

## 2.10.1, 2.10.2 & 2.10.3. Receival Hoppers for RAM and Verification

### Standard

2.10.1 Where the mill manufactures ruminant feeds, are separate receival hoppers available for handling Restricted Animal Material (RAM)?

2.10.2 If there is not a separate receiving hopper for RAM, are written procedures in place and followed to prevent cross contamination of non-RAM raw materials being received?

2.10.3 Are these procedures verified through inspection, sampling and testing?

*The auditor needs to sight the verification records as well as validations as per clause 8.1.*

### Purpose

To ensure detailed procedures are available for the receival of RAM, including hoppers for receiving and verification.

### Reason

RAM is defined as tissue, blood or feathers derived from the carcass of an animal, including any substance produced from or containing any such tissue blood or feathers (but not including tallow, gelatine, milk or milk products). RAM includes any rendered animal meal including but not limited to meat and bone meal, fish meal or poultry offal meal. (See Recommended Reading.)

A feed safety risk is present where receival hoppers are not separate. The operator shall determine all material is cleared with the appropriate flush type and volume to prevent cross-contamination into subsequent feeds or non-RAM materials. The verification of procedures ensures they are achieving their intended purpose.

Operators have a regulatory responsibility according to the Ruminant Feeding Ban, to control all possible RAM cross-contamination into incompatible feeds.

### What is Acceptable?

#### Hazard Risk Assessment

A site hazard risk assessment must be in place for the receival, storage, and processing of RAM product. The risk assessment shall utilise the seven principles of HACCP, as discussed in Fact Sheet 5.2.1 to 5.2.4. The risk assessment relating to intake hoppers shall take into consideration:

1. Receival hoppers.
2. Multi-Species Mill (particularly where ruminant feed is manufactured).
3. Transport trucks.

#### Receival Systems

Where separate intake receival systems are not available, then detailed review of procedures including sequencing of raw material delivery, cleaning and flushing after delivery of RAM is required. Fact sheet 8.1.2 discusses the validation of cross-contamination measures.

Receival vehicle declarations of previous loads and/or cleanliness need to be reviewed and filed on all bulk receivals. Refer to receival of goods as per Fact Sheet 6.2.1 & 6.2.2.

Procedures should include a mandatory inspection of the pit, surrounds and the conveyors to ensure they are cleaned of all material before the next non-restricted feed raw material is received.

Some milling equipment such as drag conveyors are designed to be self-cleaning, whilst other equipment such as screw conveyors are not self-cleaning. Where intake and conveyors do not always self-clean, these areas should be re-engineered and repaired at the earliest opportunity.

The following is recommended for raw material intake flushing following the receipt of RAM:

- For self-cleaning systems, a minimum 500kg of non-restricted materials.
- For non-self-cleaning systems, a minimum 5 minutes of running with non-restricted materials or the time it takes for the flushing material to reach the furthest possible destination point.

#### Validation and Verification

**Validation** = "Obtaining evidence that the control measures will be effective" (ISO 22000:2005). This means proving that the system you have designed will control the hazard and perform as required.

**Verification** = "Confirmation, through the provision of objective evidence that specified requirements have been fulfilled" (ISO 22000:2005). This means reviewing that procedures have been implemented and followed as designed.

It is recommended that the process to flush the intake system has been validated to confirm that no residual RAM is carried into the following feed (See 'Completing the Control Verification Test' in Fact Sheet 8.1.2). Samples shall be collected immediately after flush is complete. Validation of the flushing system is based upon:

- Physical inspection.
- Sampling and testing (completed at least every 6 months).

Verification of receipt system is through a detailed review of procedures, including sampling and testing. This might be through an internal audit process.

The flushing material used must be segregated following flushing and only used in feeds containing RAM according to the rework conditions (Fact Sheet 2.10.7). The bagged flush material shall be clearly labelled and stored in designated storage area (Fact Sheet 2.10.4).

Verification of flushing can be performed through internal audits by reviewing records of flushing, or through other internal processes such as supervisor batch release reviews.

#### Recommending Reading

[Australian Ruminant Feed Ban National Uniform Guidelines](#), Animal Health Australia.

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