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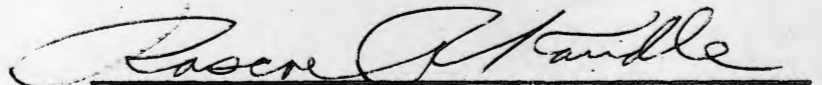


REGULATIONS CONCERNING CONSTRUCTION, OPERATION AND
- MAINTENANCE OF MEAT PROCESSING ESTABLISHMENTS
AND LABELING OF MEAT PRODUCTS PROCESSED FOR FOOD

The State Department of Health of the State of New Jersey pursuant to authority vested in it by statute, hereby establishes the following Rules and Regulations concerning construction, operation and maintenance of meat processing establishments and labeling of meat, meat byproducts and meat food products processed for food. Any Rules and Regulations in these matters which may have been adopted by this Department prior to the effective date of these regulations are hereby rescinded. (R.S. 24:2-1)

NEW JERSEY STATE DEPARTMENT OF HEALTH

By:


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State Commissioner of Health

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The following Regulations shall be met by all establishments in which meat, meat byproducts and meat food products are processed for food.

Regulation 1

Definitions

For the purpose of these regulations the following words, phrases, names and terms shall be construed, respectively, to mean:

- 1.1 The Department - The New Jersey State Department of Health.
- 1.2 The Local Board of Health - Local board or local board of health means the board of health of any municipality or the boards, bodies or officers in such municipality lawfully exercising any of the powers of a local board of health under the laws

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governing such municipality, and includes any consolidated local board of health or county local board of health created and established pursuant to law.

- 1.3 Inspector - A properly licensed representative of the State or Local Board of Health.
- 1.4 Animal - Cattle, sheep, swine, goat, horse, rabbit, deer or other animals used for food.
- 1.5 Carcasses - All parts including viscera of a slaughtered animal that are capable of being used for food.
- 1.6 Meat - The edible part of the muscles of cattle, sheep, swine, goats, horses, rabbits, deer or other animal used for food which is skeletal or which is found in the tongue, in the diaphragm, in the heart, or in the esophagus, with or without the accompanying and overlaying fat and the portion of bone, skin, sinew, nerve, and blood vessels which normally accompany the muscle tissue and which are not separate from it in the process of dressing. It does not include the muscle found in the lips, snout or ears.
- 1.7 Meat byproducts - Any edible part other than meat which has been derived from one or more cattle, sheep, swine, goat, horse, rabbit, deer or other animal used for food.
- 1.8 Meat food products - Any article of food, or any article intended for or capable of being used as food which is derived or prepared, in whole or substantial and definite part, from any portion of any cattle, sheep, swine, goat, horse, rabbit,

deer or other animal that can be used for food, except such articles as organotherapeutic substances, meat juices, meat extract, and the like, which are only for medical purposes and are advertised only to the medical profession.

- 1.9 Product - Any part or all of meat, meat byproducts, and meat food products.
- 1.10 Immediate container or true container - The unit can, pot, tin, canvas, or other receptacle or covering in which any product is customarily shipped.
- 1.11 Person - Natural person, individual, firm, partnership, corporation, company, society, and association, and every officer, agent or employee thereof. This term shall impart either the singular or plural as the case may be.
- 1.12 Meat processing establishment - Every establishment in which meat, meat byproducts or meat food products of or derived from cattle, sheep, swine, goats, horses, rabbits, deer or other food animals are wholly or in part, canned, cooked, cured, smoked, salted, packed, rendered or otherwise prepared or processed for sale in this State as food: Provided, however, the Department may exempt meat processing establishments from construction and layout requirements as specified under these regulations, in instances where the volume of meat used in food products processed represent only a small percentage of their total production. All other

sections of these regulations and Title 24 R.S.N.J. relative thereto shall be complied with.

Regulation 2

Meat Inspection Requirement and Records

- 2.1 Meats and animal carcasses or package or container thereof shall not be received for processing unless they bear a stamp, tag or legend indicating the meat or animal carcasses have been inspected for wholesomeness under the Department or Federal meat inspection programs.
- 2.2 Records of purchases of meat and animal carcasses shall be maintained by the meat processing establishment for eighteen months, and shall be available for examination by representatives of the Department or the local board of health.

Regulation 3

Construction and General Layout of Meat Processing Establishments

- 3.1 Meat processing establishments and their facilities shall be well constructed, properly situated, and equipped for the purpose used, and so maintained that products prepared for food therein will not be subject to contamination.
- 3.2 Lighting - All rooms and areas in meat processing establishments shall be well lighted with at least 30 foot-candles of light intensity on all working surfaces and at least 5 foot-candles at a distance of 30 inches from the floor.

3.3 Ventilation - All rooms and areas shall be well ventilated with sufficient ventilation to dispel disagreeable odors, condensate, and vapor. Where needed, ventilating equipment, such as individual fans, vents and hoods shall be provided. Space heaters, gas stoves, water heaters and any other equipment giving off noxious odors, fumes and vapor shall be vented to the outside air. Mechanical ventilating equipment, where used, shall be so located and controlled as to prevent air-borne contamination of meat products.

3.4 Water supply - Water supply shall be easily accessible, adequate and conform to standards of the Department for public potable water supplies. Hot and cold water shall be conveniently accessible to all parts of the establishment and shall be under ample pressure and in such quantities as are necessary to meet effectively the needs of the establishment at all times. The hot water system shall have sufficient capacity to furnish ample water of at least 140°F. during all periods of processing and operations. If hot water is used for sterilizing purposes sufficient quantities of 180°F. water shall be provided.

3.5 Plumbing and Related Facilities

3.5.1 Outlets and connections to fixtures and equipment shall be so installed as to prevent backflow into the water distribution system.

3.5.2 Each fixture directly connected with the drainage system shall be equipped with a water-seal trap.

- 3.5.3 Refrigerators, or other facilities or items of equipment in which carcasses or parts thereof, utensils, or portable equipment are placed, shall not be directly connected to the drainage system; each wastepipe of such a facility or item of equipment shall discharge into a trapped and vented open sink or receptacle, or into a floor drain, through an airgap at least twice the effective diameter of such wastepipe above the floodlevel rim of the sink or receptacle or the drain which received the drainage therefrom. If a refrigerator room is not equipped with a floor drain, all parts of the floor shall be at least 2 inches above the highest level of the floor of each adjoining room or area into which such refrigerator room opens or drains, and the floor shall be graded to drain to the outside through a wastepipe, doorway, or other opening.
- 3.5.4 Plant drainage lines shall be separate from sewer lines to a point outside the building.
- 3.5.5 A separator or indirect-waste receptor shall be provided where necessary to prevent discharge into the drainage system of solid waste from processing operation likely to clog the drainage system.
- 3.5.6 All overhead drainlines and piping shall be so located and installed, or so protected, that leakage and condensation therefrom will not drip upon carcasses or parts thereof, stored edible products, processing equipment or utensils, facilities for the

cleaning of utensils and portable equipment, or floors in working or trucking areas.

- 3.5.7 Employee toilet facilities, adequate for the use of all employees during peak periods of operation, shall be provided in convenient locations in the establishment. Toilet rooms and fixtures shall be kept clean and in good repair. A supply of toilet tissue shall be provided in toilet rooms at all times.
- 3.5.8 An adequate number of lavatory facilities shall be located in or adjacent to each employee toilet and dressing room, and at such other places in the establishment as may be necessary for the convenient washing of hands by employees engaged in the conduct of slaughtering and meat processing operations. No utensil or equipment-washing vats or water-flushed trough shall be substituted for lavatory facilities.
- 3.5.9 Each lavatory facility shall be provided with hot and cold water under pressure with provisions for mixing or blending the water to a temperature of 100°F. to 115°F. Steam mixing valves are prohibited for this purpose.
- 3.5.10 Soap or other detergent, made available through the use of a dispenser, and proper facilities for drying hands shall be provided at each lavatory. The use of a common towel is prohibited.
- 3.5.11 Containers constructed of impervious material shall be provided near lavatories for the disposal of used towels.

3.5.12 Drinking-water facilities of a sanitary type shall be provided in the establishment, and shall be so located as to be convenient for use of employees.

3.6 Disposal of Wastes

- 3.6.1 Meat processing establishments and their facilities shall be provided with an adequate system of disposal of all wastes. If practical, liquid wastes shall be discharged into a public sewer system. If liquid wastes are to be discharged into any waters of this State, a separate permit issued in accordance with the applicable sections of Title 58 R.S.N.J. and the rules and regulations of the Department governing such discharges must first be obtained.
- 3.6.2 All wastes shall be handled and disposed of in a manner which will prevent possible contamination of food, the water supply, processing equipment, packaging materials and containers and exterior premises.
- 3.6.3 All liquid wastes shall receive such treatment as may be required by the local health authority and this Department and shall be disposed of in a manner approved by such authorities.
- 3.6.4 Grease catch-basin, grease trap, or waste disposal unit shall not be located in processing, storage, or sales areas unless approved by the Department.
- 3.6.5 Waste water from processing or other equipment shall not be discharged or drained from the equipment in such manner as

will permit flooding of the floor or the flowing of water across working or trucking areas.

- 3.6.6 After collection, solid wastes shall be held in impervious, water-tight and easily cleanable containers. Such containers shall be covered with tight-fitting lids and stored on a concrete slab or on a rack which is at least 12 inches above the floor or ground for a single bank of containers; or 18 inches above the floor or ground for a multiple bank of containers; or such containers shall be stored in a refuse room. Solid wastes from the processing operation shall immediately be placed in such containers.
- 3.6.7 Containers used for the collection and holding of solid wastes shall be kept covered or otherwise protected at all times, so that such wastes shall not be accessible to flies, rodents, or other vermin, or otherwise create a nuisance.
- 3.6.8 In establishments provided with refuse rooms, solid wastes shall be stored in such rooms, and shall be disposed of at least once a day, or as otherwise approved by the Department.
- 3.6.9 Methods and procedures for the disposal of all solid wastes shall be such as will not provide food or harborage for rodents, insects, or other vermin, or otherwise create a nuisance.

3.7 Equipment, Facilities and Utensils

- 3.7.1 Equipment, facilities and utensils shall be constructed of impervious materials, so designed and fabricated as to

facilitate cleaning, so located or placed as to be readily accessible for cleaning, and shall be kept in good repair.

All surfaces that contact meat, meat byproducts or meat food products during processing shall be non-toxic, corrosion-resistant, smooth, free from breaks, open seams, cracks and chipped places, and shall be self-draining where practicable.

3.7.2 Overhead conveyors and other equipment shall be so constructed and maintained that grease, oil, or dirt from such equipment will not contaminate edible products.

3.7.3 Equipment such as pails, trays, belts, troughs, or stationary or moving-top tables shall be provided for the sanitary handling of meats, meat byproducts and meat food products.

3.7.4 Facilities shall be provided for washing dressed carcasses and meats. Such facilities or equipment shall be supplied with ample quantities of water under sufficient pressure to wash carcasses and meats thoroughly and efficiently.

3.8 Cleaning of Equipment, Facilities and Utensils

3.8.1 Equipment, facilities and utensils used for processing edible products shall be thoroughly cleaned at the end of each day's operations, and at such other times as may be necessary in order to prevent contamination of such products. Such cleaning shall remove grease and other soils, and shall leave no visible surface-film or deposit. Before being put into use, cleaned equipment shall be rinsed with a spray or flow of water. Cleaned

equipment and utensils shall be air-dried, unless stored in a protective solution or put into use immediately.

3.8.2 While in use, the cutting surfaces of knives, cleavers, saws and similar hand-operated instruments used in processing shall be maintained in a clean condition. When such an instrument becomes contaminated during use, it shall be immediately sanitized or it shall be laid aside for cleaning and a clean instrument substituted for use.

3.8.3 The surfaces of all equipment and utensils used in the preparation of edible products shall be thoroughly cleaned after each day's usage and at such other times during operations as may be required to prevent contamination of such products.

3.9 Storage of Clean Utensils, Portable Equipment and Packaging Materials

3.9.1 All utensils and portable equipment when cleaned shall be stored above the floor, in clean, dry locations and protected from splash, dust, and other contamination. Such utensils and equipment shall be air-dried before being stored, or shall be stored in a self-draining position on racks constructed of impervious, corrosion-resistant material. Such utensils may be placed in protective or other solutions if subsequently washed and rinsed before use.

3.9.2 Single-service containers and wrapping and packaging materials whose surfaces come into direct contact with edible products

shall be kept in the original cartons or packages, and shall be stored, until removed for use, in a clean, dry location protected from dust, splash, and other contamination.

3.9.3 Ice shovels, ice tongs, hoses, and nozzles shall be stored on hooks or racks in such a manner as to prevent contact with the floor and to protect them from contamination.

3.10 Refrigeration

3.10.1 Animal carcasses and primal parts thereof received at a meat processing establishment for processing shall have been cooled to an internal temperature of 40°F. unless the said products are processed immediately after slaughter and evisceration in the same establishment.

3.10.2 Temperatures and procedures which are necessary for cooling edible products shall be in accordance with good operating practices which insure the prompt removal of animal heat and externally applied heat and will preserve the condition and wholesomeness of the product.

3.10.3 Readily perishable meat, meat byproducts and meat food products processed in a meat processing establishment shall be cooled immediately after processing so that the internal temperature is reduced to 40°F. or less except that during further processing and packaging operations the internal temperature may rise to a maximum of 55°F. if immediately after packaging the product is placed under refrigeration at a temperature that will promptly

lower the product to 40°F. internal temperature or less.

- 3.10.4 Readily perishable meat, meat byproducts and meat food products that have been subject to a heat treatment shall, after such treatment, be placed under refrigeration at a temperature that will promptly lower the product to 40°F. internal temperature or less.
- 3.10.5 Readily perishable meat, meat byproducts and meat food products to be shipped from the plant in package form shall be maintained at 40°F. internal temperature or less.
- 3.10.6 Readily perishable meat, meat byproducts and meat food products which are to be held at a meat processing establishment in package form in excess of 24 hours shall be held in a room maintained at a temperature of 36°F. or less, with proper air circulation.

Regulation 4

Premises

- 4.1 Meat processing establishments, their environs and facilities shall be kept in a clean and neat condition, and shall be free from refuse, waste material, rodent infestation, insect breeding places, and other objectionable conditions.
- 4.2 To prevent harborage of rodents, loose lumber and other building or salvage material shall be stored in an orderly manner, at least 12 inches above the ground.
- 4.3 The premises shall be well-drained, and shall be so maintained that there are no pools of standing water.

Regulation 5

Cleanliness of Personnel

- 5.1 Personnel who handle edible products, processing equipment and utensils shall wear clean, washable garments, keep their hands clean and conform to hygienic practices during all periods of their employment.
- 5.2 Adequate lockers, or facilities in dressing rooms, shall be provided for the storage of employees' clothing. Such lockers and rooms shall be kept in a clean and orderly condition. Clothing shall not be stored in processing rooms.
- 5.3 Hampers shall be provided for temporary storage of soiled linens, coats, aprons, and other items of employee clothing. Soiled clothing and any personal items not used by employees in the performance of their duties shall not be placed on window ledges, on tops of lockers, or in similar location.

Regulation 6

Floors

- 6.1 All floors of meat processing establishments shall be kept clean and in good repair. Floors in rooms or areas where meats, meat byproducts and meat food products are processed or stored, and in all other rooms or areas where floors are not kept dry, shall be constructed of concrete or other equally impervious and easily-cleanable material and shall be smooth, graded to drain, and provided with adequate drains.

6.2 During operations, the floors in processing rooms and areas shall be kept reasonably free from processing wastes, including blood, scraps, grease, water, and dirt, and from litter. Where processing is conducted at short, irregular intervals, such processing wastes shall be removed from floors and properly disposed of immediately following each individual period of processing. Such floors shall be thoroughly cleaned at the end of each day's operation.

Regulation 7

Walls, Ceilings, Partitions and Posts

- 7.1 Walls, partitions, posts, ceilings, and exposed overhead structures of all rooms and areas in establishments shall be kept clean and in good repair.
- 7.2 Those sections of walls, partitions, posts, ceilings in processing rooms or areas and in refuse rooms which become soiled during the processing operations shall be thoroughly cleaned after each day's operations.
- 7.3 Walls, partitions, and posts in all rooms and areas where meat or meat products are processed or stored, where utensils are washed, in refuse rooms, and in all other rooms and areas where floors are not kept dry, shall be finished with smooth, washable, light-colored surfaces of concrete, cement-plaster, or other equally impervious and easily-cleanable materials: Provided, That light-colored surfaces shall not be required in cooler or freezer rooms.

- 7.4 Rooms or areas in which processing, cleaning, storing or daily sales are conducted shall be separate from toilet and dressing rooms and each other by interior walls extending from floor to ceiling. Such walls shall be free from openings except for necessary doorways equipped with doors, and necessary openings such as for conveyors or reach-through operations.
- 7.5 Ceilings and exposed overhead structures, in all rooms or areas where products are processed or stored, shall have washable, light-colored surfaces, with all joints sealed or tightly fitted.

Regulation 8

Doors, Windows and Openings

- 8.1 All outside doors, windows, and open skylights to processing and storage rooms shall be effectively protected against the entrance of insects and rodents.
- 8.2 Toilet-room doors, outside doors, and all doors leading in to rooms or areas where meat or meat products are processed shall be self-closing and tight-fitting.

Regulation 9

Preparation of Meat Products

- 9.1 All processes used in curing, pickling, rendering, canning or otherwise preparing any product in a meat processing establishment and all steps in the processes of manufacture shall be conducted carefully and with strict cleanliness in rooms or compartments separate from those used for inedible products.

- 9.2 The only animal casings that may be used as containers of product are those from cattle, sheep, swine, or goats.
- 9.3 Only those casings which have been carefully washed and thoroughly flushed with clean water immediately before stuffing shall be used; except that preflushed animal casings packed in salt and glycerine solution or other approved medium may be used without additional flushing provided they are found to be clean and otherwise acceptable and are thoroughly rinsed before use.
- 9.4 Beef rounds, beef bungs, beef middles, beef bladders, calf rounds, hog bungs, hog middles and hog stomachs which are used as containers of meat food product shall be inspected, turned with the fat surface exposed.
- 9.5 Portions of casings which show infestation with *Oesophagostomum* or other nodule-producing parasite and weasands infested with the larvae of *Hypoderma lineatum*, shall be rejected, except that when the infestation is slight and the nodules and larvae are removed, the casing or weasand may be used.
- 9.6 The fermenting of intestines shall not be permitted in a meat processing establishment. The stripping and sliming of intestines shall be performed in a clean manner.
- 9.7 Hog and sheep casings intended for use as containers of product may be treated by soaking in or applying thereto sound, fresh pineapple juice or a sound solution containing fresh pineapple

juice or papain or bromelin or pancreatic extract to permit the enzymes contained in these substances to act on the casings to make them less resistant. The casings shall be handled in a clean and sanitary manner throughout and the treatment shall be followed by washing and flushing the casings with water sufficiently to effectively remove the substance used and terminate the enzymatic action.

Regulation 10

Substances and Ingredients

- 10.1 All substances and ingredients used in the manufacture or preparation of any product shall be clean, sound, healthful, wholesome, and otherwise fit for food.
- 10.2 On account of the invariable presence of bone splinters, detached spinal cords shall not be used in the preparation of edible product other than for rendering where they constitute a suitable raw material.
- 10.3 Care shall be taken to remove bones and parts of bones from product which is intended for chopping.
- 10.4 Kidneys for use in the preparation of meat food product shall first be freely sectioned and then thoroughly soaked and washed. All detached kidneys, including beef kidneys detached with kidney fat, shall be examined before being used in or shipped from the establishment.

- 10.5 Testicles if handled as an edible product may be shipped from the establishment as such, but they shall not be used as an ingredient of a meat food product.
- 10.6 Heads for use in the preparation of meat food products shall be split and the bodies of the teeth, the turbinated and ethmoid bones, ear tubes, and horn butts removed, and the heads then thoroughly cleaned.
- 10.7 Cattle paunches and hog stomachs for use in the preparation of meat food products shall be thoroughly cleaned on all surfaces and parts immediately after being emptied of their contents, which shall follow promptly their removal from the carcasses.
- 10.8 Tonsils shall be removed and shall not be used as ingredients of meat food products.
- 10.9 Hog blood shall not be used as an ingredient of meat food product. No blood which comes in contact with the surface of the body of an animal or is otherwise contaminated shall be collected for food purposes. Only blood from animals the carcasses of which are inspected and passed may be used for meat food products. The defibrination of blood intended for food purposes shall not be performed with the hands.
- 10.10 No prohibited dye, chemical, preservative, or other substance shall be brought into or kept in a meat processing establishment for use as an ingredient of human food or animal feed.

- 10.11 Intestines shall not be used as ingredients of meat food products.
- 10.12 Clotted blood shall be removed from hog hearts before they are shipped from the establishment or used in the preparation of a meat food product.

Regulation 11

Approval of Substances for Use in The Preparation of Meat Food Products

- 11.1 No product shall contain any substance which impairs its wholesomeness or which is not approved by the Department.
- 11.2 There may be added to product with appropriate labeling common salt, approved sugars (sucrose (cane or beet sugar), maple sugar dextrose, invert sugar, honey, corn syrup solids, corn syrup and glucose syrup), wood smoke, vinegar, flavorings, spices, sodium nitrate, sodium nitrite, potassium nitrate, potassium nitrite, and other substances approved by the Department.
- 11.2.1 Other harmless synthetic flavorings may be added to products with the approval of the Department.
- 11.2.2 Coloring matter and dyes may be applied to products, mixed with rendered fat, applied to natural and artificial casings, and applied to such casings enclosing products, if approved by The Department. When any coloring matter or dye is applied to casings, there shall be no penetration of coloring into

the product. When any coloring matter or dye is added to meat fat shortening containing synthetic flavoring, the product shall be packed in conventional, round shortening containers having a capacity no greater than 3 pounds.

11.3 Monoglycerides and diglycerides may be added to rendered animal fat or a combination of such fat and vegetable fat with appropriate labeling.

11.4 With appropriate labeling the following antioxidants may be added, in the amounts indicated, to rendered animal fat or a combination of such fat and vegetable fat:

11.4.1 Resin guaiac not to exceed 1/10 of 1 percent; or

11.4.2 Nordihydroguaiaretic acid not to exceed 1/100 of 1 percent; or

11.4.3 Tocopherols not to exceed 3/100 of 1 percent. (A 30-percent concentration of tocopherols in vegetable oils shall be used when added as an antioxidant to products designated as "lard" or "rendered pork fat"); or

11.4.4 Lecithin: Provided, That nothing in this paragraph shall prevent the use of this substance as an emulsifier as approved by the Department; or

11.4.5 Butylated hydroxyanisole (a mixture of 2-tertiary butyl 4-hydroxyanisole) not to exceed 1/100 of 1 percent; or

11.4.6 Butylated hydroxytoluene (2,6 ditertiary butyl paracresol) (2,6 ditertiary butyl 4-methyl phenol) not to exceed 1/100 of 1 percent; or

- 11.4.7 Propyl gallate not to exceed 1/100 of 1 percent; or
- 11.4.8 Combinations of two or more of the antioxidants listed in subparagraphs (2), (5), (6) and (7) of this paragraph not to exceed 2/100 of 1 percent; or
- 11.4.9 Citric acid and/or phosphoric acid and/or monoisopropyl citrate not to exceed 1/100 of 1 percent, either alone or in combination with the antioxidants listed in subparagraphs (2), (5), (6), (7), or (8) of this paragraph.
- 11.5 To facilitate chopping and/or to dissolve the usual curing ingredients, water or ice may be used in the preparation of luncheon meat and meat loaf; however, the total amount of water used shall not exceed 3 percent of the ingredients going into the preparation of the product and its presence shall be declared as required.
- 11.6 Except as otherwise provided, sausage shall be prepared with meat, or meat and meat byproduct, seasoned with condimental proportions of condimental substances.
- 11.7 Under appropriate labeling as required, sausage may contain not more than 3½ percent, individually or collectively, of cereal, vegetable starch, starchy vegetable flour, soya flour, nonfat dry milk, or dried milk.
- 11.8 For the purpose of facilitating chopping and mixing, and under appropriate labeling, water or ice may be used in the preparation of sausage which is not cooked, in an amount not to exceed

3 percent of the total ingredients used. Sausage of the kind which is cooked, such as frankfurter, vienna, and bologna, may contain not more than 10 percent of added water or moisture.

- 11.9 Bicarbonate of soda, caustic soda, sodium carbonate, diatomaceous earth, fuller's earth, carbon, acetic acid, tannic acid, agents used exclusively as catalyzers such as nickel preparations, and such other substances as may be approved by the Department, may be used in the preparation of rendered fats: Provided, That they are not present in the finished product.
- 11.10 Caustic soda, sodium carbonate (soda ash or sal soda), trisodium phosphate, or sodium metasilicate, or a combination of these substances, or lime, or a combination of lime and sodium carbonate, and/or a solution of hydrogen peroxide, may be used in the preparation of tripe: Provided, That immediately following the treatment the tripe is thoroughly washed with clear water and the added substances are not present in the finished product.
- 11.11 The use of sodium nitrite, potassium nitrite, sodium nitrate or potassium nitrate, or combination of nitrite and nitrate, shall not result in the presence of more than 200 parts per million of nitrite in the finished product. Supplies of sodium nitrite and potassium nitrite and mixtures containing them must be kept securely under the care of a responsible employee of the establishment. The specific nitrite content of such supplies must

be known and shall be labeled accordingly. The maximum amounts of sodium nitrite and/or potassium nitrite which may be used are as follows:

- 11.11.1 2 pounds in 100 gallons of pickle.
- 11.11.2 1 ounce for each 100 pounds of meat in dry salt, dry cure, or box cure.
- 11.11.3 1/4 ounce in 100 pounds of chopped meat and/or meat byproducts.
- 11.12 Harmless synthetic flavoring may be added to products as approved by the Department and labeled "artificial flavoring".
- 11.13 Only coloring material and dyes from a batch that has been certified under the Federal Food, Drug and Cosmetic Act may be mixed with rendered fats, applied to animal and artificial casings, and applied to such casings enclosing product: Provided, That there is no penetration of the coloring matter or dye into the product. The presence of a visible ring of dyed product appearing around the periphery of the cut surface is evidence of penetration: Provided further, That when coloring matter or dyes are added to meat fat shortening containing artificial flavoring, the product shall be packed in conventional, round, shortening containers having a capacity no greater than 3 pounds.
- 11.14 For the purpose of preventing coagulation citric acid or sodium citrate with or without water, may be added to fresh beef blood in an amount not to exceed 2/10 of 1 percent of the total mixture. When water is used to make a solution of the citric acid or

sodium citrate added to the beef blood, not more than two parts of water to one part of citric acid or sodium citrate shall be used.

11.15 Harmless bacterial starters of the acidophilus type may be used in the preparation of such kinds of sausage as thuringer, lebanon bologna, cervelat, salami and pork roll in an amount not to exceed $\frac{1}{2}$ of 1 percent. When used, the harmless bacterial starter shall be included in the list of ingredients in the order of its predominance required.

11.16 Corn syrup solids, corn syrup, or glucose syrup shall not be used individually or collectively in an amount exceeding 2 percent (calculated on a dry basis) of all of the ingredients used in preparing such meat food products as sausage, hamburger, meat loaf, luncheon meat, chopped ham, or pressed ham.

11.17 Disodium phosphate, sodium hexametaphosphate, sodium tripolyphosphate, sodium pryophosphate, and sodium acid pryrophosphate, may be added to the pumping pickle for cured hams and pork shoulder picnics and may be used in the preparation of canned chopped ham, provided such use shall not result in more than $\frac{1}{2}$ of 1 percent of added phosphate in the finished product and provided that the maximum amount of such phosphate which may be so used is as follows:

11.17.1 Pumping pickle shall not contain more than 5 percent of such phosphate. When dissolved in pumping pickle, a small quantity

of a crystalline precipitate material may be formed. Such pickle shall be filtered or the precipitate allowed to settle so that only the clear solution is injected into product.

11.17.2 With appropriate declarations such phosphate may be used in the preparation of canned chopped ham in an amount not to exceed 8 ounces for each 100 pounds of the fresh uncured comminuted ham.

11.18 Ascorbic acid, erythorbic acid, sodium ascorbate, sodium erythorbate or a combination of one of these with citric acid or sodium citrate in which the citric acid or sodium citrate does not exceed 50 percent of the mixture may be used in the preparation of cured pork and beef products and cured comminuted meat food products as follows:

11.18.1 Pickle used for pumping, curing or packing pork or beef products shall not contain more than 75 ounces of ascorbic acid or erythorbic acid or a mixture of one of these with citric acid or sodium citrate, or 87.5 ounces of sodium ascorbate or sodium erythorbate or a mixture of one of these with citric acid or sodium citrate, to each 100 gallons of pickle.

11.18.2 With appropriate labeling, ascorbic acid, erythorbic acid, sodium ascorbate or sodium erythorbate or a combination of one of these with citric acid or sodium citrate may be used in the preparation of cooked, cured, comminuted meat food products in an amount not to exceed 3/4 ounce of ascorbic acid

or erythorbic acid or a mixture of one of these with citric acid or sodium citrate, or 7/8 ounce of sodium ascorbate or sodium erythorbate or a mixture of one of these with citric acid or sodium citrate, for each 100 pounds of fresh meat or meat byproduct. A solution containing not more than 10 percent ascorbic acid, erythorbic acid, sodium ascorbate or sodium erythorbate in water or brine may be applied to the outer surface of sliced and unsliced cured pork and beef product and cured comminuted meat food products prior to packaging. The use of such solutions shall not result in the addition of a significant amount of moisture to the product.

- 11.19 With appropriate labeling, not more than 3/1000 of 1 percent of butylated hydroxyanisole and 1/1000 of 1 percent of citric acid may be used in unsmoked dry sausage which is held during preparation in a drying room for purposes of trichinae treatment for the periods prescribed in these regulations.
- 11.20 With appropriate labeling, approved artificial smoke flavoring in an approved solvent or on an approved carrier may be used in the preparation of meat food products.
- 11.21 With appropriate labeling, approved smoke flavoring produced by the controlled burning of hardwood and absorption of the smoke in an approved solvent or on an approved carrier may be used in the preparation of meat food products.
- 11.22 With appropriate labeling, canned bacon may be treated with gamma radiation for purposes of preservation under the following conditions:

- 11.22.1 The radiation source shall consist of sealed units containing cesium 137 or cobalt 60.
- 11.22.2 The bacon shall be in cans coated with acceptable polymeric and/or resinous coatings and shall be under vacuum or in an inert atmosphere and the absorbed dose shall be 4.5 to 5.6 megarads.
- 11.22.3 A record of total dose shall be obtained by phantoms having the same geometry as the containers of bacon and containing dosimeters suitable for the maintenance of permanent records of exposure. Measurement of total dose shall be made by use of one phantom for each 24 hour period of operation or for each period that expires in processing 1,000 cans, whichever is the shorter period, with exposure records being made available for Department checking.

Regulation 12

Type of Product that Requires Treatment

- 12.1 Pork and pork products that require treatment to kill trichinae prior to preparation, processing, and sale to the ultimate consumer includes all pork and pork products which:
- 12.1.1 Appear cooked due to a partial heat treatment but not heated to a temperature of safety, or 137°F.
- 12.1.2 Appear cooked due to the smoking process or by the addition of dark colored spices, herbs, and flavorings, or;
- 12.1.3 Products that are normally eaten by the consumer as purchased, without further cooking, regardless of the fact that the product contains raw pork.
- 12.1.4 Products named in this paragraph, and products of the character thereof, containing pork muscle tissue (including hearts, pork stomachs and pork livers), or the pork muscle tissue which forms an ingredient of such products, shall be effectively heated, refrigerated, or cured to destroy any possible live trichinae: bologna; frankfurts; viennas; smoked sausage; knoblauch sausage; mortadella; all forms of summer or dried sausage, including mettwurst; ground meat mixtures containing pork and beef, veal, lamb, mutton or goat meat and prepared in such a manner that they might be eaten rare or without thorough cooking; flavored pork sausage such as those containing wine or similar flavoring materials; cured pork sausage; sausage containing cured and/or smoked pork; cooked loaves; roasted, baked, boiled, or cooked hams, pork shoulders, or pork shoulder picnics; Italian-style hams; Westphalia-style hams; smoked boneless pork shoulder butts;

cured meat rolls; capocollo (capicola, capacola); coppa; fresh or cured boneless pork shoulder butts, hams, loins, shoulders, shoulder picnics, and similar pork cuts, in casings or other containers in which ready-to-eat delicatessen articles are customarily enclosed (excepting Scotch-style hams); breaded pork products; cured boneless pork loins; boneless back bacon; smoked pork cuts such as hams, shoulders, loins and pork shoulder picnics (excepting smoked hams and smoked pork shoulder picnics which are specially prepared for distribution in tropical climates or smoked hams delivered to the Armed Services). Cured boneless pork loins shall be subjected to prescribed treatment for destruction of trichinae prior to being snipped from the establishment where cured.

Regulation 13

Treatment of Pork and Pork Products to Kill Trichinae.

13.1 The treatment shall consist of heating, freezing, curing as follows:

13.2 Heating - All parts of the pork muscle tissue shall be heated to a temperature not lower than 137°F., and the method used shall be one known to insure such a result. On account of differences in methods of heating and in weights of products undergoing treatment it is impracticable to specify details of procedures for all cases.

Procedures which insure the proper heating of all parts of the product shall be adopted. It is important that each piece of sausage, each ham, and other product treated by heating in water

be kept entirely submerged throughout the heating period; and that the largest pieces in a lot, the innermost links of bunched sausage or other massed articles, and pieces placed in the coolest part of a heating cabinet or compartment or vat be included in the temperature tests.

13.3 Freezing - At any stage of preparation and after preparatory chilling to a temperature of not above 40°F. on preparatory freezing, all parts of the muscle tissue or pork or product containing such tissue shall be subjected continuously to a temperature not higher than one of those specified in table 1, the duration of such refrigeration at the specified temperature being dependent on the thickness of the meat or inside dimensions of the container.

TABLE 1. - Required period of freezing at temperature indicated.

Temperature	Group 1	Group 2
°F.	Days	Days
5	20	30
-10	10	20
-20	6	12

Group 1 comprises product in separate pieces not exceeding 6 inches in thickness, or arranged on separate racks with the layers not exceeding 6 inches in depth, or stored in crates or boxes not exceeding 6 inches in depth, or stored as solidly frozen blocks not exceeding 6 inches in thickness.

Group 2 comprises product in pieces, layers, or within containers, the thickness of which exceeds 6 inches but not 27 inches, and product in containers including tierces, barrels, kegs, and cartons having a thickness not exceeding 27 inches.

The product undergoing such refrigeration or the containers thereof shall be so spaced while in the freezer as will insure a free circulation of air between the pieces of meat, layers, blocks, boxes, barrels, and tierces in order that the temperature of the meat throughout will be promptly reduced to not higher than 5°F., -10°F., or -20°F., as the case may be.

During the period of refrigeration the product or lot thereof must be kept separate from other products. Rooms or compartments equipped for being made secure with lock or seal should be provided. The rooms or compartments containing product undergoing freezing must be equipped with accurate thermometers placed at or above the highest level at which the product undergoing treatment is stored and away from refrigerating coils. After the prescribed freezing has been finished, the product must be kept under close supervision until it is prepared in finished form. Accurate dating of product and identity as to temperatures must accompany each frozen lot as follows:

"PORK PRODUCT _____ DEGREES F. _____ DAYS' REFRIGERATION".

13.4 Curing.

- 13.4.1 Sausage. Sausage may be stuffed in animal casings, hydrocellulose casings, or cloth bags. During any stage of treating the sausage for the destruction of live trichinae, except as provided in method 5, these coverings shall not be coated with paraffin or like substance, nor shall any sausage be washed during any prescribed period of drying. In the preparation of sausage, one of the following methods may be used:

Method No. 1. The meat shall be ground or chopped into pieces not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than 3 1/3 pounds of salt to each hundredweight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After being stuffed, sausage having a diameter not exceeding 3 1/2 inches, measured at the time of stuffing, shall be held in a drying room not less than 20 days at a temperature not lower than 45°F., except that in sausage of the variety known as pepperoni, if in casings not exceeding 1 3/8 inches in diameter measured at the time of stuffing, the period of drying may be reduced to 15 days. In no case, however, shall the sausage be released from the drying room in less than 25 days from the time the curing materials are added, except that sausage of the variety known as pepperoni, if in casings not exceeding the size specified, may be released at the expiration of 20 days from the time the curing materials are added. Sausage in casings exceeding 3 1/2 inches, but not exceeding 4 inches, in diameter at the time of stuffing, shall be held in a drying room not less than 35 days at a temperature not lower than 45°F., and in no case shall the sausage be released from the drying room in less than 40 days from the time the curing materials are added to the meat.

Method No. 2. The meat shall be ground or chopped into pieces not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than 3 1/3 pounds of salt to each hundredweight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After being stuffed, the

sausage having a diameter not exceeding 3 1/2 inches, measured at the time of stuffing, shall be smoked not less than 40 hours at a temperature not lower than 80°F., and finally held in a drying room not less than 10 days at a temperature not lower than 45°F. In no case, however, shall the sausage be released from the drying room in less than 18 days from the time the curing materials are added to the meat. Sausage exceeding 3 1/2 inches, but not exceeding 4 inches, in diameter at the time of stuffing, shall be held in a drying room, following smoking as above indicated, not less than 25 days at a temperature not lower than 45°F., and in no case shall the sausage be released from the drying room in less than 33 days from the time the curing materials are added to the meat.

Method No. 3. The meat shall be ground or chopped into pieces not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than 3 1/3 pounds of salt to each hundredweight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After admixture with the salt and other curing materials and before stuffing, the ground or chopped meat shall be held at a temperature not lower than 34°F. for not less than 36 hours. After being stuffed the sausage shall be held at a temperature not lower than 34°F. for an additional period of time sufficient to make a total of not less than 144 hours from the time the curing materials are added to the meat, or the sausage shall be held for the time specified in a pickle-curing medium of not less than 50° strength (salometer reading) at a temperature not lower than 44°F. Finally, the

sausage having a diameter not exceeding 3 1/2 inches, measured at the time of stuffing, shall be smoked for not less than 12 hours. The temperature of the smokehouse during this period at no time shall be lower than 90°F., and for 4 consecutive hours of this period the smokehouse shall be maintained at a temperature not lower than 128°F. Sausage exceeding 3 1/2 inches, but not exceeding 4 inches, in diameter at the time of stuffing shall be smoked, following the prescribed curing, for not less than 15 hours. The temperature of the smokehouse during the 15-hour period shall at no time be lower than 90°F., and for 7 consecutive hours of this period the smokehouse shall be maintained at a temperature not lower than 128°F. In regulating the temperature of the smokehouse for the treatment of sausage under this method, the temperature of 128°F. shall be attained gradually during a period of not less than 4 hours.

Method No. 4. The meat shall be ground or chopped into pieces not exceeding one-fourth of an inch in diameter. A dry-curing mixture containing not less than 2 1/2 pounds of salt to each hundredweight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After admixture with salt and other curing materials and before stuffing, the ground or chopped sausage shall be held as a compact mass, not more than 6 inches in depth, at a temperature not lower than 36°F. for not less than 10 days. At the termination of the holding period, the sausage shall be stuffed in casings or cloth bags not exceeding 3 1/2 inches in diameter, measured at the time of stuffing. After

being stuffed, the sausage shall be held in a drying room at a temperature not lower than 45°F. for the remainder of a 35-day period, measured from the time the curing materials are added to the meat. At any time after stuffing, if a concern deems it desirable, the product may be heated in a water bath for a period not to exceed 3 hours at a temperature not lower than 85°F., or subjected to smoking at a temperature not lower than 80°F., or the product may be both heated and smoked as specified. The time consumed in heating and smoking, however, shall be in addition to the 35-day holding period specified.

Method No. 5. The meat shall be ground or chopped into pieces not exceeding three-fourths of an inch in diameter. A dry-curing mixture containing not less than 3 1/3 pounds of salt to each hundredweight of the unstuffed sausage shall be thoroughly mixed with the ground or chopped meat. After being stuffed the sausage shall be held for not less than 65 days at a temperature not lower than 45°F. The coverings for sausage prepared according to this method may be coated at any stage of the preparation before or during the holding period with paraffin or other substance approved by the Department.

13.4.2 Capocollo (capicola, capacola). Boneless pork butts for capocollo shall be cured in a dry-curing mixture containing not less than 4 1/2 pounds of salt per hundredweight of meat for a period of not less than 25 days at a temperature not lower than 36°F. If the curing materials are applied to the butts by the process known as churning, a small quantity of pickle may be added.

During the curing period the butts may be overhauled according to any of the usual processes of overhauling including the addition of pickle or dry salt if desired. The butts shall not be subjected during or after curing to any treatment designed to remove salt from the meat, except that superficial washing may be allowed. After being stuffed, the product shall be smoked for a period of not less than 30 hours at a temperature not lower than 80°F., and shall finally be held in a drying room not less than 20 days at a temperature not lower than 45°F.

13.4.3 Coppa. Boneless pork butts for coppa shall be cured in a dry-curing mixture containing not less than 4 1/2 pounds of salt per hundredweight of meat for a period of not less than 18 days at a temperature not lower than 36°F. If the curing mixture is applied to the butts by the process known as churning, a small quantity of pickle may be added. During the curing period the butts may be overhauled according to any of the usual processes of overhauling, including the addition of pickle or dry salt if desired. The butts shall not be subjected during or after curing to any treatment designed to remove salt from the meat, except that superficial washing may be allowed. After being stuffed, the product shall be held in a drying room not less than 35 days at a temperature not lower than 45°F.

13.4.4 Hams. In the curing of hams either of the following methods may be used: Method No. 1. The hams shall be cured by a dry-salt curing process not less than 40 days at a temperature not lower than 36°F. The hams shall be laid down in salt, not less than 4 pounds to each hundredweight of hams, the salt being applied

in a thorough manner to the lean meat of each ham. When placed in cure the hams may be pumped with pickle if desired. At least once during the curing process the hams shall be overhauled and additional salt applied, if necessary, so that the lean meat of each ham is thoroughly covered. After removal from cure the hams may be soaked in water at a temperature not higher than 70°F. for not more than 15 hours, during which time the water may be changed once; but they shall not be subjected to any other treatment designed to remove salt from the meat, except that superficial washing may be allowed. The hams shall finally be dried or smoked not less than 10 days at a temperature not lower than 95°F.

Method No. 2 The hams shall be cured by a dry-salt curing process at a temperature not lower than 36°F. for a period of not less than 3 days for each pound of weight (green) of the individual hams. The time of cure of each lot of hams placed in cure should be calculated on a basis of the weight of the heaviest ham of the lot. Hams cured by this method, before they are placed in cure, shall be pumped with pickle solution of not less than 100° strength (salometer), about 4 ounces of the solution being injected into the shank and a like quantity along the flank side of the body bone (femur). The hams shall be laid down in salt, not less than 4 pounds of salt to each hundredweight of hams, the salt being applied in a thorough manner to the lean meat of each ham. At least once during the curing process the hams shall be overhauled and additional salt applied, if necessary, so that the lean meat of each ham is thoroughly covered. After removal from the cure

the hams may be soaked in water at a temperature not higher than 70°F. for not more than 4 hours, but shall not be subjected to any other treatment designed to remove salt from the meat, except that superficial washing may be allowed. The hams shall then be dried or smoked not less than 48 hours at a temperature not lower than 80°F., and finally shall be held in a drying room not less than 20 days at a temperature not lower than 45°F.

13.4.5 Boneless Pork Loins and Loin Ends. In lieu of heating or refrigerating to destroy trichinae in boneless loins, the loins shall be cured for a period of not less than 25 days at a temperature not lower than 36°F. by the use of one of the following methods:

Method No. 1. A dry-salt curing mixture containing not less than 5 pounds of salt to each hundredweight of meat.

Method No. 2. A pickle solution of not less than 80° strength (salometer) on the basis of not less than 60 pounds of pickle to each hundredweight of meat.

Method No. 3. A pickle solution added to the approved dry-salt cure provided the pickle solution is not less than 80° strength (salometer).

After removal from cure, the loins may be soaked in water for not more than 1 hour at a temperature not higher than 70°F. or washed under a spray but shall not be subjected, during or after the curing process, to any other treatment designed to remove salt.

Following curing, the loins shall be smoked for not less than 12 hours. The minimum temperature of the smokehouse during

this period at no time shall be lower than 100°F. and for 4 consecutive hours of this period the smokehouse shall be maintained at a temperature not lower than 125°F.

Finally the product shall be held in a drying room for a period of not less than 12 days at a temperature not lower than 45°F.

13.5 General Instructions. When necessary to comply with these regulations, the smokehouse, drying rooms, and other compartments used in the treatment of pork to destroy trichinae shall be suitably equipped by the establishment with an accurate automatic recording thermometer or some other suitable method of determining time and temperature relationship.

Regulation 14

Rendering, Tanking, Denaturing and Products Passed for Cooking

Separation of Edible From Inedible Products

14.1 All tanks and equipment used for rendering, preparing or storing inedible products shall be in rooms or compartments separate from those used for rendering, preparing or storing edible products. There shall be no connection between rooms or compartments containing inedible products and those containing edible products, except that there may be one connecting the doorway between the slaughtering or viscera separating department and the tank charging room of the inedible products rendering department. Only pipes and chutes meeting the requirements of the Department may be used to convey inedible and condemned material from the edible products departments to inedible products departments. In conveying to the inedible product tank carcasses of animals which have been condemned on ante-mortem inspection, they shall not be taken through rooms or compartments in which any edible product is prepared, handled or stored.

14.1.1 Under no circumstances shall the carcass of any animal which has died otherwise than by slaughter be brought into any room or compartment in which any edible product is prepared, handled or stored.

14.2 Suppression of Odors

14.2.1 Tanks, fertilizer driers and other equipment used in the preparation of inedible products shall be properly equipped with condensers and other appliances which will acceptably suppress odors incident to such preparation.

14.3 Method of Disposing of Parts by Tanking

14.3.1 Condemned carcasses and products at establishments having facilities for tanking shall be disposed of by tanking as follows: The lower opening of the tank shall first be sealed except when permanently connected with a blow line, then the condemned carcasses and products shall be placed in the tank after which the upper opening shall also be sealed securely and the contents of the tank are subjected to sufficient heating for sufficient time to destroy effectively the contents for food purposes.

14.4 Denaturing

14.4.1 Rendered fat derived in whole or in part from condemned products shall be so denatured, either with low-grade offal or approved mineral oil, as to destroy it effectually for food purposes. When low-grade offal is used as a denaturant the rendered fat shall be at least as dark in color as the Department color guide. When mineral oil is used as a denaturant the rendered fat shall contain not less than one part of mineral oil in each two hundred parts of the finished rendered product. Rendered inedible fat from products other than condemned will not be required to be denatured unless it possesses the physical characteristics of color, odor and taste of an edible product.

14.4.2 Any carcass or product condemned at an establishment which has no facilities for tanking shall be thoroughly slashed with a knife and denatured with crude carbolic acid under the supervision of an inspector. When a carcass or product is condemned because of anthrax, in the absence of tanking facilities, the

inspector shall at once notify the State Department of Health, the State Division of Animal Industry and the health officer; disposal of the carcass shall then be determined by the health officer.

14.4.3 Livers condemned because of parasitic infestations, nonmalignant changes, benign abscesses or contamination may be forwarded from the establishment for fish food, provided the livers are trimmed free of the abscess process within the establishment, after they have been thoroughly cooked by boiling and then slashed and denatured by dipping in a hot solution of methyl violet in five thousand parts of water or other approved dye. In lieu of the dye treatment such livers may be slashed and finely powdered dry charcoal may be applied, and then frozen at a temperature not higher than 10°F. for not less than forty-eight hours. Such freezing may be accomplished in a regular freezer in a separate receptacle and plainly marked "Not for Human Consumption".

14.5 Rendering Carcasses and Parts Into Lard, Etc., and Other Cooking

14.5.1 Carcasses and parts passed for cooking may be rendered into lard or rendered pork fat or rendered into tallow, provided, such rendering is done in the following manner:

14.5.2 When closed rendering equipment is used, the openings shall be sealed and the product heated to a temperature not lower than 170°F. for a period of not less than thirty minutes.

14.5.3 Open rendering in open kettles of products passed for cooking may only be performed during regular hours and until all parts have been heated to 170°F. for not less than thirty minutes.

14.6 Carcasses and Parts Passed For Cooking

- 14.6.1 Carcasses and parts passed for cooking may be used for the preparation of such products as canned meat, sausage, cooked or boiled meat, meat loaves and similar products; provided, all parts of such carcasses and parts which are so used are heated to a temperature not lower than 170°F. for a period of not less than thirty minutes, either before being used in or during the preparation of the finished product.
- 14.6.2 Products passed for cooking, if not handled and processed under the provisions of the regulations, shall be disposed of by tankage.

Regulation 15

Labeling of Meats, Meat Byproducts and Meat Food Products; Standards of Identity, and Content

- 15.1 All meat, meat byproducts and meat food products shall be labeled in accordance with Title 24 R.S.N.J. and the following specific requirements.
- 15.2 No statement, word, picture, design, or device which conveys any false impression or gives any false indication of origin or quality shall appear on any label. For example:
- 15.2.1 Terms having geographical significance with reference to a locality other than that in which the product is prepared may appear on the label only when qualified by the word "style," "type," or "brand," as the case may be, in the same size and style of lettering as in the geographical term, and accompanied with a prominent qualifying statement identifying the country, state, territory, or locality in which the product is prepared, using terms appropriate to effect the qualification. When the word "style" or "type" is used, there must be a recognized style or type of product identified with and peculiar to the locality represented by the geographical term and the product must possess the characteristics of such style or type, and the word "brand" shall not be used in such a way as to be false or deceptive:
- Provided, That a geographical term which has come into general usage as a trade name and which has been approved by the Department as being a generic term may be used without the qualifications provided for in this paragraph. The terms "frankfurter," "vienna," "bologna," "lebanon bologna," "braunschweiger,"

"thuringer," "genoa," "leona," "berliner," "Holstein," "goteborg," "milan," "polish," and their modifications as applied to sausages, the terms "brunswick" and "irish" as applied to stews, and the term "boston" as applied to pork shoulder butts, need not be accompanied with the word "style," "type," or "brand," or a statement identifying the locality in which the product is prepared.

15.2.2. Such terms as "farm," "country," and the like shall not be used on labels in connection with the products unless such products are actually prepared on the farm or in the country: Provided, That if the product is prepared in the same way as on the farm or in the country these terms, if qualified by the word "style" in the same size and style of lettering, may be used: Provided further, That the term "farm" may be used as part of a brand designation when qualified by the word "brand" in the same size and style of lettering, and followed with a statement identifying the locality in which the product is prepared. Sausage containing cereal shall not be labeled "farm style" or "country style", and lard not rendered in an open kettle shall not be designated as "farm style" or "country style".

15.3 Coverings shall not be of such color, design, or kind as to be misleading or deceptive with respect to color, quality, or kind of product to which they are applied. For example, transparent or semitransparent coverings for such articles as sliced bacon or pork sausage shall not bear lines or other designs of red or other color which give a false impression of leanness of the product.

- 15.4 The word "fresh" shall not be used on labels to designate product which contains any sodium nitrate, sodium nitrite, potassium nitrate, or potassium nitrite, or which has been salted for preservation.
- 15.5 The words, "spice", "spices", and "spiced", without qualification, shall not be used unless they refer to genuine natural spices.
- 15.6 As used on labels of meat or product, the term "gelatin" shall mean (a) the jelly prepared by cooking pork skins, tendons, or connective tissue from inspected and passed meat, and (b) dry commercial gelatin or the jelly resulting from its use.
- 15.7 Product (other than canned product) labeled with the term "loaf" as its name or part of its name shall be prepared in loaf form.
- 15.8 The term "baked" shall apply only to the product which has been cooked by the direct action of dry heat and for a sufficient time to permit the product to assume the characteristics of a baked article, such as the formation of a brown crust on the surface, rendering out of surface fat, and the caramelization of the sugar if applied. Baked loaves shall be heated to a temperature of at least 160°F. and baked pork cuts shall be heated to an internal temperature of at least 170°F.
- 15.9 When the product such as loaves is browned by dipping in hot edible oil or by a flame, its label shall state such fact, the words "Browned in Hot Cottonseed Oil" or "Browned by a Flame", as the case may be, appearing as part of the name of product.
- 15.10 The word "ham", without any prefix indicating the species of animal from which derived, shall be used on labels only in connection with pork hams. Ham shanks as such or ham shank meat as such or the trimmings accruing in the trimming and shaping of hams shall not be labeled "ham" or "ham meat" without

qualification. When used in connection with a chopped product the term "ham" or "ham meat" shall not include the skin.

- 15.11 The terms "shankless" and "hockless" shall apply only to hams and pork shoulders from which the shank or hock has been completely removed, thus eliminating the entire tibia and fibula, or radius and ulna, respectively, together with the overlying muscle, skin and other tissue.
- 15.12 When cereal, vegetable starch, starchy vegetable flour, soya flour, soya protein concentrate, dried milk, nonfat dry milk or calcium reduced dried skim milk is added to sausage within the limits prescribed there shall appear on the label in a prominent manner, contiguous to the name of the product the name of each such added ingredient, as, for example, "cereal added", "with cereal", "potato flour added", "cereal and potato flour added", "soya flour added", "soya protein concentrate added", "nonfat dry milk added", "calcium reduced dried skim milk added", or "cereal and nonfat dry milk added", as the case may be.
- 15.13 When any product is enclosed in a container along with a packing substance such as brine, vinegar, or agar jelly, a declaration of the packing substance shall be printed prominently on the label in connection with the name of product, as for example, "frankfurts packed in brine," "lamb tongue packed in vinegar," or "beef tongue packed in agar jelly," as the case may be. The statement of the quantity of contents shall represent the weight of the drained product when removed from the container to the exclusion of the packing substance. The packing substance shall

not be used in such a manner as will result in the container being so filled as to be misleading.

- 15.14 The term "lard" is applicable only to the fat rendered from fresh clean, sound, fatty tissues from the hogs in good health at the time of slaughter with or without lard stearin or hydrogenated lard. The tissues do not include bones, detached skin, head skin, ears, tails, organs, windpipes, large blood vessels, scrap fat, skimmings, settlings, pressings, and the like, and are reasonably free from muscle tissues and blood.
- 15.15 The term "leaf lard" is applicable only to lard prepared from fresh leaf fat.
- 15.16 The term "rendered pork fat" is applicable to the fat other than lard, rendered from clean, sound carcasses, parts of carcasses, or edible organs from hogs in good health at the time of slaughter, except that stomachs, bones from the head, and bones from cured or cooked pork are not included. The tissues rendered are usually fresh, but may be cured, cooked or otherwise prepared and may contain some meat food products. Rendered pork fat may be hardened by the use of lard stearin and/or hydrogenated lard and/or rendered pork fat stearin and/or hydrogenated rendered pork fat.
- 15.17 When lard or hardened lard is mixed with rendered pork fat or hardened rendered pork fat, the mixture shall be designated as "rendered pork fat" or "hardened pork fat" as the case may be.
- 15.18 Oil, stearin, or stock obtained from beef or mutton fats rendered at a temperature above 170°F. shall not be designated as "oleo oil", "oleo stearin", or "oleo stock", respectively.

- 15.19 When not more than 20 percent of beef fat, mutton fat, oleo stearin, vegetable stearin, or hardened vegetable fat is mixed with lard or with rendered pork fat, there shall appear on the label, contiguous to and in the same size and style of lettering as the name of product, the words "beef fat added", "mutton fat added", "oleo stearin added", "vegetable stearin added", or "hardened vegetable fat added", as the case may be.
- 15.20 The designation "vegetable fat" is applicable to vegetable oil, vegetable stearin, or a combination of such oil and stearin, whereas the designations "vegetable oil" and "vegetable stearin" shall be applicable only to the oil and the stearin, respectively.
- 15.21 No rendered edible animal fat or mixture of fats containing rendered edible animal fat shall contain added water, except that puff pastry shortening may contain not more than 10 percent of water, and oleomargarine may contain water within the limits prescribed.
- 15.22 Containers of edible rendered animal fats and mixtures of edible fats containing animal fats shall, before or immediately after filling, be legibly marked with the true name of the product. Shortening prepared with a mixture of meat fats and vegetable oils may be identified either as "Shortening Prepared with Meat Fats and Vegetable Oils" or "Shortening Prepared with Vegetable Oils and Meat Fats" without regard to the order of predominance of the fats and oils used, provided there is a significant amount of the lesser ingredient used.
- 15.23 Product labeled "Chili Con Carne" shall contain not less than 40 percent of meat computed on the weight of the fresh meat.

Head meat, cheek meat, and heart meat exclusive of the heart cap may be used to the extent of 25 percent of the meat ingredient under specific declaration on the label. The mixture may contain not more than 8 percent, individually or collectively, of cereal, vegetable starch, starchy vegetable flour, soya flour, soya protein concentrate, dried milk, nonfat dry milk, or calcium reduced dried skim milk.

- 15.24 Product labeled "Chili Con Carne With Beans" shall contain not less than 25% of meat computed on the weight of the fresh meat. Head meat, cheek meat, and heart meat exclusive of the heart cap may be used to the extent of 25% of the meat ingredient under specific declaration on the label.
- 15.25 Product labeled "hash" shall contain not less than 35 percent of meat computed on the weight of the cooked and trimmed meat. The weight of the cooked meat used in this calculation shall not exceed 70 percent of the weight of the uncooked fresh meat.
- 15.26 Products labeled as meat stews, for example, "beef stew", "lamb stew", and the like, shall contain not less than 25 percent of meat computed on the weight of the fresh meat.
- 15.27 Products labeled "Tamales" shall be prepared with at least 25 percent meat computed on the weight of the uncooked fresh meat in relation to all ingredients of the tamales. When tamales are packed in sauce or gravy, the name of the product shall include a prominent reference to the sauce or gravy, for example "Tamales With Sauce" or "Tamales With Gravy." Product labeled "Tamales With Sauce" or "Tamales With Gravy" shall contain not less than 20 percent meat, computed on the weight of

the uncooked fresh meat in relation to the total ingredients making up the tamales and sauce or the tamales and gravy.

- 15.28 Spaghetti with meat balls and sauce, spaghetti with meat and sauce, and similar product, shall contain not less than 12 percent of meat computed on the weight of the fresh meat. The presence of the sauce or gravy constituent shall be declared prominently on the label as part of the name of the product. Meat Balls may be prepared with not more than 12 percent, singly or collectively, of farinaceous material, soya flour, soya protein concentrate, nonfat dry milk, calcium reduced dried skim milk and similar substance.
- 15.29 Spaghetti sauce with meat shall contain not less than 6 percent of meat computed on the weight of the fresh meat.
- 15.30 Scrapple shall contain not less than 40 percent of meat and/or meat byproducts computed on the basis of the fresh weight, exclusive of bone. The meal or flour used may be derived from grain and/or soybeans.
- 15.31 Hamburger shall consist of chopped beef, ground beef or beef patties, with or without the addition of beef fat as such or of seasoning, and shall not contain more than 30% of fat by chemical analysis.
- 15.32 Ground meat, chopped meat, uncooked meat loaf, chopped meat patties or similar meat products, shall consist of either ground beef, ground veal, ground mutton, ground lamb, ground pork or any combination thereof, with or without the addition of fat or seasoning and shall not contain more than 30% of fat by chemical analysis. In every case in which any such product is sold in

other than package form, the product shall be accompanied by a placard or label placed on or adjacent to its immediate container declaring the common or usual name of the ingredients contained therein in the order of their predominance.

- 15.33 Liver sausage, liver loaf, liver paste, liver cheese, liver pudding, liver spread, and the like shall contain not less than 30% of liver computed on the weight of the fresh liver.
- 15.34 Product labeled "ham spread," "tongue spread," and the like, shall contain not less than 50 percent of the meat ingredient named computed on the weight of the fresh meat. Other meat and fat may be used to give the desired spreading consistency provided it does not detract from the character of the named spread.
- 15.35 Deviled ham may contain added ham fat: Provided, That the total fat content shall not exceed 35% of the finished product. The moisture content of deviled ham, deviled tongue and the like, shall not exceed that of the fresh unprocessed meat.
- 15.36 Pork sausage, country style sausage, breakfast sausage and farm style sausage shall consist of ground fresh pork, with or without the addition of condimental proportions of condimental seasonings, and shall not contain more than 55% of fat by chemical analysis.
- 15.37 All sausage to which cereal, vegetable starch, starchy vegetable flour, soya flour, dried milk or nonfat dried milk has been added shall not contain more than 3½% individually or collectively of such ingredients, and not more than 55% of fat by chemical analysis.

- 15.38 Cooked, cured or pickled pigs feet, pigs knuckles, and the like, shall be labeled to show that the bones remain in the product, if such is the case. The designation "semi-boneless" shall not be used if less than 50 percent of the total weight of bones has been removed.
- 15.39 Canned product labeled "Corned Beef" and canned product labeled "Roast Beef Parboiled and Steam Roasted" shall be prepared so that the weight of the finished product shall not exceed 70 percent by weight of the fresh beef, plus salt and flavoring material included in the product. Beef cheek meat and beef head meat from which the overlying glandular and connective tissues have been removed, and beef heart meat, exclusive of the heart cap may be used individually or collectively to the extent of 5 percent of the meat ingredient in the preparation of canned product labeled "Corned Beef" and canned product labeled "Roast Beef Parboiled and Steam Roasted". When beef cheek meat, beef head meat, and beef heart meat are used in the preparation of these products, their presence shall be reflected in the statement of ingredients as required by this part.
- 15.40 Canned product labeled "Tripe With Milk" shall be prepared so that the finished canned article, exclusive of the cooked-out juices and milk, will contain at least 65 percent tripe. The product shall be prepared with not less than 10 percent milk.
- 15.41 Product labeled "Beans with Frankfurters in Sauce," "Sauerkraut with Wieners and Juice," and the like shall contain not less than 20 percent frankfurters or wieners computed on the weight of the

smoked and cooked sausage prior to its inclusion with the beans or sauerkraut.

- 15.42 Product labeled "Lima Beans With Ham in Sauce," "Beans With Ham in Sauce," "Beans With Bacon in Sauce," and the like, shall contain not less than 12 percent ham or bacon computed on the weight of the smoked ham or bacon prior to its inclusion with the beans and sauce.
- 15.43 Product labeled "Chow Mein Vegetables With Meat" and "Chop Suey Vegetables With Meat" shall contain not less than 12 percent meat computed on the weight of the uncooked fresh meat prior to its inclusion with the other ingredients.
- 15.44 Products labeled "Pork With Barbecue Sauce" and "Beef With Barbecue Sauce" shall contain not less than 50 percent meat computed on the weight of the cooked and trimmed meat. The weight of the cooked meat used in this calculation shall not exceed 70 percent of the uncooked weight of the meat. If uncooked meat is used in formulating the products, they shall contain at least 72 percent meat computed on the weight of the fresh uncooked meat. When cereal, vegetable flour, nonfat dry milk, calcium reduced dried skim milk, or similar substances are used in preparing the product, such fact shall be prominently stated contiguous to the name of the product.
- 15.45 Labels for product which is in imitation of another food shall bear the word "imitation" immediately preceding the name of the food imitated and in the same size and style of lettering as in that name and immediately thereafter the word "ingredients" and the names of the ingredients arranged in the order of their predominance.

15.46 The weight of smoked products such as hams, pork shoulders, pork shoulder picnics, pork shoulder butts, beef tongues, and the like, except hams, pork shoulder picnics, and similar products prepared for canning shall not exceed the weight of the fresh uncured article. Hams, pork shoulders, pork shoulder picnics, pork shoulder butts, beef tongues, pork loins, and the like, except hams, pork shoulder picnics, and similar products prepared for canning which do not conform to such provisions because they contain added water not in excess of 10 percent of the weight of the fresh uncured products, shall in lieu of complying with the preceding sentence, bear on their labels the term "Water Added", immediately following the word "ham" or other product name, in prominent lettering not less than 3/8ths in height, and shall be so marked with the term "Water Added", except that the Department may approve smaller lettering for labels of small packages, such as 4-ounce packages of sliced ham, when he finds that the size and style of the lettering in connection with the product name are such as to ensure the prominence of the required term. The qualifying phrase "Up to 10%" or equivalent phrase may be used in labeling or marking such products in connection with the term "Water Added" at the option of the operator of the establishment, provided the qualifying phrase does not detract from the prominence of the term "Water Added." In marking products with strip labels or other approved devices, the required terminology shall be repeated in product, and the qualifying phrase "Up to 10%" or equivalent phrase may be applied at the ends of the strip label

or similar device and in small letters between the repeated term "Water Added."

- 15.47 "Beef with Gravy" and "Gravy with Beef" shall not be made with beef which, in the aggregate for each lot contains more than 30 percent trimmable fat, that is, fat which can be removed by thorough practical trimming and sorting.
- 15.48 The application of curing solution to beef briskets shall not result in an increase in the weight of the finished cured product of more than 20 percent over the weight of the fresh uncured briskets. The application of curing solution to other beef cuts, such as navels, clods, middle ribs, rumps, and the like, which are intended for bulk corned beef shall not result in an increase in the weight of the finished cured product of more than 10 percent over the weight of the fresh uncured meat. The application of curing solution to fresh beef tongue shall not result in an increase in the weight of the cured beef tongue of more than 10 percent over the weight of the fresh uncured beef tongue.
- 15.49 The preparation of cooked cured product such as hams, pork shoulders, pork shoulder picnics, pork shoulder butts, and pork loins, either by moist or dry heat, shall not result in the finished cooked article weighing more than the fresh uncured product.
- 15.50 Product labeled "Pressed Ham," and "Pressed Ham with Natural Juices", may contain finely chopped ham shank meat to the extent of 25 percent over that normally present in the boneless

ham. The weight of the cured chopped ham prior to processing shall not exceed the weight of the fresh uncured ham, exclusive of the bones and fat removed in the boning operations, plus the weight of the curing ingredients and 3 percent moisture.

- 15.51 When approved proteolytic enzymes are used on steaks or other meat cuts which are frozen or cooked within the official establishment where they are produced, there shall appear on the labels of the frozen or cooked cuts, contiguous to the name of the products, a prominent descriptive statement such as "Dipped in Solution of Papin," to indicate the use of such enzymes.
- 15.52 The preparation of a ham, pork shoulder picnic, or similar product for canning shall not result in an increase in weight of more than 8 percent over the weight of the fresh uncured article.
- 15.53 When an approved artificial smoke flavoring or an approved smoke flavoring is added to meat food products, there shall appear on the label, in a prominent manner, approved by the Department, contiguous to the product name, a statement such as "Artificial Smoke Flavoring Added" or "Smoke Flavoring Added", as may be applicable.
- 15.54 Oleomargarine or margarine includes all substances, mixtures, and compounds sold, offered for sale or labeled as oleomargarine or margarine and all substances, mixtures, and compounds which have a consistence similar to that of butter and which contain any edible oils or fats other than milk fat if made in imitation

or semblance of butter. Oleomargarine or margarine shall contain not less than 80% of fat.

- 15.55 Products labeled as meat pies, e.g., "Beef Pie," "Veal Pie," and "Pork Pie," shall contain not less than 25 percent of meat computed on the weight of the fresh uncooked meat in relation to all of the other ingredients including the crust.
- 15.56 When beef cheek meat (trimmed beef cheeks) is used in the preparation of hamburger, chopped beef, and fabricated beef steaks, the amount of such cheek meat shall be limited to 25 percent of the meat ingredient and its presence shall be declared on the label, either contiguous to the name of the product or in the ingredient statement.
- 15.57 Barbecued meats shall be cooked by the direct action of dry heat resulting from the burning of hard wood or the hot coals therefrom for a sufficient period of time to permit the product to assume the usual characteristics of a barbecued article which include the formation of a brown crust on the surface and the rendering of surface fat. The product may be basted with a sauce during the cooking process. The weight of the barbecued meat shall not exceed 70 percent of the weight of the fresh uncooked meat.
- 15.58 When methyl polysilicone is added as an antifoaming agent to rendered fats, its presence shall be declared on the label contiguous to the name of the product. Such declaration shall read "Methyl Polysilicone Added."
- 15.59 Cured, unsmoked, boneless pork shoulders, pork shoulder butts, or pieces of pork loin, in casings or similar packages of

consumer size, shall not contain more than 10 percent added substances as a result of the curing process.

- 15.60 Cheesefurters and similar products made in simulation of sausage in casings but containing sufficient cheese to give definite characteristics to the finished article may contain cereal, vegetable starch, starchy vegetable flour, soya flour, soya protein concentrate, nonfat dry milk, calcium reduced dried skim milk, or dried milk. The finished product shall contain no more than $3\frac{1}{2}$ percent of these additives, individually or collectively, exclusive of the cheese constituent. When any such additive is added to these products, there shall appear on the label in a prominent manner, contiguous to the name of the product, the name of each such added ingredient, as for example, "Cereal Added," "With Cereal," "Potato Flour Added," "Cereal and Potato Flour Added," "Soya Flour Added," "Nonfat Dry Milk Added," "Cereal and Nonfat Dry Milk Added," as the case may be.
- 15.61 When harmless synthetic flavoring is added to product for which it is approved by the Department, it shall be declared in the ingredient statement as "Artificial Flavoring."
- 15.62 The amount of batter and breading used as a coating for breaded product shall not exceed 30 percent of the weight of the finished breaded product.
- 15.63 "Cooked Salisbury Steak" shall be prepared with chopped beef and may contain not more than 25% pork and/or veal. It may also contain whole eggs and extender substances such as bread crumbs, cracker meal, cereal and nonfat dry milk. When extenders

are used, the label shall show a statement reflecting their use prominently displayed contiguous to the name of product, such as "Cooked Salisbury Steak Bread Crumbs Added".

- 15.64 The amount of batter and breading used as a coating for such products as "Breaded Ham Sticks", "Breaded Beef Sticks", "Breaded Beef Steaks", "Breaded Chopped Pork Steaks", "Breaded Veal Cutlets", "Breaded Chopped Veal Steaks" and the like shall not exceed 30% of the weight of the finished breaded product. When used the ingredients of the batter and breading shall be shown in the order used in an ingredient statement.
- 15.65 When a product is treated with ionizing radiation, a term approved by the Department such as "Processed by Ionizing Radiation" shall appear on the main display panel in conjunction with the designation of the product.

Regulation 16

Penalties

- 16.1 Any person who shall violate any provision of Title 24 R.S.N.J. or any rule or regulation of the State Department made pursuant thereto, or who shall refuse to comply with any lawful order or direction of the Department shall be liable to the following penalties, unless otherwise specifically provided:
- a. For each first offense a penalty of fifty dollars;
 - b. For each second offense a penalty of one hundred dollars;
 - c. For each third and every subsequent offense a penalty of two hundred dollars.