy tom turkeys at this time. I saw &nbsp;(B)(6), Boning Room personnel, who was near the Boning Room Wings area. I waved to him for help and notified him of the UFM&nbsp;on the belt. Mr. (B)(6) called (B)(6). He removed the whole body turkey's from the affected belt. U.S. Retain Tag NO:B39554699 was applied to the affected chiller exit belt. Mr. (B)(6) was showed the UFM on the&nbsp;conveyor belt. He restored sanitary conditions by stopping the conveyor and removing all of the UFM from the belt with a sanitized cotton glove. The belt was&nbsp;sanitized and reinspected.&nbsp;The conveyor was released for operations at approximately 1010Hrs. U.S. Retain Tag&nbsp;No's: B39554697 & 98 was applied to the one and 1/4 tanks of whole body turkeys which were on the affected conveyor belt. At approximately 1110Hrs the&nbsp;(2300 pounds) of heavy tom turkeys were released back to production flow after verifying the plant's implemented reconditioning by (b)(4) water spraying/trimming and reinspection.&nbsp;One Turkey was found with UFM. This observed incident of UFM on a food contact surface during food products processing operations is in violation to 9 CFR 416.4(a); 416.4(d) and monitoring of the plant's operational sanitation 416.13(c). This noncompliance JDD2422102710N/1 is being linked to noncompliance (#119) JDD1922091518N/1 dated 9/17/2013 and &nbsp;(86) JDD1419071502N/1 dated 7/2/2013 for the same cause respectively.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD2422102 710N-2	10/10/2013	01C02	Operational SSOP Review and Observation	C	On 10/10/2013 at approximately 1340Hrs, I observed injestas spilling out of a whole body heavy hen turkey's crop. The turkey was on the chiller B exit conveyor with other whole body turkeys. I pulled the turkey from the food contact conveyor onto the food contact chiller B inspection table. The injestas were still spilling out of the broken open crop. As the contamination was extensive, U.S. Retain Tag NO:B39554114 was applied to the turkey and table. The Evisceration Line was at lunch break, I went to the Supervisor's office and notified Ms. (B)(6). Ms. (B)(6) immediately had the affected turkey carcass which did not have its crop properly removed taken to the Evisceration reprocessing room. She had the injestas contamination on the food contact surfaces removed by (b)(4) water spraying (b)(4) ppm. She had the crop properly removed by trimming and washing with (b)(4) ppm spraying. The turkey was reinspected by Q.C. The turkey was released back to production flow after verifying the plant's implemented appropriate corrective actions. This observed incident of turkey food product and food contact surfaces adulteration is in violation to 9 CFR 416.4(a); 416.4(d) and monitoring of the plant's operational sanitation 9 CFR 416.13(c). Ms. (B)(6) and Ms. (B)(6) were notified of the noncompliance.
5308	M6137	BXL2414103 510N-1	10/10/2013	04A06	Poultry Finished Product Standards	C	On 10/10/2013 while monitoring the Establishments' Reprocessing Procedures on Line (B)(6) in Plant #2, I observed the following noncompliance. At approximately 1032 hours, with a line speed of (B)(4) and two House Inspectors, I randomly removed a 10 bird sample and found one split tail bird with airsacculitis exudates and one split tail bird with partial lung remaining in the bird. I took regulatory control action by stopping the line and I informed (B)(6). The line was started back up with a line speed of (B)(4) and three House Inspectors and product was retained in a tank. I performed a recheck at approximately 1043 and failed with one split tail bird containing airsacculitis exudates. I informed (B)(6) and the line remained running with all split tail and missing tail birds being retained. I performed a recheck at approximately 1054 hours and passed, bringing the process back into control. I tagged the tank of retained birds with U.S. Retained/Rejected Tag #B31408095 pending rework of the product and I informed (B)(6) of the noncompliance. I performed a recheck of the held product at approximately 1345 hours and it passed. I removed my tag and released the product back to production at that time. My findings indicate a noncompliance with regulatory requirements 9CFR 381.76(b) and 9CFR 381.84.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN491110 1810N-1	10/10/2013	01D01	SPS Verification	C	On Tuesday October 8th at approximately 12 O'clock, I observed that the drain of the offal area was clogged, and the area around the drain, approximately 20 feet by 20 feet, was covered with bloody water. I immediately asked one of the plant maintenance to inform management about the drain in order to take care of the problem. The following day, at approximately 0910 hours, I went to check the area and found that the drain still clogged and covered with smelly stagnant water. At this time the plant supervisors were in a meeting so, I informed Ms. (B)(6) [REDACTED], of my observation and the forthcoming NR. Also, later in that day I informed MR. (B)(6) [REDACTED], of the noncompliance documentation. Mr. (B)(6) [REDACTED] informed me that he will take care of the Problem. At approximately 1600 hours, the area was found acceptable. 9 CFR 416.2(e)(1)(2)(3)(4) states: "Plumbing systems must be installed and maintained to: (1) Carry sufficient quantities of water to required locations throughout the establishment; (2) Properly convey sewage and liquid disposable waste from the establishment; (3) Prevent adulteration of product, water supplies, equipment, and utensils prevent the creation of insanitary conditions throughout the establishment; (4) Provide adequate floor drainage in all areas where floors are subject to flooding-type cleaning or where normal operations release or discharge water or other liquid waste on the floor."
5309	P6137A	NJN581610 1910N-1	10/10/2013	01C02	Operational SSOP Review and Observation	C	At approximately 1430 hours, while performing an operational sanitation inspection in the new room, I observed the following noncompliance: There was a pallet of returned boxed rotisseries placed in the new room for rework (cut up). The boxes were damaged not clean and wet. A plant employee started to process the first box, she moved her gloved hands on the surfaces of the box to open it, and then she took a pair of scissors to open the plastic bag containing the rotisseries, after that, she proceeded to take the carcasses out of the bag without washing or sanitizing her gloves, creating an insanitary condition and cross contaminating the product. I showed Ms. (B)(6) [REDACTED], my finding, also, Mr. (B)(6) [REDACTED] (day), was informed of the noncompliance and the forthcoming NR. 9 CFR 416.5(a) states: "All persons working in contact with product, food-contact surfaces, and product-packaging materials must adhere to hygienic practices while on duty to prevent adulteration of product and the creation of insanitary conditions." 9 CFR 416.4(d) states: "Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments."

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL5004105 509N-1	10/09/2013	01802	Pre-Op SSOP Review and Observation	C	<p>On 10/08/2013 at approximately 2210 hours while monitoring Pre-Operational Sanitation cleaning procedures in the Rewrap Room, I observed the following. A sanitation worker was using an air hose to blow down the conveyor belt, Stainless Steel table, product table and finally the floor until approximately 2230 hours. He swept up the big pieces of paper then blew the rest of the dust and dirt out into the packaged products storage area. He then sprayed some hand sanitizer on the tables and belt then wiped it off with brown paper towels. The employee left at approximately 2244 hours. I checked back several times and I observed no further cleaning in the Rewrap Room. A review of the establishments' Pre-Operational Sanitation 'Daily Procedures' states (B)(4)</p> <p>" under Wet Clean-Up (food contact surfaces) it states in part (B)(4)</p> <p>" At approximately 2355 hours when my Pre-Operational Sanitation Verification procedure started, I selected the Rewrap Room. There was black UFM (Unidentified Foreign Material) on the belt and belt stainless steel support bracket, on the stainless steel table, on the stainless product table, and on the majority of the floor. I discussed the cleaning procedures with (B)(6) who said they only use soap on Saturdays when the area is cleaned at the same time that the stair well that goes down into packaging is cleaned. There is no floor drain in the Rewrap Room to facilitate a normal cleaning process. The Establishments' SSOP Implementation and Monitoring Log for the Rewrap Room lists the (b)(4)</p> <p>. These areas are treated as product contact surfaces that should be addressed on a daily basis using the Establishments' Wet -Cleanup (food contact surfaces) Pre-Operational SSOP procedure. The General sanitation log was completed at approximately 2248 hours by (B)(6), and a QC according to the SSOP implementation and Monitoring Log for the shift found the area to be acceptable at 2337 hours. The Rewrap Room routinely unwraps and rewraps consumer packaged products that were dumped on the floor in the Weigh & Price cooler and are highly contaminated. The Establishment uses a Bio-Trace test for organic material on product contact surfaces to check the effectiveness of the cleaning process. According to (B)(6) Bio-Trace testing is not used on product contact surfaces in the Rewrap Room. My findings indicated a noncompliance</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							with 9 CFR 416.1, 9 CFR 416.4(a) & (b), 9 CFR 416.12(a), 9 CFR 416.13(c), 9 CFR 416.14, and 9 CFR 416.2(e)(4).
5310	M6137B	FFA3316103 409N-1	10/09/2013	01C01	Operational SSOP Record Review	C	On October 9, 2013 at approximately 0430 hours, while performing my operational record review for 10/08/2013. I observed that the operational records (Sanitary Practice Log) record for the night shift Raw side was not available for review. I informed (B)(6) of the noncompliance.This does not comply with establishment Monitoring and Record keeping: which states; The Qa Manager/ designee has the responsibility for the daily monitoring of the Sanitation-SOP and recording the findings and corrective action that have to be taken. Results are recorded on Establishment P-6137B Sanitary Practice Log Form B.This also does not comply with 416.16(a); which states in part "Each official establishment shall maintain daily records sufficient to document the implementation and monitoring of the Sanitation SOP's and any corrective action taken". " Daily records required, responsible individual, initialed and dated.This document serves as written notification that failure to comply with regulatory requirement(s) of 9CFR Part 416 could result in additional regulatory or administrative action.
6036	P6164A	OIJ3522102 109N-1	10/09/2013	04A06	Poultry Finished Product Standards	C	On October 9, 2013 at 1551 I, Dr. (B)(7)(C) preformed a pre-chill Finished Product Standard (FPS) test in order to verify finished product standards were being met for ready to cook poultry prior to entry into the chiller. The absolute limit allowed for processing nonconformance is 20 points, I observed 47 points. Nonconformances observed were as follows: 7 oil gland remnants (7pts), 1 whole oil gland (2pts), 2 partial lungs (2pts), 4 whole lungs (8pts), 1 Bursa of Fabricius (2pts), 1 partial crop (2pts), 3 tracheas >1" (6pts), feathers or pin feathers (9pts), feathers >1" (3pts), and 3 long shanks (6pts). (B)(6) was verbally notified of the USDA failure and preformed a retest at 1602. The tightened nonconformance standard for a retest is 20 pts, (B)(6) observed 34. The nonconformance observed by (B)(6) were as follows: Extraneous material >1" (2pts), 5 partial oil glands (5pts), 2 partial lungs (2pts), 3 whole lungs (6pts), 3 Bursa of Fabricius (6pts), 1 partial crop (2pts), 2 trachea >1" (4pts), feathers >1" (2pts) and 2 long shanks (4pts). Plant immediately implemented their FPS failure procedures. (B)(6) had a passing test at 1620 (25pts) and 1641 (22pts) bringing the plant back into compliance. Auto out at post chill was 1810. Post chill documentation showed no failing tests. I verbally informed (B)(6) of the failing prechill FPS tests and that a noncompliance report would be issued. This noncompliance report is linked to OIJ041610007N which was issued on 7 October 2013 for processing FPS noncompliance. It remains unanswered at this time. Linked FPS noncompliance was last discussed at the plant meeting on 3 October 2013.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH460410 3809N-1	10/09/2013	01D01	SPS Verification	C	<p>On the calendar date of October 9, 2013 (for the shift beginning on 10/8/13) at approximately 0118 hours while performing the Operational SSOP Review and Observation task, the following facility noncompliance was observed in the Breast Cone line processing area: Part 2 of the Sanitation SOP's states that (B)(4) [REDACTED], CSI (B)(7)(C), observed multiple beads of condensation on the ceilings above the tender and frame conveyors. At the time of the findings, tenders and frame were on the conveyors; however, no product adulteration was observed. Also, while in the area, I observed larger droplets of condensation on the ceiling near the light fixture (yellow cord attached). (B)(6) [REDACTED], was shown the noncompliance and he confirmed the findings. Mr. (B)(6) [REDACTED] was informed that a noncompliance record would be issued. This noncompliance record will be discussed during the next weekly meeting. A similar noncompliance record was documented on September 18, 2013; please reference NR # NHH0703094920N/1. The establishment's response to NR # NHH0703094920N/1 of - "The condensation was removed." - failed to prevent recurrence.</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD3621100 708N-1	10/08/2013	01D01	SPS Verification	C	On 10/8/2013 at approximately 1420Hrs, I observed the establishment's six restrooms. The Evisceration Live Hanging restroom had standing brownish water at the floor drain which appeared to be plugged. The toilet bottom was leaking onto the floor around the floor seam. 2.) In the women's Evisceration restroom seven toilets had water coming out through the pipes connected to the flush handles. The water was going onto the floor. 3.) The men's Evisceration restroom had 2 sinks dripping at the back wall pipes onto the floor. Two toilets had water coming out through the pipes connected to the flush handles which was going onto the floor. 4.) The women's Boning Room restroom had two toilets leaking through the pipes at the flush handles and one broken towel dispenser. 5.) The men's Boning Room restroom had a puddle of brownish/yellow fluids on the floor near a urinal and one towel dispenser was broken. (B)(6) was notified of the Evisceration restrooms and showed the leaking toilets and standing water at the floor drain. (B)(6) was notified and showed the Boning Room's men's restroom. Ms (B)(6) and Mr (B)(6) ensured inspection; the observed issues will be addressed. Ms. (B)(6) and Mr (B)(6) were notified of the noncompliance. This observed incident of restroom not in good repair is in violation to (facilities) 9 CFR 416.2(h)(1) which states in part; "Dressing rooms, toilet rooms, and urinals must be maintained in a sanitary condition and in good repair at all times to ensure cleanliness of all persons handling any product." The floors with standing water and fluids is in violation to 9 CFR 416.4(b) non-food contact surfaces, cleaned and sanitized.
5112	M18909	JDD5122103 208N-1	10/08/2013	01D01	SPS Verification	C	On 10/8/2013 at approximately 1050Hrs while performing sanitary operations (food contact utensils). I saw several (b)(4) staged at the blender in the Raw Fabrication Room. The establishment was refilling them with ground turkey blends. I looked inside one (b)(4) and saw an approximately 1" crack/split. The crack was open and sharp to the touch. U.S. Retain Tag NO:B39554113 was applied to the (b)(4) to prevent its use. (B)(6) was notified of the noncompliance and showed the crack/split. This observed incident of a food contact container not maintained in good repair was creating insanitary conditions and a potential food products adulteration which is in violation to the relevant regulations cited above. The (b)(4) remains on hold for repairs.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0423102 508N-1	10/08/2013	03C02	Raw Intact HACCP	C	<p>On 10/07/2013 at approximately 1945 hours while monitoring Packaging at the end of the PM shift, I observed the following. Packaged product was backed up&nbsp;outside the Crust Tunnel. There were numerous racks of packaged product in the bulk product storage side of the Crust Tunnel some with a packaging time on the Dolly Tags from 11 AM. I went to the exit end of the crust tunnel which was full of crusted product as the elevators were not functioning. The elevators take the crusted product to the Weigh&nbsp;& Price Cooler for shipping.&nbsp;I checked the&nbsp;Establishments computer to see if there was anyone monitoring the product exiting the crust tunnel or the product being stored&nbsp;in the bulk storage side of the crust tunnel. The&nbsp;last entries were made for Crust Tunnel Temperatures at approximately 1940 hours. There were no entries for product monitoring in the Bulk Storage Area. &nbsp;The crust tunnel is normally approximately (B)(4) and the bulk product storage side is normally approximately (B)(4).&nbsp;At approximately 2130 hours .using a&nbsp;company calibrated thermometer,&nbsp;&nbsp;the&nbsp;temperature of&nbsp;one item labeled 'Fresh'in the bulk storage side of the crust tunnel&nbsp;was found to be satisfactory. The temperature of&nbsp;a packaged&nbsp;product exiting the Crust Tunnel was warmer than usual at approximately (B)(4). A rack of bulk product exiting the Crust Tunnel was at approximately (B)(4). With the elevators broken the crust tunnel&nbsp;had been turned off. I contacted (B)(6) in the QC Office&nbsp;and informed her that the last check in the&nbsp;Crust tunnel&nbsp;was at 1940 hours. I returned later to let her know that the last product exiting the&nbsp;Crust Tunnel was loaded&nbsp;onto the elevators at approximately 2207 hours and that no temperatures had been taken for over two and one half hours. There were&nbsp;no Supervisors or QC personnel&nbsp;monitoring the process. I contacted (B)(6) on 10/08/2013 and was told there&nbsp;are no procedures written&nbsp;for&nbsp;when the&nbsp;Crust Tunnel or associated elevator fail.&nbsp;A review of the establishments' HACCP plan - Raw not ground - Packaging under Step #9, states in part: Crust Tunnel (B) Pathogens, i.e. Salmonella. Is the Hazard Significant? NO.&nbsp;'Justification for Decision' Refrigerated temperatures will prevent the growth of pathogens, such as salmonella. Temperatures are monitored as part of the plant program. Supplement #35, CP-14 (b)(4), states in part that:</p> <p>(B)(4)</p> <p>" No temperatures were taken from approximately 1940 hours to approximately 2207 hours as required by CP-14</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
							which is used to support the Hazard Analysis. My findings indicated a noncompliance with 9 CFR 417.5(a)(2).
5309	P6137A	NJN002110 4108N-1	10/08/2013	04A06	Poultry Finished Product Standards	C	<p>At approximately 0920 hours, while performing finished product standards check on the reprocessing line I noticed the following: &nbsp;the plant employee assigned to check the bird starts to pull the bird out of the line and retain them either by hanging them behind him or retain them in a metal container, in spite of that I found three birds with cellulitis trim defect and that require a re-check. I immediately informed Mr. (B)(6) (B)(6), of my findings and asked him to inform the QC (B)(6) (B)(6) to perform the re-check. The recheck pass at approximately 0930 hours, with one trim defect. At approximately 0945 hours, I noticed that the reprocessing line was full so I elected to perform another check to make sure that the reprocessing line is in compliance and the product is wholesome. In the 10 birds ample I found three birds with contamination in various areas of the carcasses, and three birds with trim defect. I immediately took control action and stopped the line, and informed Mr. (B)(6) (B)(6), of my findings and the forthcoming noncompliance. The plant failed to keep the reprocessing line in control and comply with the regulations cited. 9 CFR 381.91(b)(1) states: " Any carcass of poultry accidentally contaminated during slaughter with digestive tract contents shall not be condemned if promptly reprocessed under the supervision of an inspector and thereafter found not to be adulterated adulterated. Contaminated surfaces that are cut shall be removed only by trimming. Contaminated inner surfaces that are not cut may be cleaned by trimming alone, or at an approved reprocessing station away from the main processing line, by any method that will remove the contamination, such as vacuuming, washing, and trimming, singly or in combination. All visible specks of contamination must be removed, and if the inner surfaces are reprocessed other than solely by trimming, all surfaces of the carcass shall be treated with (b)(4) water containing (b)(4) ppm available (B)(4) " 9 CFR 381.86 states: "Any organ or other part of a carcass which is affected by an inflammatory process shall be condemned and, if there is evidence of general systemic disturbance, the whole carcass shall be condemned."</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD5106103 107N-1	10/07/2013	01D01	SPS Verification	C	<p>On 10/06/2013 I observed the Giblet Chiller Tank. Chilled water circulates around numerous stainless steel pipes that contain the Giblets on the interior of the pipes. The Exterior of these pipes in the chilling tank are black in color, greasy, grimy with UFM. Mr (B)(6), Mr (B)(6), Mr (B)(6), and Mr (B)(6) were shown or were verbally notified. This is a violation of the following 9 CFR's: §416.3 Equipment and utensils. (a) Equipment and utensils used for processing or otherwise handling edible product or ingredients must be of such material and construction to facilitate thorough cleaning and to ensure that their use will not cause the adulteration of product during processing, handling, or storage. Equipment and utensils must be maintained in sanitary condition so as not to adulterate product. (b) Equipment and utensils must not be constructed, located, or operated in a manner that prevents FSIS inspection program employees from inspecting the equipment or utensils to determine whether they are in sanitary condition. §416.4 Sanitary operations. (b) Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL0416102 007N-1	10/07/2013	01C02	Operational SSOP Review and Observation	C	<p>On 10/07/2013 at approximately 1225 hours while walking past the packaging&nbsp;re-hang area in Plant #2, I observed the following noncompliance. An&nbsp;employee was throwing whole breasts with wings attached&nbsp;into a brown tub that was designated for fillet pack out.The employee threw a breast&nbsp;but&nbsp;missed the tub and it&nbsp;landed on the floor. The employee picked up the breast&nbsp;and sprayed it with water from a red hose and then put it into the brown tub. The Establishments&nbsp;SSOP states in part that (B)(4)</p> <p>(B)(4)</p> <p>.&nbsp;i tagged the tub with U.S. Retained tag #B31 408090 and asked the lead person to call (B)(6)</p> <p>The lead person dumped the brown tub of&nbsp;breasts into a&nbsp;stainless steel mesh cart. The production employee responsible for reconditioning started washing the product&nbsp;and&nbsp;putting them into&nbsp;another stainless steel cart. I applied the retain tag to the cart and I started inspecting the product. (B)(6) came over and I informed him of the noncompliance. While inspecting the product I found two breasts&nbsp;with some&nbsp;black specks, UFM (Unidentified Foreign Material)&nbsp;on them. I showed them to (B)(6) and he told the employee responsible for reconditioning to condemn the product in the cart. I followed the employee to the edible dump room where I removed the tag and the product was condemned.My findings indicate a noncompliance with regulatory requirements of regulations 9CFR 416.4(d), 9CFR 416.13(c), and 9CFR 416.1.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1818103 907N-1	10/07/2013	01C02	Operational SSOP Review and Observation	C	While monitoring the Establishments' Operational Sanitation Procedures at the start of the shift at the Re-wrap Room, at approximately 0910 hours, I found the following there: at the area just outside of the Re-wrap Room, at the end of the line for re-wrap product, there was two gray baskets stack on top of each other. The baskets were covered with blue plastic and were full of product. The product was uncovered, dry and had some black specks UFM (Unidentified Foreign Material) on them. Also on the first basket was a pair of green rubber gloves and a ball of already used (b)(4) wrap plastic. The product was from the previous day production (Saturday 10/05/2013). I immediately tagged the gray baskets with U.S. Rejected/Retained Tag # B31 406280. Since no Supervisor was there, I informed (B)(6) of my findings. At approximately 1045 hours CS (B)(7)(C) removed the tag and observed when a company employee from the Re-wrap Room, took the product to the edible dump room and condemned it. This is a noncompliance with the following regulatory requirements of regulation 9CFR 416.1 and 9CFR 416.4 (d).
6036	P6164A	OIJ0416100 007N-1	10/07/2013	04A06	Poultry Finished Product Standards	C	On October 7, 2013 I, CSI (B)(7)(C) performed a scheduled Finished Product Standard test at the Prechill area. This test is applied to permit FSIS to estimate when the production process is in control for ready-to-cook poultry. The test consists of two parts, trim and processing nonconformances. The absolute limit allowed for processing nonconformances is (b)(4) points. My test at 0900 resulted in 45 points. Plant records showed a failure within the last (b)(4) tests and a CuSum above the start number of (b)(4). Specifically the test at 0648 resulted in 44 points and a CuSum of 19. The plant implemented the required procedures for FPS failure. I verbally notified (B)(6) that I would be issuing a NR. Plant records show no failures occurred at Post chill and the plant achieved two passing tests at Prechill at 0945. No further failures occurred for the remainder of the shift. The Prechill nonconformances I observed were: 1 ingesta < 1/16" (1 pt), 3 partial oil glands (3 pts), 2 partial lungs (2 pts), 5 whole lungs (10 pts), 1 bursa (2 pts), 3 small feathers (3 pts), 4 large feathers (4 pts), and 9 long hocks (18 pts). On September 25, 2013 NR # OIJ3321093125N (#72) was issued for processing noncompliance. This noncompliance is linked to NR # OIJ3321093125N (#72) for the same root cause. The Establishment Awareness Meeting notes show that FPS NRs were last discussed at the September 26, 2013 meeting.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1605100 305N-1	10/05/2013	03J02	Slaughter HACCP	C	On 10/05/2013 at approximately 0108 hours while conducting a Pre-Chill Finished Products check on line (b)(6), I observed the following. After taking a standard 10 bird random sample, I observed one carcass with visible fecal contamination. There was a small cut at the base of the tail at the junction with the saddle on the left side of the carcass. The fecal material was in that tissue tear. The fecal material was olive green in color, pasty in texture and measured approximately 1/8" by 1/4". This exceeded the Zero Tolerance for the process to be in control. I contacted (b)(6) and the protocol for fecal failure was implemented. A QC recheck passed at 0135 hours. My finding indicated a noncompliance with 9 CFR 381.65(e), 9 CFR 417.2(c)(4) and the CCP-2B (b)(4) of the Plant's HACCP Plan for Slaughter.
5112	M18909	JDD2712102 406N-1	10/04/2013	01C02	Operational SSOP Review and Observation	O	On 10/04/2013 at approximately 1320Hrs, Dr (b)(7)(C) and I observed the plant personnel touching the outside (non food contact) and inside of the (food contact) casings in the Raw Fabrication Cooler 9 Department. The plastic casing were being filled with 95559 ground turkey products. The casings were blowing open inside the machine as they were being filled. The meat was exposed through the openings approximately 8" to 4". The exposed meat open casings were dropping onto a food contact table. The open casings were landing on top of each other on the table. The meat coming out of the casings was touching the outside plastic casings. The personnel was touching the turkey products as she struggle to remove the meat from the open rolls. She scooped the meat out with her gloved hands and put the affected 95559 turkey into a food contact (b)(4) next to the table. She did not change her gloves or sanitize her hands. She did not sanitize the affected rolls or table. U.S. Retain Tag NO:B39554112 was applied to the affected product in the (b)(4). (b)(6) was notified of the noncompliance. Mr. (b)(6) immediately sanitized another table and separated the rolls. The affected exposed meat rolls were opened and put into the (b)(4). The not open plastic casing were sanitized and put on the clean table for rework because the did not meet the net weight.

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2105102 704N-1	10/04/2013	01D01	SPS Verification	C	<p>On 10/04/2013 at approximately 0100 hours while performing a scheduled SPS Verification procedure in Plant #2, I observed the following. There were loose stainless steel splinters at three locations on a guide bar located behind the mirror at the middle inspection station on line (B)(6). The guide bar is approximately 2' in length. Two splinters were attached to the top of the bar and one was attached to the bottom. The splinters were approximately 4mm and (2) 12mm in length. The Guide Bar is approximately 1/4" thick with the wear process caused by the metal to metal contact between the Guide Bar and the stainless steel carcass shackles. Approximately 1/2 of the guide bar has worn away. With the guide bar directly above the carcasses metal splinters flaking off are creating a Physical Hazard condition. Metal of any size on or in a carcass would be considered a contaminant by USDA. I contacted (B)(6) who called a mechanic. The guide bar had raised flattened edges that were the source of the splinters. Mechanics scraped off the raised edge removing pieces of varying size from 1mm to over 2" in length and up to approximately 2mm wide. A piece of emery cloth was used to remove any remaining loose pieces. The area was rinsed with potable water and released by approximately 0115 hours. The establishment has no metal detectors.</p> <p>I gave a sample to (B)(6). The metal to metal contact creating a Physical Hazard has been occurring for sometime. A review of the Establishments' Haccp Plan - Slaughter Plant 2 which was last revised on July 9, 2013 states under (B)(4)</p> <p>(B)(4)</p> <p>(B)(4) This issue has been discussed at several weekly meetings with the Plant Management. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL3818105 904N-1	10/04/2013	03J02	Slaughter HACCP	C	<p>At approximately 1500 hours while performing a HACCP Slaughter Record Review Task, I found a noncompliance with the following regulatory requirements of regulation 9CFR 417.2 (c)(4).1.-The HACCP Monitoring Log -CCP 1B- (b)(4))&nbsp;for Line (b)(4) dated on 09/27/2013 AM shift had the following Zero Tolerance checks times: One check at 0518 hours and the following&nbsp;check at 0637 hours. The gap between these two checks&nbsp;was 1 hour and 19 minutes.2.-The HACCP Monitoring Log -CCP1B- (b)(4) for Line (b)(4), dated on 10/02/2013 AM shift&nbsp;had the following&nbsp;Zero Tolerance&nbsp;checks times: One check at 0520 hours and the&nbsp;following check at 0636 hours.&nbsp;&nbsp;The gap between these two checks was 1 hour and 16 minutes. The&nbsp;HACCP Plan states in part under monitor procedures that &nbsp;(B)(4) ".* A unit may be a carcass or a part.&nbsp;&nbsp;"Approximately is defined as 15 (-)(+) minutes".&nbsp;I notified (B)(6) &nbsp;of the noncompliance.</p>
1325 7	P33900	NHH310410 0104N-1	10/04/2013	01C02	Operational SSOP Review and Observation	C	<p>On the night of production that began on October 3, 2013 at approximately 2150 hours while observing the start of operations in the evisceration department I observed an unlabelled plastic spray bottle hanging on a hook used to hang birds at the line 1 mirror station.&nbsp;The outer surface of the bottle including the handle was greasy and dirty thereby contaminating the hook (product contact surface).&nbsp;The bottle was approximately one fourth full of an unidentified liquid.&nbsp;The hook and the bottle were rejected with US tag B38075936.&nbsp;At the time, no product was on or near the hook.&nbsp;Mr. (B)(6) , was notified of the noncompliance.&nbsp;The establishment elected to discard the bottle and cleaned and sanitized the hook.&nbsp;As a verbal preventive measure, Mr. (B)(6) stated maintenance employee would be retrained to properly label containers and not to hang them on product contact surfaces.&nbsp;The regulatory control actions were then released.&nbsp;The establishment's SSOP plan states (B)(4) The requirements of 9 CFR 416.4(c) and 416.13(c) were not met. For a similar noncompliance refer to NR NHH5202082501N dated July 31, 2013.&nbsp;The preventive measure for this noncompliance was pipes would be removed from the production area prior to the start of production.&nbsp;These measures may have been implemented incorrectly or may have been ineffective at preventing recurrence.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5112	M18909	JDD1911101 703N-1	10/03/2013	01802	Pre-Op SSOP Review and Observation	C	<p>While performing PRE-OP this date&nbsp;09/30/2013 at 0400 H PST above the south end of Chiller B is a fan with flaking rust over the Carcass Chiller B. The following noted in Boning: 1): Product residue in the Tendon Puller. 2): Shrouds on the Frame Work&nbsp;of the MDP Motor was not disassembled an much product residue was noted. 3): Pallet Jack had product residue on it. 4): Two incidences of product residue in the Spiral Belt. 5): Belt Cog on the Thigh Skinner had product residue in it. 6): Cooler Ten: Three SS Tanks from sister facility has product residue in it. 7): The Door to (B)(4) Room by the Rosier is rusty. 8): Motor, Piping &nbsp;Etc. under the Injector in Bagging needs reconditioning as it is rusty with flaking paint. Items noted were corrected by Sanitation, Maintenance or are programmed to be fixed. Ms. (B)(6) was notified by e-mail.&nbsp;This is linked to NR 122-2013, Dated 09/27/2013, JDD00080955127N/1 and Seven other JDD # numbers listed on NR 122-2013. This is a violation of the Establishment's written SSOP Procedures and the following 9 CFR's:</p> <p>&nbsp;416.4&nbsp;&nbsp;&nbsp;Sanitary operations. (a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. (b) Non-food-contact surfaces of facilities, equipment, and utensils used in the operation of the establishment must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. (d) Product must be protected from adulteration during processing, handling, storage, loading, and unloading at and during transportation from official establishments.</p> <p>&nbsp;416.14&nbsp;&nbsp;&nbsp;Maintenance of Sanitation SOP's. Each official establishment shall routinely evaluate the effectiveness of the Sanitation SOP's and the procedures therein in preventing direct contamination or adulteration of product(s) and shall revise both as necessary to keep them effective and current with respect to changes in facilities, equipment, utensils, operations, or personnel.</p>

Table: NRs for all Foster farms for foia 2014-190 from Jan 01, 09 through March 06, 2014

Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN251210 4903N-1	10/03/2013	01802	Pre-Op SSOP Review and Observation	C	At approximately 0540 while performing hands on Pre-Operational Sanitation after company Pre-Operational Sanitation and before the start of production I observed the following noncompliance's in Zone D, Catering-rapid pack #1. Observed 1 knife holder on the side of the production belt with meat particules from the previous days production inside the knife holder all around the inside at the bottom. Also observed build up of material from previous days production on 5 rubber strips (5"highX6"long) which make up the steam guard at the front of the shrink tunnel. There were 2 rubber strips with buildup from the previous days production (1/2"wideX 5"long) at the exit of the shrink tunnel. The knife holder is a direct product contact surface, and the rubber strips on the shrink tunnel are product contact surface which could create cross contamination. This is a noncompliance of Regulations 416,4(a), 416.13(c) and a failure of the company SSOP Plan Pg 2, I (B)(6), and (B)(6) were notified and observed the noncompliance's. Immediate corrective action was implemented to restore sanitary conditions in my presence. This NR is being linked to NR LQN3314090018N/1 dated 09/18/2013. This document serves as written notification that your failure to comply with regulatory requirement(s) could result in additional regulatory or administrative action.
1325 7	P33900	NHH270310 4603N-1	10/03/2013	03J02	Slaughter HACCP	C	On the night shift that began on 10/02/2013, from 2245 until 2305, while giving relief breaks to the line inspectors, Dr. (B)(7)(C) and I observed a large amount of carcasses that displayed cloacae and intestines attached to the carcasses. At approximately 0100 I went to the exit end of the chiller system to verify that all of these cloacae and intestines had been removed. I inspected approximately 20 carcasses and found 4 with cloacae and intestines still attached to them. On the fourth carcass that still displayed an intestine, I observed feces on the inside of the carcass. The fecal material was tanish brown in color and smeared easily to the touch. The two spots of feces were each approximately 1/8 inch in size. Two of the (b)(6) in the area (Mr. (B)(6) and Mr. (B)(6)) were shown the feces at this time. I had randomly selected the carcasses to sample from the designated Post chill collection point, located at the station designated by the Establishment. There are no other check points and/or employees stationed between where the carcass was selected from the line and the point where they enter the rehang area. The carcass was also shown to Mr. (B)(6). Mr. (B)(6) was also notified. The establishment failed to meet the requirements of 9 CFR 417.2 (c)(4) and 9 CFR 381.65 (e). For similar noncompliance refer to NR #NHH4104053703N /1, dated 05/03/2013.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5129	M210	LQN251510 2502N-1	10/02/2013	01D01	SPS Verification	C	At approximately 13:10 while performing SPS verification I observed light from the outside coming in under the left corner (2inchX2inch) of the exit door between pest boxes 28&29 and over the doors top right hand corner (12 inches long) The door is in the raw oven staging area behind the weighing scale. This is a non compliance of Regulation 416.2(b)(3).Also observed peeling paint (3inchX 4inch), (2inchX 2inch) on the wall behind the salt(B)(4) mixing tank, and several places up the wall. I observed small pieces (1/4") of white peeling paint on the walls behind the guard rails (24 plus feet in lenght) on both sides of the hallway just inside the swinging doors from cooler #3, leading to the raw side oven area.This is a non compliance of Regulation 416.2(b)(2).Also observed 2 holes- 1 (12"X 8") and 1 (3"X4") in the floor topping in Raw Cooler #2 in a high traffic area. This is a non compliance of Regulation 416.2(b)(1).These non compliances are a noncomplianc of Regulation 416.1 (B)(6) and (B)(6) were notified and observed the noncompliances.This document serves as written notification that failure to comply with regulatory requirement(s) could result in additional regulatory or administrative actions.
5308	M6137	BXL2713104 402N-1	10/02/2013	04A06	Poultry Finished Product Standards	C	On 10/02/2013 at 1050 hours, while monitoring the Establishments AQL Procedure in Plant #1, randomly selected ten livers. Three out of the ten livers had whole spleens attached and one liver had a whole gall bladder attached. This exceeds the limit of (b)(4) incomplete trim-major defects for the process to be in control. l informed (B)(6) and (B)(6) of the noncompliance. Quality Control performed a recheck at 10:53 hours and failed with four incomplete trim-major defects and two incomplete trim-minor defects.Quality Control retained three tubs of livers. A recheck passed at 1112 hours, bringing the process back into control. The three tubs of livers were reworked and released by Quality Control.This is a noncompliance with regulations 9CFR381.65(a) and 9CFR381.1 "Giblets".

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL1905105 301N-1	10/01/2013	06D02	Other Inspection Requirements	C	At approximately 0139 hours, I performed a presentation check in Plant 1 on Line 2 at a line speed of (B)(4) (B)(4). Station #5 had 4- viscera not uniformed, and 2- opening cut for a total of 34 nonconformance points. Station #6 had 3- viscera not uniformed, 2- viscera attached to carcass, and 1- opening cut for a total of 49 nonconformance points. Station #7 had 2- viscera not uniformed, 2- viscera attached to carcass, 2- opening cut, and 1- parts inside for a total of 43 nonconformance points. This exceeded the limit of (B)(4) nonconformance points or 2 occurrences for the process to be in control. I informed (B)(6) and (B)(6) of the noncompliance, the line speed was reduced to (B)(4). At approximately 0205 hours I performed a recheck with the line speed at (B)(4). Station #7 failed with 3- viscera not uniformed, and 1- opening cut for a total of 25 nonconformance points. I informed (B)(6) of the noncompliance, the line speed was reduced to (B)(4). Rechecks at approximately 0231 hours, at a line speed of (B)(4) again at approximately 0349 hours at a line speed of (B)(4) and again at approximately 0439 hours at a line speed of (B)(4). All rechecks passed bringing the process back in control.
5308	M6137	BXL2211104 201N-1	10/01/2013	03J02	Slaughter HACCP	C	At approximately 0914 hours while performing scheduled Pre-Chill Finish Product Standards task I observed the following noncompliance. After taking a random 10 bird sample from Line (B)(4) in Plant #2, I observed one carcass with visible fecal contamination. There were two spots of fecal material on the leaf fat on the right side of the carcass, both pieces measuring approximately 1/4" x 1/8" in size. The fecal material was brownish green in color and thick and pasty in texture. I immediately informed (B)(6) and (B)(6) of the noncompliance. The Protocol for fecal failure was implemented. Quality Control performed a recheck at approximately 0946 hours which passed, bringing the process back into control. My findings indicate a noncompliance with 9CFR 381.65(e), 9CFR 417.2(c)(4) and the critical limits of CCP2B, (b)(4) of the Plants HACCP Plan for Slaughter.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL2708101 801N-1	10/01/2013	04A06	Poultry Finished Product Standards	C	On 10/01/2013 at approximately 0217 hours while monitoring Pre-Chill Finished Product Standards on line (B)(4) I observed the following. After taking a standard 10 bird sample I accumulated 50 nonconformance points. 30 points were from whole lungs. At this point CUSUM exceeded the Action Number allowed (22) so the process is judged to be out of control. I contacted (B)(6) who slowed the line to (B)(4) birds per minute. Normal line speed is (B)(4) birds per minute. Three extra personnel were placed at the end of the line to manually remove the lungs as there is no vacuuming facility available at that location. A QC recheck passed at 0226 hours. As product from lines (B)(4) & B are mixed coming out of the chiller, Post-Chill checks passed at 0321 hours and 0336 bringing the process back into control. The line was repaired and the line speed was returned to (B)(4) birds per minute at approximately 0420 hours. My findings indicated a noncompliance with 9 CFR 381.76(b)(3)(iv)(e)(3).
5568	M20923	XUM021210 0401N-1	10/01/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 0725 hours, while performing a routine PHIS task Pre-op review and observation inspection task (after establishment performed their pre-operational inspection and prior to start of production), I observed the following noncompliance: Line 2, Cook side of the establishment: I found few pieces of food crumbs on blue add back conveyor belt and the also on the back stainless plate from the previous day of production. Upon continuing my inspection Line (B)(4) found few pieces of food particles on takeaway and transfer conveyor belt also from the previous day of production. I took a regulatory control action and applied USDA retain/rejected tag# B24829895. I informed (B)(6) and (B)(6) and (B)(6) of the non-compliance. The finding described in the non-compliance was on the food contact surface, it is reasonable to conclude that when production began it would be under insanitary conditions. Immediate corrective action was performed by establishment on all affected areas upon notification of my finding. After sanitary conditions had been restored, I relinquished the regulatory control action at 0800 hours. Plant SSOP Section1, page1, states: (B)(4) ". 9CFR 416.13 (c) states: "All establishment shall monitor daily the implementation of the procedures in the sanitation SOP's". 9CFR 416.4 (a) states: "All food contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and adulteration of product". This document serves as written notification that failure to meet these regulatory requirement(s) could result in additional regulatory or administrative action.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
1325 7	P33900	NHH460010 4801N-1	10/01/2013	06D02	Other Inspection Requirements	C	On the night shift that began on 09/30/2013, at approximately 2115 hours I asked the Evisceration supervisor, Mr. (B)(6), to perform a test in the picking room of the establishment. This Establishment uses a batching system of inspection, if the carcass is condemned or hung back for re-inspection the paw condemn button is pressed and a batch of paws are condemned. This insures that all paws from condemned carcasses are also condemned. The result of the test was that the establishment could not collect but three of the paws that are marked to show that all condemned paws would be captured and condemned on line #2. Mr. (B)(6) diverted all paws from this system to the drain so no Regulatory Control Action was taken. Line #1 segregated and condemned all 4 of the marked paws, so this line was allowed to collect paws from this system. At approximately 2230 another test was performed on the line #2 system and the results were that all the paws were segregated and condemned. This allowed the Establishment to begin collecting paws from that line also. The requirements of Regulation 381.76(b) were not being met. Refer to NR NHH4620090922N / 1 dated 09/22/2013 for similar noncompliance.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5308	M6137	BXL4305093 430N-1	09/30/2013	01D01	SPS Verification	C	<p>On 09/30/2013 at approximately 0100 hours while performing an SPS Verification task in Plant 2, I observed the following. There was rust on the painted support brackets for the kickoff assembly on the first inspection for Line (b)(4). There was rust on the support brackets; the motor assembly for Line (b)(4) at the same location. There was rust and peeling paint on a section of a dead end electrical conduit over the IOBW (inside/outside bird washer) over line (b)(4) that extends over the presenters area through line (b)(4) and (b)(4). At the second inspection station of line (b)(4) the light support bracket that measures approximately 2" by 15' has peeling paint. Mounted on the ceiling over the Liver & Heart machine are two support brackets for the rail; that each measure approximately 3" by 15' both are rusted. At the third inspection station for line (b)(4) over the gray wing salvage container there is a support bracket that measures approximately 2" by 20' that has peeling paint. Over the Liver & Heart machine on line (b)(4) is a bracket that measures approximately 2" by 6' that is rusted. Over the Gizzard Puller for line (b)(4) a bracket that measures approximately 2" by 3' is rusty. At the backup gizzard pullers station a pipe holder that measures approximately 2" by 20' is rusted. Near the Liver & Heart machine for line (b)(4) is a pipe hanger that measures approximately 2" by 2' that has rust and peeling paint. Over the backup gizzard pullers station there was a bracket measuring approximately 2" by 10' that is rusty. Over the Lunger for line (b)(4) a bracket that measures approximately 4" by 4' is rusty. A 4" dead end pipe near the ceiling at the same location is rusty. Two brackets over the (b)(4) bird washer for line (b)(4) are rusty. On line (b)(4) there are two support brackets over the (b)(4) bird washer that are rusted. A 4" air pipe over the Liver & Heart machine has peeling paint. At the third inspection station there was rust on the painted brackets for the kickoff. The painted surfaces of the kickouts for line (b)(4) & (b)(4) at all three inspection stations are rusty/peeling paint. Over the Gizzard Puller backup station for line (b)(4) there are three pipe hangers that are rusted. A support bracket measuring approximately 3" by 10' over the (b)(4) bird washer for line (b)(4) is rusty. Rust and corrosion and peeling/flaking paint directly over exposed product passing down the Evisceration line is creating an insanitary condition. My findings indicated a noncompliance with 9 CFR 416.1 and 9 CFR 416.2(b)(1).</p>

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5309	P6137A	NJN241609 1630N-1	09/30/2013	03J04	Poultry Zero Tolerance Verification	C	On 9/30/13 at approximately 1445 hours I observed the following while performing the Zero Tolerance procedure on line # 2 at the FPS station . After pulling a ten bird random sample I noticed the back side of one bird with dark green spots were the oil gland had been removed . The area was approximately 1 sq inch size . I immediately reported my findings to (B)(6) who observed the bird and contacted Evis/Pkg. Dept. (B)(6) while (B)(6) performed a recheck (B)(6) requested further disposition from Dr.(B)(7)(C) . After confirmation by Dr.(B)(7)(C) the establishment was informed of the noncompliance. My finding indicate noncompliance with regulation 9CFR 381.65(e) which states that carcasses contaminated with fecal material shall be prevented from entering the chiller tank the establishments, the criteria for CCP 1B was also compromised .
5568	M20923	XUM542209 5830N-1	09/30/2013	01D01	SPS Verification	C	On 9/30/13, at approximately 2028 hours, while performing a routine scheduled Sanitation Performance Standard (SPS) inspection task on the Cook Area Line ^{(B)(6)} by the north portion of the Oven Room, I observed the following noncompliance: leaking water from piping to the belt wash pump creating insanitary conditions of flooded standing waste water on the flooring by the electrical room door a noncompliance per 9 CFR 416.1 and 416.2(e)(2). This type of environment can possibly grow and spread food borne pathogens such as Listeria Monocytogenes. I took regulatory control by rejecting the area with US Tag # 147503. I showed and informed Mr. (B)(6) of the forthcoming noncompliance. After corrective actions were performed by production and sanitary condition were restored, I relinquished the US Tag at 2048 hours. The requirements of 9 CFR 416.1 and 416.2(e)(2) were not met. A similar noncompliance XUM5919094917N/1 was documented on 09/17/2013.
5568	M20923	XUM542209 5830N-2	09/30/2013	01D01	SPS Verification	C	On 9/30/13, at approximately 2036 hours, while continuing my Sanitation Performance Standards (SPS) inspection check, on the Cook Area Cooling Line ^{(B)(6)} Mezzanine, I observed the following noncompliance: two plumbing pipes that provide water for the upper mezzanine leaking water creating insanitary conditions, a noncompliance per 9 CRF 416.2(e)(3) and 416.1. This condition was leaking water to the mezzanine floor causing standing water. I showed and informed Mr. (B)(6) of the forthcoming noncompliance. The requirements of 9 CFR 416.2(e)(3) and 416.1 were not met.

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Est ID	Est Nbr	NR Number	Date	Procedure Code	Regulations	Status	Description
5769	M6492	DIO4902091 230N-1	09/30/2013	01B02	Pre-Op SSOP Review and Observation	C	At approximately 2315 hours I started my Pre-operational Review and Observation task upon learning from the QC that the area (Raw Processing) is ready for inspection. I noticed at kettle number 7 that there are specks of debris of unknown origin which is black and hairlike of about 1/16"x1/8" to 1/16"x3/8" of an inch scattered at the center of the kettle which numbered to approximately 100 specks. I called the attention of (B)(6) and he immediately called the Sanitation worker to clean up the said debris. Had this contaminant not been found, it will potentially contaminate and adulterate the product that will be produced in that kettle. This is in violation of Title 9 CFR 416.4(a) and 9 CFR 416.13(c) 9 CFR 416.4(a) All food-contact surfaces, including food-contact surfaces of utensils and equipment, must be cleaned and sanitized as frequently as necessary to prevent the creation of insanitary conditions and the adulteration of product. 9 CFR 416.13(c) Each official establishment shall monitor daily the implementation of the procedures in the Sanitation SOP's.
1325 7	P33900	NHH411109 2330N-1	09/30/2013	01D01	SPS Verification	C	At 0952 hours while performing a Sanitation Performance Standard task I came across 11 combos of product that were labeled "inedible" and placed in the inedible section of the back cooler that did not have denaturant applied. There were 8 combos of livers and 3 which contained bones. Management was notified and shown the combos. CFR 381.95 states that denaturing shall be accomplished by liberally applying it to all of the carcasses and parts. These requirements were not met; therefore, US reject tag #B36322955 was applied to the cooler. The same noncompliance was reported in Noncompliance Records NHH4811092411/1 on 09/11/2013 and NHH4612063721/1 on 06/21/2013. Efforts to prevent the recurrence of this noncompliance either have not been made or have not been effective.