

		Product Release	
Compilation Date	09 Oct 2018	Revision date	09 Oct 2018
Controlling Officer	QA Manager	Sign	Document Ref. No. SOP 1.13
Approval Officer	Operations Manager	Sign	Revision Number 000

Purpose: This procedure will provide a full description of the “release” criteria used during the slaughter process.

Scope: Receiving of livestock and Slaughter process

Definitions: As per document DEF 001

Applicable legislation: As per document LESGIS 002

Work Instruction

In order to ensure a good end product slaughter quality standard should be adhered to. Thus, work instruction on slaughtering should be clear and not compromised.

Receiving of livestock

Delico Mainly slaughter their own livestock. When animals are offloaded a meat inspector together with the animal welfare officer will be present to ensure humane offloading. The batch is offloaded into the sorting pens. If an animal is dead upon arrival, or damaged it will be noted as such in the check sheet. Animals that are in good condition will be accepted. Damaged or animals that was stepped on will be inspected by meat inspectors who will decide if product can be slaughtered.

Once a batch is offloaded the animals need to rest for a few hours (± 12 hours), depending on the distance it travelled. The animals need to be put in pens that is equip with a water and the pens need to be under roof. Animals may be stored in such a manner that it complies with regulations.



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Slaughtering and Dressing process

Slaughter procedure – SHEEP/LAMB

Stunning

1. Ensure electrical stunner are in good condition
2. Follow the manufacturer recommendations for time, 180-200 volts and 0.8-1 amperes
3. Ensure pincers are long enough to penetrate wool
4. Place electrodes correctly on both sides of the head to over span the brain.
5. Ensure effective stunning by checking for a well-defined tonic phase, involving retraction of both front and back legs, followed by stunning animal as long as 15 – 20 seconds, along with the absence of breathing and a fixed position of the eye
6. Do not over stun (kill stun)

Shackle and hoist

1. Do not waste time
2. Attach bleeding chain around hind leg
3. Time

Throat Cutting / Bleeding

1. Make use of two knife system
2. Rotate between carcasses
3. Ensure knife is sharp
4. Take the head of the sheep by the mouth (lower jaw), in the left hand and pull it.
5. With the right hand, position the knife across the throat, just behind the lower jaw, and with a quick pulling action, sever the arteries in the neck without cutting into the neck vertebrae.



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6. Take care not to “crack” the neck during this procedure.
7. Allow 6 minutes bleeding time

Electrical Stimulation

1. Move 5-6 lamb/sheep to the stimulator bar away from other sheep
2. Clear away
3. Activate the stimulator
4. After the stimulator cycle of 45 seconds, the carcass will relax
5. Remove sheep away from the stimulator bar
6. If needed rinse with water
7. AMP 250 VA
8. Volt 11
9. Stimulate for ± 1 min (automatic switch off)

Small incision on loose leg (right), spear cut, remove leg, transfer

1. Do not start cutting before the 6 minutes bleeding time is over
2. Make use of two knife system
3. Spear cut made from inside to outside
4. Wash hands and equipment regularly

Small incision on loose leg (left), spear cut, remove leg, transfer

1. Spear cut made from inside to outside
2. Use two knife system
3. Wash hands and equipment regularly

Front feet & Hind Feet

1. Remove front feet.
2. The front feet and hind feet is placed in a container.
3. The central opening line is now extended to the throat.

1ST and 2ND hind leg inside and outside ✓

1. Avoid contamination of meat by skin, wool, dust and dirty hands.
2. Use 2 knives.



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Heads removed, count teeth

1. When removing head place serial number in ear of sheep and the other on the shank of carcass.
2. Count the teeth and the age colour code is put on the shank
3. The head gets placed in container.

Flaying left and right and back, final removal of the skin

1. Flaying with hand knife until the elbows are exposed
2. The brisket area is now flayed
3. Spear cuts are made on front legs and the legs are flayed
4. The skin are pulled off by hand till the neck
5. Final skin removed by skin puller
6. Skins are directly taken to the skin room

Ring anus, middle opening line, saw breast bone, eviscerate rough, eviscerate red and hang up for inspection

1. Make an incision in the abdominal wall (on the central opening line) between the legs.
2. Make an incision down to the breastbone.
3. Two fingers may be used to press the intestines away from the incision while cutting.
4. An incision is made on either side of the rectum in the pelvic canal.
5. Two fingers of the left hand are pushed into the pelvic canal and the anus and the rectum is pulled down to the bladder and uterus in the case of ewes.
6. These organs are then cut loose together with the large intestine up to the junction between the large and small intestines.
7. Before above mentioned is separated from the small intestine, the intestine should be stroked to move the contents away from where the separation is to be done before cutting.
8. Failure to do this will result in faecal contamination of the carcass.
9. Pull the omentum together, cut loose and place into a container.
10. Push the rumen down with the left hand and with the same hand take hold of



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the reticulum pulling it out of the abdominal cavity.

11. The oesophagus will now be visible and should be cut off.
12. The total stomach can now be lifted out and placed into a tray for inspection.
13. As an alternative, the intestines and stomach should be removed as a whole if above procedure cannot be accomplished without contamination.
14. The plug is now removed and hangs on rail for inspection.
15. The serial number is written on the lung for correlation
16. Gall not to be opened on the floor, gall is treated as condemned material.
17. If there is a commercial market for the re-productive organs, then the re-productive system will also be processed in an allocated area outside the abattoir, the offal processing area before or after any other processing in the area.

Meat inspection

No carcass contaminated may be washed of, contaminant, only the Meat Inspector to trim off before final wash.

Grading

1. Grading is done by FSA personal
2. Make sure that grading equipment is clean

Weighing

1. Carcass is pull onto the scale weighing and tagging

Wash carcasses and hanging

1. Use clean running water
2. Wash only bone splinters and blood- do not try to wash off contamination- report to MI & Abattoir Manager
3. Do not wash the outside extensively- try to keep the outside as dry as possible
4. Wash only the inside if possible
5. The carcass is now hanged on sheep cradles (6 on a cradle)



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Chillers

1. The full cradles are now pushed into the drying area
2. The passed stamp is stamp on the carcass
3. Then the cradles are push into the chillers, not to close to ensure good flow of air for effective chilling

Continues quality throughout process

In each abattoir is a Quality Controller to monitor the quality of the carcasses in both abattoirs though out the slaughtering and dressing of carcasses. These checks are done to better the overall quality of the final product.

Corrective action

All nonconformances will be reported to QA manager. QA Manager will do investigation and once investigation is done, corrective action will be done accordingly.

Specific Responsibility	Designated To:
Steady flow of carcass from stunning to cooling	Production Managers
Hygienic practices throughout the process	Hygiene manager/assistant
Grading	Meat Inspectors
Chilling and Dispatch	Dispatch Manager



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Supporting Documents:	Doc. Ref. Number
Calibration & Verification of Equipment	SOP 1.17
Sterilizer Control	SOP 1.19
Foreign Matter Control	SOP 2.13

Supporting Records:	Doc. Ref. Number
Scale Verification Record	REC 1.17.3
Cold Room Dial Verification Record	REC 1.17.4
Stunner Verification Record	REC 2.5.3
Sterilizer Temperature Record – Clean Area	REC 1.19.1
Sterilizer Temperature Record – Dirty Area	REC 1.19.2
Receiving of sheep-beef livestock	REC 1.13.1
Continuous Quality Checks beef/Sheep	REC 1.13.2

Process	Lower Limit	Upper Limit	Verification	Frequency	Correction
Sheep					
Stunning	110-220 Volts & 250 Å.	No over stunning (kill stun)	REC 1.17.7	For every animal	
Shackle and Hoist	n/a	n/a	None	For every animal	
Bleeding	6 min bleeding time	n/a	None	For every animal	
Electrical	- 45 sec	- 6 sheep	None	6 animals	



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Stimulation	cycle	at a time		at a time	
Small incision on loose leg (right), spear cut, remove leg, transfer	n/a	n/a	None	For every animal	
Small incision on loose leg (left), spear cut, remove leg, transfer	n/a	n/a	None	For every animal	
Front feet	n/a	n/a	None	For every animal	
1 ST and 2 ND hind leg inside and outside	n/a	n/a	None	For every animal	
Heads removed, count teeth	n/a	n/a	None	For every animal	
Flaying left and right and back, final removal of the skin	n/a	n/a	None	For every animal	
Ring anus, middle opening line, saw breast bone, eviscerate rough, eviscerate red and hang up for inspection	n/a	n/a	None	For every animal	
Meat inspection	condem n	Approve	Only for NC	For every animal	
Grading	n/a	n/a	ABASERVE	For every animal	



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Weighing	n/a	n/a	ABASERVE	For every animal	
Wash carcasses and hanging	Just inside of carcass	Entire carcass	None	For every animal	
Chillers	<6 °C	Cool to 6 °C	None	For every animal	

Required Training for Specific Responsibility:	
Slaughtering skills for respective species (Ovine)	
Recording of time and temperature data	
Grading of carcasses and identification of illnesses	