

**§ 381.67**

**9 CFR Ch. III (1-1-01 Edition)**

from the official establishment prior to freezing: *Provided*, That the plant and freezer are so located and such necessary arrangements are made that the Inspection Service will have access to the freezing room and adequate opportunity to determine compliance with the time and temperature requirements specified in paragraph (f)(2) of this section.

(4) Warm packaged ready-to-cook poultry which is to be chilled by immediate entry into a freezer within the official establishment shall within 2 hours from time of slaughter be placed in a plate freezer or a freezer with a functioning circulating air system where a temperature of -10 °F. or lower is maintained.

(5) Frozen poultry shall be held under conditions which will maintain the product in a solidly frozen state with temperature maintained as constant as possible under good commercial practice.

(6) Immersion or spray freezing equipment shall be constructed of non-corrosive metal or other acceptable material. Compounds used in immersion or spray freezing procedures shall be approved by the Administrator.

[37 FR 9706, May 16, 1972, as amended at 39 FR 4568, 4569, Feb. 5, 1974; 40 FR 42338, Sept. 12, 1975; 49 FR 9411, Mar. 13, 1984; 60 FR 44412, Aug. 25, 1995; 63 FR 48960, Sept. 11, 1998]

**§ 381.67 Young chicken slaughter inspection rate maximums under traditional inspection procedure.**

The maximum birds to be inspected by each inspector per minute under the traditional inspection procedure for the different young chicken slaughter line configurations are specified in the following table. These maximum rates shall not be exceeded. The inspector in charge shall be responsible for reducing production line rates where in the inspector's judgment the prescribed inspection procedure cannot be adequately performed within the time available, either because the birds are not presented by the official establishment in such a manner that the carcasses, including both internal and external surfaces and all organs, are readily accessible for inspection, or because the health conditions of a particular flock dictate a need for a more

extended inspection procedure. The standards in §381.170(a) of this part specify which classes of birds constitute young chickens. Section 381.76(b) specifies when either the traditional inspection procedure or the modified traditional inspection procedure can or must be used.

**MAXIMUM PRODUCTION LINE RATES—YOUNG CHICKENS—TRADITIONAL INSPECTION PROCEDURES**

Line configuration <sup>1</sup>	Number of inspection stations	Birds per inspector per minute
6-1 .....	1	25
12-1 .....	2	23
12-2 .....	2	21
18-1 .....	3	19
18-2 .....	3	19
18-3 .....	3	18
24-1 .....	4	16½
24-2 .....	4	16
24-4 .....	4	15½

<sup>1</sup>Birds are suspended on the slaughter line at 6-inch intervals. The first number indicates the interval in inches between the birds that each inspector examines. The second number indicates how many of the birds presented, the inspector is to inspect, i.e., "1" means inspect every bird. "4" means inspect every fourth bird, etc.

[47 FR 23435, May 28, 1982]

**§ 381.68 Maximum inspection rates—New turkey inspection system.**

(a) The maximum inspection rates for one inspector New Turkey Inspection (NTI-1) and two inspector New Turkey Inspection (NTI-2) are listed in the table below. These line speeds are for lines using standard 9-inch shackles on 12-inch centers with birds hung on every shackle and opened with J-type or Bar-type opening cuts. Maximum rates for those establishments having varying configurations will be established by the Administrator but will not exceed those in the table. Neither the rates in the table nor those established for establishments with varying configurations shall be exceeded under any circumstances.

(b) There are two categories of turkeys for determining inspection rates, "light turkeys" and "heavy turkeys". Light turkeys are all turkeys weighing less than 16 pounds. Heavy turkeys are all turkeys weighing 16 pounds or more. The weights refer to the bird at the point of post-mortem inspection, with blood, feathers and feet removed.

(c) The inspector in charge may reduce inspection line rates when in his/her judgment the prescribed inspection procedure cannot be adequately performed within the time available because the health conditions of a particular flock dictate a need for a more extended inspection.

MAXIMUM TURKEY INSPECTION RATES

Inspection system	Line configuration	Number of inspectors	Birds/Minute			
			J-Type		Bar-Type	
			(<16#) light	(>16#) <sup>1</sup> heavy	(<#) light	(>16#) <sup>1</sup> heavy
NTI-1 .....	12-1	1	32	30	25	21
NTI-2 .....	<sup>2</sup> 24-2	2	51	41	45	35

<sup>1</sup>This weight refers to the bird at the point of post-mortem inspection, without blood, feathers, or feet.  
<sup>2</sup>The turkeys are suspended on the slaughter line at 12-inch intervals, with two inspectors each looking at alternating birds at 24-inch intervals.

[50 FR 37512, Sept. 16, 1985]

**Subpart J—Ante Mortem Inspection**

**§ 381.70 Ante mortem inspection; when required; extent.**

An ante mortem inspection of poultry shall, where and to the extent considered necessary by the Administrator and under such instructions as he may issue from time to time, be made of poultry on the day of slaughter in any official establishment.

**§ 381.71 Condemnation on ante mortem inspection.**

Birds plainly showing on ante mortem inspection any disease or condition, that under §§ 381.80 to 381.93, inclusive, 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.

**§ 381.72 Segregation of suspects on ante mortem inspection.**

All birds which on ante mortem inspection do not plainly show, but are suspected of being affected with any disease or condition that under §§ 381.80 to 381.93, inclusive, may cause con-

demnation in whole or in part on post mortem inspection, shall be segregated from the other poultry and held for separate slaughter, evisceration, and post mortem inspection. The inspector shall be notified when such segregated lots are presented for post mortem inspection and inspection of such birds shall be conducted separately. Such procedure for the correlation of ante mortem and post mortem findings by the inspector, as may be prescribed or approved by the Administrator, shall be carried out.

**§ 381.73 Quarantine of diseased poultry.**

If live poultry, which is affected by any contagious disease which is transmissible to man, is brought into an official establishment, such poultry shall be segregated. The slaughtering of such poultry shall be deferred and the poultry shall be dealt with in one of the following ways:

(a) If it is determined by a veterinary inspector that further handling of the poultry will not create a health hazard, the lot shall be slaughtered separately, subject to ante mortem and post mortem inspection pursuant to the regulations.

(b) If it is determined by a veterinary inspector that further handling of the poultry will create a health hazard, such poultry may be released for treatment under the control of an appropriate State or Federal agency. If the circumstances are such that release for treatment is impracticable, a careful