

CANADIAN

July/August 2012

# Meat Business

*The Beef, Pork & Poultry Industry Magazine*

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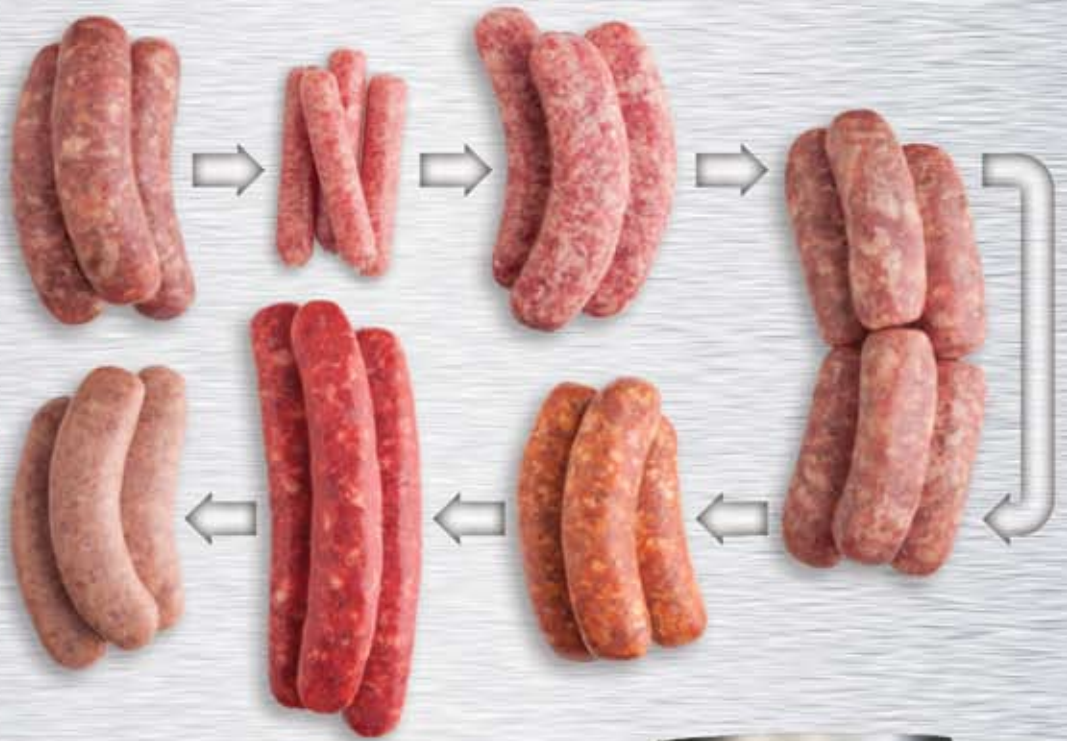
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# Horse Slaughter in Canada

**CANADA IS TRUSTED** as a world leader in the provision of safe and wholesome meat. Last year we exported \$1.3 billion of beef and \$3.2 billion of pork to over 150 different countries around the world. We also exported approximately \$83 million worth of horse meat to some very sophisticated and demanding overseas markets such as Japan, France, Switzerland, Belgium and Kazakhstan.

That's why it is most disturbing to see the recent unfounded allegations made by British Columbia's NDP MP Alex Atamanenko against horse slaughter in Canada.

On Oct. 5, 2011 he introduced a private member's bill into Parliament entitled C-322 an act to amend the Health of Animals Act and the Meat Inspection Act. The act would ban the import, export and interprovincial movement of live horses for slaughter for human consumption. It would also ban the import and export of horse meat for human consumption.

The bill's preamble states that horses are ordinarily kept as pets for sporting and recreational purposes. It then goes on to claim that horse meat products for human consumption are likely to contain prohibited substances. That is simply not true.

Mr. Atamanenko's campaign to ban horse slaughter alleges that Canada does not adequately monitor residues of phenylbutazone residues in horse meat and therefore, exposes humans to an unacceptable food safety risk. Phenylbutazone is a pain reliever and anti-inflammatory agent commonly used to treat lameness in horses.

The CFIA doesn't agree and has posted a fact sheet on horse meat on its website to counter the statements made by this member of Parliament. It states:

- The Agency has a monitoring program to randomly test meat based on international scientific standards as outlined by the United Nation's Food and Agriculture Organization and the World Health Organization. The testing is conducted at a frequency to detect trends in drug use violations.
- In addition to randomly sampling horse meat for chemical residues, the CFIA conducts targeted testing based on clinical observation of animals, before stunning and slaughter.
- Since 2002, the CFIA has been regularly testing horse meat for phenylbutazone. Results show a very high compliance rate for phenylbutazone residues. Canada's equipment and testing methods are among the most sensitive in the world and currently allow us to detect chemical residues in food at the level of parts per trillion.

Competent government authorities from Japan and Europe have audited and approved those Canadian horse slaughter facilities and the inspection and company food safety systems under which the horse meat is produced. They too monitor Canadian horse meat for residues. Canada would be quickly informed if any food safety issues were identified by these importing countries.

It's not just the \$83 million worth of horse meat exports that this MP's bill and recent communications put in question – but the credibility of the entire Canadian food inspection system. Canada's meat processing industry has annual sales of over \$21.3 billion and employs over 67,500 hardworking people here in Canada.

Given the choice, I'll put my faith in the Canadian Food Inspection Agency that values scientific rigour and professional and technical competence over a proposed law based on false information. **M**

*James Laws, P.Ag. is the executive director of the Canadian Meat Council.*



# Food Safety Culture and the Three Little Pigs

Just like with building a house, the third little pig knows best when it comes to the food production business.

*By Paul Medeiros*

**ONCE UPON A TIME** there were three little pigs who decided to venture out into the world to build food production facilities.

Pig No. 1 built his plant quickly and inexpensively. He had been in the food business for 20 years and had never made anybody sick, so he firmly believed he could run his facility safely and profitably without bothering to develop and implement a formal food safety program. Besides, he had historically been able to survive most government inspections relatively unscathed.

Pig No. 2 built his plant using a contractor with no food experience but who was inexpensive. He also realized begrudgingly that to keep his customers off his back he'd need to develop and implement a food safety system so he hired the cheapest consultant he could find who parachuted in a finished set of procedures and documents that he promptly placed on his office shelf.

Pig No. 3 built his plant using a reputable and recognized contractor and architect with food plant experience. He also included an experienced food safety consultant on the design/build team. Once completed, he invested in training himself and all his employees on food safety. Armed with a good understanding of food safety, he hired an eager and qualified food safety co-ordinator and working with the support of an outside food safety expert took the lead in developing and implementing a food safety system. The food safety co-ordinator made sure to both verify and validate its effectiveness. Pig No. 3 oversaw the entire development and implementation process and insisted on routine updates and reports on their key food safety metrics. He was an engaged piggy!

Sometime soon, Pig No. 1's plant was visited by a mean gang of pathogens – made up of the likes of salmonella, campylobacter and a host of others. They pounded on the

door to the plant, but Pig No. 1 didn't worry. He actually didn't even hear the pounding since his hearing had deteriorated due to his lack of hearing protection and the fact his machinery was so loud. He was shocked to look up from his desk to see the pathogen gang swarming all over the place and destroying his plant – and his future. He ran over to Pig No. 2's plant for a new job opportunity.



Pig No. 3 oversaw the entire development and implementation process and insisted on routine updates and reports on their key food safety metrics.

Pig No. 2 hired him on and felt smug in the safety of his plant because he had passed an audit eight months earlier. He tended to work very hard in the two to three weeks prior to the audit to make sure he could please the auditor and keep his customers from complaining too much. He figured that the hard work he had conducted eight months earlier would keep any gang of pathogens

from ruining him. He was wrong. The gang showed up and within short order, destroyed his plant too. He was shocked – and very upset. He blamed the auditor, the consultant, the government, his employees, and anybody else he could think of.

Pig No. 1 and Pig No. 2 eventually went over to Pig No. 3's plant and asked for work. Pig No. 3 ran a lean operation but business was expanding and he was grateful for the help. He told his brothers they'd need to attend training before they could work with him. They agreed and were amazed at the amount of useful information they learned. Pig No. 3 was always concerned about the pathogen gang so he stayed vigilant. Pig No. 3 drove his entire team to work together to protect themselves and their customers against the threat of the pathogen gang. The gang slithered to the door often but because every employee was trained to recognize the sound of their knock and had been given the authority to react, the pathogen gang never ever made it past the door.

The pathogen gang never tires however and to this day, they continue to attack Pig No. 3's plant. However they have yet to make it past the plant's robust food safety management systems. They change their tactics often but because the plant's system is always evolving and improving too, the pathogen gang has failed every time. **M**

*Paul Medeiros is the director of consulting services at Guelph Food Technology Centre ([www.gftc.ca](http://www.gftc.ca)). Under his leadership, GFTC consultants work with a variety of clients to meet their food safety and quality goals. Paul is responsible for the design, implementation, troubleshooting and training of food safety and quality systems. He can be reached at [pmedeiros@gftc.ca](mailto:pmedeiros@gftc.ca).*

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# New Beef Market Access

## Key countries open doors to Canadian beef

By Alan MacKenzie

CANADIAN BEEF producers have gained full market access to two key international markets in recent weeks.

On July 26, Agriculture Minister Gerry Ritz announced the government secured market access to Kazakhstan for boneless beef from animals over 30 months of age, in addition to the recently negotiated access for all beef from animals under 30 months. The government expects this new market access to be worth up to \$1 million annually for eligible exporters.

"We've enhanced our trading relationship with Kazakhstan by supplying world-class beef to a market of strategic importance, giving producers the opportunity to compete for sales in this country," Agriculture Minister Gerry Ritz stated in a release.

"We are pleased with the science-based decision of the Government of Kazakhstan to reopen its market to Canadian beef," added International Trade Minister Ed Fast.

The government secured the same beef access for Kazakhstan as it has with Russia. Canada is currently negotiating new import requirements with the regional Customs Union, which notably includes Russia and Kazakhstan.

Kazakhstan imported almost \$14 million worth of Canadian agricultural and agri-food products in 2011.

A week after the Kazakhstan notice, Ritz announced the United Arab Emirates (UAE) will now accept beef from animals over 30 months of age. The UAE is part of the Gulf Cooperation Council (GCC), a regional trading block which also includes Bahrain, Kuwait, Oman, Qatar and Saudi Arabia.

"The UAE is the first country in the Gulf Cooperation Council region to resume full access to our high-quality beef and this is a significant milestone for Canadian beef producers," Ritz stated. "We are hopeful that the

UAE's decision will encourage other countries in this region to grant full access to Canadian beef."

Canadian exports of beef from animals under 30 months of age to the UAE, Canada's 19th largest beef export market, was worth more than \$1 million in 2011, according to Agriculture and Agri-Food Canada. The industry estimates that full market access for beef could provide




"The UAE joins nearly 70 countries that have either fully or partially re-established access for Canadian beef since closing their borders in 2003."

— Canadian Cattlemen's Association president Martin Unrau

additional opportunities worth up to \$365,000 annually.

Canadian Cattlemen's Association president Martin Unrau also welcomed the announcement, applauding the efforts of Ritz and Fast.

"The UAE is the latest country to recognize the safety of Canadian beef and align its import requirements with the science-based standards of the World Animal Health Organisation (OIE)," he said. "The UAE joins nearly 70 countries that have either fully or partially re-established access for Canadian beef since closing their borders in 2003." 



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# Taking the Backache Out of Mixing and Marinating

How food processors are finding production efficiencies and saving time and money with automated mixing and marinating.

By Ed Sullivan

**PROCESSORS OF PREPARED** foods are continually challenged to meet higher product quality standards, they are often simultaneously confronted with other demanding issues, such as how to improve on production throughput, product consistency, and safety – all while containing capital investments.

One of the prevalent processes that can be a source of time-and-money-consuming inefficiencies in the production of prepared foods is mixing, blending and marinating. This applies to seasoned meats and poultry as well as fruits and vegetables, seafood, and mixed foods such as rice and vegetable dishes and many deli salads.

The traditional approach for many processors has been to use equipment containing blades or other mechanical agitators, or even a combination of machines, to mix or blend products. In some operations workers perform manual mixing with paddles. Either way, the process can be overly cumbersome, time-consuming and costly, particularly if marinating is involved.

Also problematic, those traditional mixing and blending methods can damage the finished product by crushing fruits and vegetables, bruising meats, and breaking pastas. Moreover, when multiple pieces of equipment are involved, the risk of poor hygienic standards is increased as well as the need to wash and sanitize more equipment.

Today's food processors, especially those who see the value of process integration, are beginning to focus on a more advanced mixing and blending technology as a way to save money, increase throughput and increase food quality. Such technology would give processors the ability to mix products quickly and hygienically, yet do so without causing product damage.

## An optimum mixing solution

Summer Fresh Salads of Woodbridge, Ont., a producer of flavorful, healthy and nutritious gourmet dips and appetizers, salads and chef-prepared foods, was looking for a more efficient and consistent way to mix and blend its line of deli salad dishes, such as pasta, rice and potato salads as well as its line of prepackaged gourmet products including



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Greek pasta salad and summer rotini salad.

"We wanted a system that would mix the salad ingredients quickly and efficiently, while also protecting ingredients such as pasta from bruising or other damage," explains Michael Leibold, senior director of operations.

The company had previously mixed its salad products "by hand," using time-consuming and costly manual labor with paddles. If not performed precisely, the paddles could crumple some delicate products, or possibly affect the consistency of products.

"We are a very quality-conscious company, so we researched automated systems that would ensure that product integrity would not be compromised, and that product throughput would increase," says Leibold.

The system that Summer Fresh Salads decided on is the GBT300 Buggy Mixer and Tumbler from CM Process Solutions of Corona, California, a supplier of food processing, washing and hygienic systems throughout North America.

The GBT300 is designed for tumbling, mixing and marinating a wide range of products, including meats, vegetables and salads in a 400-lb. stainless steel buggy. After being loaded with product ingredients and spices, each buggy is wheeled to the machine where it is lifted into a position that allows it to rotate in a tumbling fashion according to a pre-set recipe input by an operator at the control panel. A vacuum seal prevents any products from spilling out of the buggy.

"The product is very easy to use," Leibold says. "It will do a 100 per cent mix in as little as one minute, depending on the recipe – much faster than mixing manually, which is relatively time-consuming. The salads are mixed very evenly, and there is no bruising or deterioration of product integrity."

Mark Corser president and owner of CM Process Solutions notes, "Not only does it provide Summer Fresh Salads with a superior and better mix, it also contributes to employee health and safety with the reduced risk of back strain from an arduous manual task that comes with employees mixing by hand."

Although Summer Fresh Salads does not use the equipment for marinating, the same benefits are enjoyed by



"We wanted a system that would mix the salad ingredients quickly and efficiently, while also protecting ingredients such as pasta from bruising or other damage."

– Michael Leibold, senior director of operations

food processors that do. According to CM Process Solutions, many of their customers are mixing and marinating meat products within five minutes, cutting the time consumed by more than half. The optional vacuum system facilitates marinating at higher-than-normal speeds.

"We recently supplied the GBT300 to a leading pork processor who uses it to tumble and marinate products such

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as Peppercorn Tenderloins and barbecue loin fillets,” Corser says. “The results were outstanding, we were achieving an efficient tumble and marinate of products within minutes.”

### Integrating the solution

Another benefit of automating the mixing process into a single system is that it can be more easily integrated into the process line, including automated washing and sanitizing of the buggies used by the mixing system.

Hygiene mandates in food production facilities continue to be a critical focus of processors and regulators, so integration of automated washing and sanitizing equipment into the production stream can have a synergetic effect, saving additional time and money.

“CM Process Solutions is pretty famous for its line of washing and sanitizing equipment,” says Leibold. They have provided us with a hand and boot wash system, as well as several buggies and buggy lifters.”

The 400-lb. wheeled buggies that are used for mixing by Summer Fresh Salads are washed and sanitized automatically. Quick turnaround of clean buggies eliminates the need for added buggies while also saving considerable cleaning time and the labour associated with it.

“As far as the mixer is concerned, we’ve already bought a second one, and are waiting for it to be delivered,” says Leibold.



“The results were outstanding, we were achieving an efficient tumble and marinate of products within minutes.”

– Mark Corser, CM Process Solutions

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He adds that there is a human benefit to using this type of automation equipment. “Mixing by hand is difficult, ergonomically. Some workers would complain about upper back pain after mixing by hand all day long. Now the operator just pushes a button. Plus, one person can handle what six people would do when the task was performed manually.”

“The machine comes with many pluses, by mixing the product within the buggy, there is less handling; usually mixing is achieved in large paddle blenders where the recipe ingredients have to be loaded multiple times by column dumpers, and after mixing are discharged into another buggy,” Corser adds. “By using the GBT300 you are mixing the product within one buggy, which not only cuts down the mechanical handling but also the amount of containers that need to be washed and sanitized after the production process, thus saving on energy and water costs.” <sup>M</sup>

*Ed Sullivan is a technical writer who has researched and written about high technologies, food processing, healthcare, and finance for over 25 years.*



# Ractopamine Standards

Approved standards for additive expected to create opportunities for Canadian beef and pork industry.

**AT ITS 35TH SESSION** in Rome on July 7, the Codex Alimentarius Commission (CAC), a United Nations body that sets international food standards, guidelines, and codes of practice, officially adopted new global food safety standards for feed additive ractopamine hydrochloride.

The standard is expected to facilitate trade and create new export opportunities for Canadian beef and pork producers, Agriculture and Agri-Food Canada (AAFC) said, applauding the new ruling.

"This marks an important step forward for science-based trade, an approach this government has constantly advocated with trading partners around the globe," Agriculture Minister Gerry Ritz stated.

Ractopamine is a feed additive that is used by Canadian beef and pork producers. It directs nutrients from fat to lean protein, helping increase the yield of lean meat from pigs and cattle. It is a synthetic organic compound, not an antibiotic nor a steroid hormone, according to Elanco Animal Health, a company that manufactures the ingredient as Paylean for swine and Optaflexx for cattle.

"These standards provide an international food safety reference point that helps assure consumers that their food is safe. Codex standards for ractopamine are a significant step toward enabling sustainable meat production, fulfilling the increased demand for animal protein and therefore addressing worldwide hunger," stated Elanco president Jeff Simmons.

Health Canada approved its use after a thorough evaluation, including the completion of a human health risk assessment. The establishment of an international science-based standard on maximum residue limits (MRLs) for ractopamine will help provide clarity and greater trade predictability for Canadian producers, processors, and exporters, AAFC said.

"The Canadian Pork Council thanks the Government of Canada delegation to the Codex meetings for their leadership efforts in achieving this important science-based decision," added Canadian Pork Council chair Jean-Guy Vincent.

The decision on ractopamine is based on the scientific advice of the Joint FAO/WHO Expert Committee on Food Additives, the independent international expert scientific committee that performs risk assessments and provides advice to the CAC.

According to Elanco, the human safety of meat products derived from pigs and cattle fed ractopamine had been confirmed three times by the Joint FAO/WHO Expert Committee on Food Additives (JECFA) in 2004, 2006 and 2010 and by 27 regulatory

authorities from around the world.

The CAC was established by the Food and Agriculture Organization (FAO) of the United Nations and the World Health Organization (WHO) to develop harmonized



"This marks an important step forward for science-based trade, an approach this government has constantly advocated..."

— Agriculture Minister Gerry Ritz

international food standards, guidelines, and codes of practice to protect the health of the consumers and ensure fair food trade practices. **M**

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# Compliance to NFPA 70E and GFSI Standards

Selecting the proper personal protective equipment is a key step in protecting your employees, your processes and your products.

*By Jan Eudy*

**THE INDUSTRY STANDARDS** governing the food industry have been revised and/or will be revised in 2012. The 2012 version of NFPA 70E standard was released in August 2011. The IFS (International Food Standard), BRC (British Retail Consortium) standard and SQF (Safe Quality Food) 2000 standard recognized in North America by the Global Food Safety Initiative will also be revised in 2012.

The task of implementing and executing compliance of multiple divergent standards can be daunting. The implementation and execution of the Global Food Safety Initiative standards requires food industry operators to wear a garment system compatible with the food industry to prevent contamination of the products and processes during manufacturing. These garments must be precision laundered in a laundry that has implemented and maintains a HACCP based validated laundry process.

## What is NFPA 70E?

The 2012 version of the NFPA 70E standard that was issued on Aug. 31, 2011 addresses the electrical safety requirements for all employees who install, maintain or repair electrical systems. It recognizes the hazards associated with the use of electrical energy and includes guidelines to take precaution against injury or death. Specifically, compliance to NFPA 70E requires that all personnel working on electrical

equipment operating at or greater than 50 volts to wear arc-flash protective garments in order to prevent injury. Arc-flash is an electric current that passes through the air when the insulation between electrified conductors can no longer withstand the applied voltage. A flash can last less than a second, and its results can be severe and even lead to fatalities.

## Compliance to NFPA 70E 2012

Compliance to NFPA 70E in any company begins with a risk assessment of the hazards associated with the tasks employees perform. The 2012 standard lists the various tasks and assigns a Hazard/Risk Category (HRC) for each of these tasks. Within each HRC, there is a minimum arc rating required for the protective garments. The arc rating or arc thermal performance value (ATPV), measured in cal/cm<sup>2</sup>, represents the incident energy on a fabric or material that results in a sufficient heat transfer through the fabric or material to cause the onset of a second-degree burn.

After conducting the hazard risk assessment one must consider the following toward the final objective of properly protecting your employees:

- Selecting the proper personnel protective equipment (PPE)
- Caring for and repairing the PPE

## Selecting the proper PPE

Typical food processing garments constructed of arc-rated fabric can meet NFPA 70E HRC 2, provided the garments are 8 cal/cm<sup>2</sup> or higher. Heavy-duty leatherwork shoes provide some protection to the feet and must be used in all exposures greater than 4 cal/cm<sup>2</sup>. Additionally, construction features such as no pockets or buttons must be considered when selecting food processing arc-rated garments to comply with FDA food code 2-304.11 and the GFSI standards and minimize the risk of food contamination.

Employees may also wear disposable or reusable arc-rated hairnets, arc-rated face shields, safety glasses, voltage rated gloves and use tools to enhance compliance to NFPA 70E. In most circumstances, arc-rated balaclavas must be worn with the arc-rated face shield, or an arc-rated hood is permitted instead of the arc-rated balaclava and face shield. The arc-rated face shield must wrap-around to protect the face, chin, forehead, ears and neck areas. Research and development is ongoing to find compliant materials for food industry applications.

## Garment care


Next one must decide how to care and repair the PPE. The arc-rated fabric must be precision laundered using a validated laundry process to maintain the integrity of the arc-rated garments. Home laundering is not recommended. Wash chemical formulas must be validated to assure that soils and wash chemical residuals are removed thoroughly with adequate rinses. Chemical residuals of detergents and additives, such as fabric softeners, negate the effectiveness of the arc-rated fabrics. Additionally, food processing companies are concerned with the risk of cross-contamination from home laundering to the manufacturing facility and vice versa. The garments must be

inspected and repaired correctly with similar arc-rated fabrics to achieve sanitation and safety requirements of the food processing industry.

## Why NFPA 70E is important

Automation is prevalent in any industry including food processing. Constant preventive and corrective maintenance of automated systems create processing efficiencies and increase profits. However, to protect the employees maintaining and operating these automated systems, employers must assess the risk of potential arc-flash and establish the safe arc-flash boundaries in the production process. Training for all employees, and auditing for implementation and effectiveness, is a key element in compliance with all safety and food industry standards.

The final step to compliance is training employees on arc-flash protection and the appropriate use of the PPE based on all documentation of the food processing arc-rated garment system supporting the selection, care and repair of the PPE.

An integrated program of the safety of the food processing operators/electricians working around the equipment based on NFPA 70E requirements with the sanitation standard operating procedures based on the GFSI standards must be derived through the risk assessment. Once this program has been implemented, it must be constantly reviewed and maintained to the current industry standards. Compliance to the latest industry standards is the way to protect your employees, your processes, your products and ultimately your brand. 

*Jan Eudy, a corporate quality assurance manager for Cintas Corporation, is made available as a technical resource for Cintas Partners interfacing with customers in the food processing industry. She is knowledgeable in the GFSI, FDA and USDA requirements for implementation of effective HACCP programs and has spoken food processing seminars such as IDFA.*

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## Real-time fat/protein/moisture analysis for ground meat



Thermo Fisher Scientific's E scan in-line process analyzer is now available for ground meat applications.

The E scan analyzer provides real-time fat,

protein and moisture percentage information that gives meat processors a critical tool to accurately meet specifications.

Ground meat processing operations typically use time-consuming off-line analyzing methods that only check random samples. More recently, however, some have elected to use more expensive X-ray systems or near infrared (which only measures content at the product surface).

The E scan analyzer is based on guided microwave spectrometer (GMS) technology and is designed to offer faster, more accurate test results than what is currently available. The analyzer has no moving parts or optical sensors and continuously measures all of the ground meat coming through the pipeline. The GMS technology enables the E scan analyzer to "see through" the product, measure its constituents and provide immediate information about fat, protein, moisture and other content.

In addition to reducing raw material costs, the E scan analyzer can help meat processors prevent energy waste, improve productivity and help attain quality and consistency objectives.

The E scan analyzer is easy to calibrate, integrates seamlessly into the process without flow obstruction and eliminates the need for constant offline lab testing. It is easy to operate via a 15-inch touch screen, which also provides a continuous process graph over 30 minutes, 8- or 24-hours.

*thermoscientific.com*

## ZM Series indicators provide superior connectivity, durability and application versatility

The new ZM Series from Avery Weigh-Tronix combines unprecedented connectivity with superior durability to maximize industrial application flexibility. These sustainable, IP69K-rated indicators provide fast, accurate measurements, as well as analyze, store, display and transmit crucial weighing data to offer an adaptable weighing solution.

Available in two models, ZM301 and ZM303, and eight variants, the series provides an array of performance features and optimal flexibility. The ZM301 is a simple-to-operate, basic weight-reading indicator, with high-speed value capturing capabilities of up to 80 times per second. This model is also

equipped with six operational keys, including Zero, Print, Units, Tare, Select and F1, and offers built-in operational routines – enabling users to configure the device for individual weighing needs. The ZM303 can store multiple TAREs and IDs in its internal memory, providing easy retrieval for future use. The indicator also features a numeric keyboard, as well as clearly-displayed buttons, for common weighing requirements, such as counting, checkweighing and process control, allowing users to quickly switch between applications.

The ZM Series features multiple standard connectivity interfaces, with additional options to ensure seamless compatibility and communication with previous and new peripheral technologies. Standard options include Ethernet, USB ports and two RS232 serial interface ports, with analog output, USB device, current loop, RS485/RS42 and Wireless connections also available. Each model can also be remotely activated via push buttons or foot controls. These indicators are designed with universal usability, functionality and maintenance requirements—reducing the need for additional training.

*wtxweb.com*

## New case erector/loader cuts costs



The new Boxxer Case Erector Loader Sealer System combines case erecting and product loading into one fully automated system that significantly reduces labour costs. Fully enclosed and built

in a heavy duty welded tubular frame, the system can produce fully packaged cases at speeds up to 15 cases per minute and weighing up to 50 lbs.

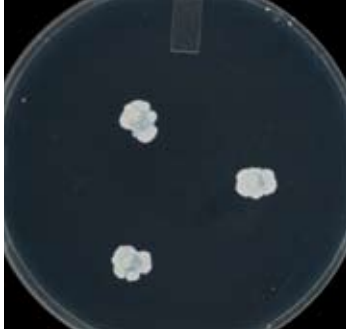
Designed in a compact footprint, the system can be built for tape or glue applications and features quick size changeover that can be done in minutes with no tools. All guarding is interlocked and includes alarms for low or no product and a low hopper alarm for the case blanks.

With a minimal distance between up-stacking of the product and case loading, stack integrity is assured. Servo drive ensures precision control of the entire system and is supplied with a PLC and colour touch screen that includes electronic troubleshooting to easily identify the source of alarms.

Available with an Omron or Allen Bradley PLC, the colour touch screen user interface provides easy adjustment of glue patterns and full access to all functions and timing of the system. Machines for glue applications are supplied with a Nordson ProBlue glue system.

*eaglepm.com*





# Partners Against Listeria

Government teams with researchers in listeria detection project.

**THE CANADIAN FOOD** Inspection Agency (CFIA), Genome Canada and Alberta Innovates Bio Solutions are partnering in a \$600,000 project that will help protect consumers from listeriosis.

The project aims to map the genome of listeria bacteria so that more rapid tests can be developed. Current test methods take at least five days. Genomic techniques could improve accuracy and cut testing time significantly, allowing the CFIA and industry to more effectively identify unsafe foods.

In general, listeria monocytogenes appears to be capable of survival regardless of freezing, dehydration and exposure to temperature regimes commonly used in the pasteurization of food. Given the seriousness of this bacterium as a food pathogen, its timely detection in food will help reduce the incidence of foodborne listeriosis, a release from Genome Canada said.

“Genomics research will bring a new level of advanced innovation and technology to food safety,” Genome Canada president and CEO Pierre Meulien stated. “We expect to provide the means to enable both the food industry and food regulators to respond swiftly to food safety investigations by identifying a potentially dangerous food contaminant as quickly as possible to prevent or limit the impact of an outbreak.”


The 18-month research project involves an investment of \$250,000 each from Genome Canada and the CFIA, and

\$100,000 from Alberta Innovates Bio Solutions. Through a request for applications, participants have until October to submit proposals for funding.



“Genomics research will bring a new level of advanced innovation and technology to food safety.”

– Pierre Meulien, Genome Canada

“While Canada and Alberta have an excellent reputation for food safety, we strive for continuous improvements through the application of science and innovation. We are pleased to support a program that will further our knowledge about listeria and enhance Canada’s reputation as a preferred supplier of safe food products,” added Stan Blade, CEO, Alberta Innovates Bio Solutions. 

- staff



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## Canadians willing to pay premium to eat local, survey says

A new study suggests that most Canadians try to buy local products when they shop for groceries and are willing to pay a premium to put local food on their kitchen tables. On average, Canadians are willing to pay 16 per cent more for domestic fruits and vegetables and 19 per cent more for Canadian meat products, the survey said.

Released on Aug. 4 as a tie-in to Food Day Canada celebrations, the new study by BMO Financial Group said Canadians are most likely to buy Canadian food products when grocery shopping for vegetables (91 per cent), fruit (86 per cent), poultry (84 per cent), cheese (81 per cent), and beef (78 per cent).

The top benefit cited for buying Canadian food when grocery shopping was supporting Canadian producers. Freshness, the environment and safety were also recognized as top benefits.

"BMO research suggests that Canadians are becoming increasingly loyal to the notion of buying local food, particularly fruits and vegetables, cheese, beef and poultry. Consumers appreciate the quality of food produced by local farm families and recognize the importance of supporting an agricultural sector that accounts for one in eight jobs in Canada," David Rinneard, BMO's national agriculture manager, stated in a release.

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## CFIA and CCA announce new national beef biosecurity standard

The Canadian Food Inspection Agency (CFIA) and the Canadian Cattlemen's Association (CCA) recently announced the release of a new a national biosecurity standard to strengthen Canada's beef sector.

According to a joint release from the CFIA and CCA, the standard outlines on-farm practices designed to minimize the introduction and control the spread of endemic, emerging and foreign infectious diseases in the Canadian herd.

"Canadian beef producers know that quality products come from healthy stock," stated Agriculture Minister Gerry Ritz. "Employing practices that contribute to the health of the industry and the animals on farm makes good sense."

"On-farm biosecurity is one of the front lines of prevention for managing the risk of animal diseases for cattle producers," added CCA president Martin Unrau. "This standard will provide the industry with a valuable tool to reduce the risk of disease entering cattle operations."

Many of the practices outlined in the standard are already in use on beef cattle operations throughout Canada. The standard is a tool that producers can use to measure their biosecurity practices on farm, the groups noted.

The standard is built on four basic principles:

- managing and minimizing the risks associated with animal movement;
- managing the movement of people, vehicles, equipment and tools;
- managing animal health practices, such as buying feed from reliable sources; and
- fostering employee knowledge and training on biosecurity practices and principles.

The standard was developed over two years, in consultation with producers, industry associations, academia, and provincial governments through funding provided by the Growing Forward policy initiative of Agriculture and Agri-Food Canada. It was designed specifically for the Canadian beef cattle industry, and is applicable to farm-level operations of all types and sizes.

For more information, visit [www.inspection.gc.ca](http://www.inspection.gc.ca).

## Government invests in food safety for chicken industry

The Government of Canada on July 25 announced an investment of up to \$72,500 to the Chicken Farmers of Canada (CFC). The group will use this investment to undergo an audit of its on-farm food safety system.

According to Agriculture and Agri-Food Canada, the investment will help ensure that the chicken industry follows top-notch safety procedures and practices.

The CFC will then proceed to the final stage of the Canadian Food Inspection Agency's On-Farm Food Safety Recognition Program. This national program follows the Hazard Analysis of Critical Control Points (HACCP) principles to make sure that potential food safety problems are caught before products leave the farm gate.

The CFC is working toward becoming the first organization to achieve full recognition by this program, and other organizations will be able to learn from the experiences of this pilot project.

"We are committed to food safety and growing the quality

Canadian chicken that consumers can trust,” stated Dave Janzen, CFC chair. “As a leader in on-farm food safety programming, Chicken Farmers of Canada is proud to be the first commodity to pilot the final steps of the recognition program and provide lessons learned for other commodities. We are committed to partnering with government so that that we remain responsive to the needs of the Canadian consumer.”

### New deputy minister of agriculture named

Prime Minister Stephen Harper on July 20 announced several changes in the senior ranks of the public service, including naming Suzanne Vinet as Deputy Minister of Agriculture and Agri-Food, effective Sept. 17.

Vinet, currently president of the Economic Development Agency of Canada for the Regions of Quebec, will take over the role from John Knuble, who will move on to become Deputy Minister of Industry.

Vinet entered public service in 1984 and has held several positions with Agriculture and Agri-Food Canada over the years, including roles as the department’s director general for international trade policy (1999-2002) and assistant deputy minister for strategic policy (2005-2007).

She also worked with the department of foreign affairs and international trade as director general for trade policy in international trade (2002-2005), and was associate deputy minister of health (2007-2009) and deputy minister for transport, infrastructure and communities (2009-2010).

### First shipment of Canadian lambs reach Vietnam

Agriculture Minister Gerry Ritz on July 9 announced that the first shipment of Canadian lambs successfully entered Vietnam. The first ever commercial sale of Canadian live ruminants to Vietnam, worth \$50 000, is paving the way for an expanded market, said Ritz.

In August 2011, the federal government secured new market access for its breeding cattle, sheep, and goats. The industry estimates the total market value for imports of live ruminants in Vietnam worth close to \$50 million, according to Agriculture and Agri-Food Canada.

“This is the first shipment of many, as Vietnam is a promising market, a strong trading partner, and a door to Southeast Asia for Canadian farmers,” Ritz stated in a release.

The minister congratulated OC Flock Management, a member of the Canadian Livestock Genetics Association (CLGA) from Bowden, Alberta, as the first Canadian company to ship lambs to Vietnam.

“CLGA would like to thank all of the people who have worked so hard to make this finally happen – our Government of Canada partners, member companies, and our colleagues in Vietnam,” added Rick McDonald, CLGA executive director. “We congratulate CLGA member OC Flock Management for securing this agreement with the Goat and Rabbit Research Centre. This first ever delivery of sheep strengthens the Canada-Vietnam partnership and signals the beginning of the next phase in the development of the nucleus herd project.”

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Bacon cooked in Unitherm Food Systems micro and mini spiral ovens. Cooking consistency is built into the spiral oven by design.

# Small Processors Spiralling to Success

A new range of mini spiral ovens is bridging the gap from small batch cookers to large spiral ovens used by major food processors.

By Ed Sullivan

**SMALL AND MEDIUM-SIZE** food processors with plans to move from batch to continuous are left with few options when it comes to new cookers. As a result, the go to strategy becomes adding more batch ovens without the benefit of better yields and consistency that major food processors obtain from large continuous cook lines.

Processors that get caught in the strategy of adding multiple batch cookers to meet increased demand also often simply run out of room.

As a result, many small to medium-sized food processors are now focusing on a new category of mini – and more recently micro-sized – spiral ovens as an affordable “bridge” from small batch cookers to large continuous cookers.

By way of example, U.S.-based ready meal manufacturers Simmering Soup, Garden Fresh Gourmet and B. Robert’s Foods have recently transitioned from batch to continuous cooking. International processors are also adopting the new technology, including Australia Jewel of India that specializes in Indian ready meals, Primo Moraitis and its roasted veggie products, and Moira Mac for a variety of fully cooked meats.

“A food processor that is expanding production will get to the point where they need to move to a continuous cook line. The mini spiral gives them that option sooner,” says Adam Cowherd, International Sales Manager of food processing equipment manufacturer Unitherm Food Systems, of Bristow, Oklahoma.

What is particularly appealing to small processors with these smaller spiral cookers is the consistency they can achieve. In the spiral cooker each product travels on a conveyor belt through the same exact cooking conditions.

On the other hand, batch cooked products are racked, which by its design makes controlling the final product difficult.

“The racks do not allow for an even cooking of all products in each batch,” explains Cowherd. “As a result, you see products on the top racks getting darker from overcooking, compared to products in the middle of the oven. This consistency problem detracts from product yield and quality, particularly when production is ramped up.”

## Flexibility

Smaller processors tend to prefer batch-style cookers because these ovens provide flexibility for a variety of products, which can change on a daily basis. At the same time, they may view continuous cooking as only for large volumes of a particular product.

But these small spirals are also extremely flexible. They can roast, steam, bake, broil or even pasteurize ready-meals. Examples of the products range from baked quiches, meatballs, and chicken wings, to oven-roasted vegetables and steamed chicken breast.

Advanced touch-screen controls on the mini and micro

spiral ovens allow processors to edit and store multiple recipes. It is not uncommon for small processors to have over 100 different recipes. Recipe selection is achieved through an easy to use interface that allows for quick adjustments and line changeovers.

### Spiral ovens – High volume in small package

The spiral oven, which offers important benefits such as minimal footprint, increased yield and consistent product, is the continuous cooking system of choice among many large food processors.



“A food processor that is expanding production will get to the point where they need to move to a continuous cook line. The mini spiral gives them that option sooner.”

– Adam Cowherd, Unitherm Food Systems

Cooking consistency is built into the spiral oven by design. As each product travels on the spiral belt through the oven, it is subjected to the exact same condition – the same temperature, the same airflow, the same humidity, and the same cook time.

“As a meat product cooks in the spiral oven, it bastes from


tier to tier. This basting improves yield and product quality. Each product has the potential to pick up juices that are falling from the tier above. The end result is better yield, appearance and quality that is very appealing to food processors,” explains Cowherd.

The introduction of smaller spiral ovens has placed the technology into the hands of small and mid-sized producers of ready-to-eat frozen and chilled foods market. Developed by Unitherm Food Systems approximately five years ago, the “mini” spiral was the smallest of its kind on the market. It has since been surpassed by the company’s release of a “micro” version, which has an even smaller footprint.

The micro spiral is nominally 5’ wide x 7’ long x 7’ tall and has over 60 linear feet of belt. A single micro spiral oven has the equivalent throughput of approximately three batch ovens. The company’s mini spiral oven is slightly larger at 8’ x 8’ x 8’ and has over 180 linear feet of belt with throughput of up to 1500 lbs. per hour.

These small spiral ovens are not scaled-back versions of the large spiral ovens used in mass production. They deliver all the same benefits of the larger continuous spirals, recipe selection and setpoint controls, only in a smaller footprint.

Cowherd adds that from a capital investment standpoint the micro and mini spiral ovens bridge the gap between the more expensive, and for small processors currently impractical, investment in large spiral ovens and relatively inexpensive batch ovens.

Not only are these new spirals attracting small processors, but large processors as well. The affordability and “scalability” of the micro spiral, for example, makes it an ideal R&D oven. 

*Ed Sullivan is a technical writer who has researched and written about high technologies, food processing, healthcare, and finance for over 25 years.*

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**BRITISH COLUMBIA**

**Province extends tax exemption list to include livestock genetics**

The Province of British Columbia recently announced plans to extend its farm tax exemptions to include livestock genetics operations.

The province said it will implement four panel recommendations for the 2013 Assessment Roll, including “more flexibility in meeting the requirements to maintain farm status by expanding the list of qualifying agricultural products.” This includes the addition of three new products:

- broad leaf maple and birch sap or syrup;
  - breeding products (i.e., livestock semen, ova and embryos produced as part of livestock raising);
  - horse stud services provided as part of horse rearing.
- Other recommendations include:
- increase the tax exemption limit on farm outbuilding improvements (excluding the residence);
  - extend farmer’s dwelling and home site farm classification to retired farmers in the Agricultural Land Reserve (ALR) for farms that stay in production;
  - reduce the administrative paperwork for farmers by changing the farm income reporting period to be consistent with each farmer’s Canada Revenue Agency income tax reporting period (i.e., a calendar or fiscal year).

**ALBERTA**

**Government invests in system to improve chick production**

Agriculture and Agri-Food Canada (AAFC) announced it will invest more than \$240,000 to the Alberta Hatching Egg Producers to help develop a precision broiler breeder feeding system that is expected to achieve improved flock uniformity and increased chick production.

According to an AAFC release, the investment will be used to help develop a system that provides the right amount of feed to the right bird at the right time, with the goal of keeping birds fit and reducing waste. The system is expected to improve production by taking the guesswork out of feed allocation, thereby potentially reducing labour and management inputs, while increasing environmental benefits through improved feed efficiency and a reduction in manure production.

The hatching egg producers house all their birds in free-run facilities, and this precision feeding technology will further enhance an already welfare-friendly environment for the birds, the release said.

“We are very excited to be working with the hatching egg industry on this innovative project,” stated Dr. Martin Zuidhof, project leader at the University of Alberta. “It is exciting to see over 20 years of research come together in a way that promises so much benefit for the poultry industry and the birds themselves. We are pleased with the investments of government and industry partners that are moving this worthwhile initiative forward.”

The government is making the investment through the five-year \$163 million Canadian Agricultural Adaptation Program (CAAP).

**MANITOBA**

**Province changes criteria for farm loans**

The Province of Manitoba in July announced changes the eligibility criteria for credit services available through the Manitoba Agricultural Services Corporation (MASC).

Through the changes, more producers can access loans and the funding they need to manage their farming operations, Agriculture, Food and Rural Initiatives Minister Ron Kostyshyn announced in a release.

“These new measures are the result of our strategic planning consultations with producers and producer groups,” stated Kostyshyn. “By removing a number of the eligibility restrictions and increasing the maximum loan amount, MASC will improve its service to Manitoba farmers. The changes will help more farmers access long-term, fixed-rate financing and initiatives for young farmers that MASC currently offers.”

As part of its overall plan to expand its services, MASC introduced several changes in its lending policy:

- the limits on net worth and off-farm income have been eliminated;
- the maximum loan limit has been increased to \$2 million for all applicants, up from \$900,000 for individuals and \$1.8 million for corporations and partnerships;

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- financing of new or used farm equipment has been made eligible for loans; and
- the maximum loan limit for on-farm housing has been eliminated.

Removing the eligibility restrictions means all farmers will be treated equitably and young farmers will have greater access to the credit necessary to buy into or take over the family farm, said Kostyshyn, adding higher loan limits will provide more support for higher-cost operations such as dairy and poultry farms, and respond to the rising cost of land for all operations.

“These changes respond to advances in the agriculture industry and the evolving needs of today’s producers, many of whom are younger with ambitions to expand and grow their operations,” said Kostyshyn.

For more information, visit [www.masc.mb.ca](http://www.masc.mb.ca).

**ONTARIO**

**OIMP searching for “Ultimate Burger”**

The Ontario Independent Meat Processors (OIMP) has launched a call for entries for its 2012 Ontario Finest Meat Competition. “The Search for the Ultimate Burger” is a quest to find Ontario’s finest burgers in six protein categories – veal, turkey, beef, chicken, lamb and pork. Winners will be crowned at the OIMP annual conference in November.

“Holding a fresh meat competition allows our members who don’t produce the further processed products as seen in previous competitions, to be able showcase their

products and enjoy the potential bragging rights and promotion that comes along with producing an award-winning product,” OIMP executive director Laurie Nicol said in a release. “It also builds that value chain relationship, as demonstrated by our competition supporters, Ontario Cattlemen’s Association, Turkey Farmers of Ontario, and Ontario Veal Association.”

Entries can be fresh or frozen, but must be a ground product, use only Ontario protein, and be processed in Ontario by an OIMP member. In the first round of judging, the six proteins will compete amongst themselves, as separated into fresh or frozen, to determine winners in each meat category. In the final round, the proteins will compete against each other, in both a “fresh” and “frozen” competition, with one winner from each rising to the top to be crowned “The Ultimate Burger.”

Fresh burgers will be judged on consumer appeal, taste and texture with the winners being promoted to consumers through traditional and social media networks. Frozen burgers are being judged on yield, taste and texture and winners will be promoted to foodservice operators and distributors.

Top industry talent as judges have been confirmed for the prestigious event to be held in October, including three returning judges: professional home economist and TV personality Emily Richards; Sun Media’s national food editor Rita DeMontis; and Annabelle Waugh, food director with Canadian Living.

OIMP also welcomes chefs John Placko and Ted Reader as first-time judges.

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## AMI Foundation offers listeria workshop in September

The AMI Foundation is offering an educational workshop this September that will address one of the most relevant issues in the meat and poultry industry today: listeria monocytogenes control.

The AMI Foundation Advanced Listeria monocytogenes Intervention and Control Workshop, co-sponsored by the Canadian Meat Council (CMC), will be held Sept. 24 to 25, at the Hyatt Regency Chicago in Chicago, Illinois.

Every day, ready-to-eat (RTE) manufacturers face the challenge of controlling listeria monocytogenes in order to produce a safe, nutritious product. The AMI Foundation has worked with experts across the industry to develop a learning experience tailored to meet those challenges.

The event will feature presentations on the latest developments in listeria control and real-life examples from people with plant experience, as well as hands-on breakout sessions and case studies designed to give you firsthand knowledge to use in your plant. In addition to assuring optimal product safety and implementing best practices for RTE process, the workshop offers a key benefit: helping to assure compliance.

Scheduled session topics include an introduction to listeriosis process control technology and principles; challenges of facility design; sanitary equipment design principles; understanding product risk and appropriate intervention; monitoring for process control; data analysis; process data management tools; investigation and corrective actions; and lot and line segregation. The workshop will also feature a number of case studies.

For more information and to register, visit [www.meatami.com/lmworkshop](http://www.meatami.com/lmworkshop).

## New president named at IAFP 2012

The International Association for Food Protection (IAFP), a non-profit educational association of food protection professionals, recently announced its new president and executive board.

Dr. Katherine M.J. Swanson of Saint Paul, Minnesota, assumed the presidency at the conclusion of IAFP 2012, the organization's annual meeting, in Providence, Rhode Island. Swanson is the vice president of Food Safety for Ecolab Inc., where she identifies control strategies for emerging food safety concerns and assists customers with high level food safety issues.

Prior to joining Ecolab in 2004, Swanson was director of global product safety at General Mills, responsible for

microbiology, thermal process, toxicology, food allergen, and non-food premium support worldwide. Previously, she was director of microbiology and food safety for the Pillsbury Company, where she restaged their world-class HACCP program to meet regulatory requirements worldwide. Prior to joining Pillsbury, Dr. Swanson was a Senior Microbiologist at 3M and an assistant professor of Food Microbiology at Cornell University.

Other members of the IAFP's executive board include:

- President-elect, Don Schaffner, Ph.D., Rutgers University, New Brunswick, New Jersey;
- Vice-president, Don Zink, Ph.D., U.S. FDA, College Park, Maryland;
- Secretary, Alejandro Mazzotta, Ph.D., Campbell Soup Company, Camden, New Jersey;
- Past president, Isabel Walls, Ph.D.;
- Affiliate council chairperson, Tori Stivers, University of Georgia, Peachtree City, Georgia.

IAFP 2013 will be held July 28 to 31 at the Charlotte Convention Center in Charlotte, North Carolina.

## Grandin to speak at Hall of Fame induction

The Meat Industry Hall of Fame has announced Dr. Temple Grandin will deliver the keynote presentation at its annual induction ceremony and dinner. Held in conjunction with the North American Meat Association's Outlook Conference, the event will take place on Oct. 27 at the JW Marriott Hill Country, San Antonio, Texas.

Grandin, a professor of Animal Science at Colorado State University, is a leading designer of livestock handling facilities. Almost half of cattle in North America are handled in a center track restrainer system that she designed. She has developed an objective scoring system for assessing handling of cattle and pigs at meat plants, used by many large corporations to improve animal welfare. She is also a leading authority on cattle temperament, environmental enrichment for pigs, and effective stunning methods for cattle and pigs at meat plants.

Grandin, named one of Time magazine's 100 most influential people in the world in 2012, was the focus of an HBO film starring Claire Danes as Grandin. The movie was nominated for 15 Emmys and received five awards, including Outstanding Made for Television Movie and Best Actress in a Drama.

Grandin was an inaugural inductee into the Meat Industry Hall of Fame in 2010.

For more information, visit [www.meatindustryhalloffame.org](http://www.meatindustryhalloffame.org).



# Upcoming Events

## September 2012

9 – 10

Alberta Foodservice Expo  
Edmonton Expo Centre  
Edmonton, Alta.  
albertafoodserviceexpo.ca

20 – 21

Canada Beef Inc. Annual  
Forum  
Calgary, Alta.  
canadabeef.ca

24 – 25

AMI Foundation Advanced  
Listeria Monocytogenes  
Intervention and Control

Workshop

Hyatt Regency Chicago  
Chicago, Illinois  
meatami.com

## October 2012

2 – 3

NAMA E. Coli Conference  
Sheraton Four Points at O'Hare  
Chicago, Illinois  
meatassociation.com

11 – 12

Food Safety Supply Chain  
Management Conference  
Philadelphia, Pennsylvania  
foodsafetytech.com

23 – 24

3rd Annual Food Regulatory &  
Quality Assurance Summit  
Holiday Inn, Airport  
Toronto, Ont.  
foodregulationcanada.com

24 – 27

NAMA Outlook Conference  
J.W. Marriott Hill Country  
San Antonio, Texas  
meatassociation.com

28 – 31

Pack Expo 2012  
McCormick Place  
Chicago, Illinois  
packexpo.com



*TheFoodNewz* is an on line events calendar created by Debra Bradshaw of Zep Food & Beverage Division. To find out more about the events listed in this magazine visit [thefoodnewz.com](http://thefoodnewz.com). If you know of events not listed please email Debra directly at [zeprep@rogers.com](mailto:zeprep@rogers.com).



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Thermo Fisher's EZx 465 Touchless X-ray system eliminates shielding curtains by conveying the product through the inspection chamber via a series of small slopes.

# Case-Ready at PACK EXPO 2012

Innovations at international trade show to help meet retailer demand for case-ready meat and poultry.

**NOT LONG AGO**, nearly every grocery store employed a butcher. Today, the retail landscape is changing, and at the heart of this change are advancements in case-ready products distributed by meat and poultry packers.

At U.S.-based private-label retailer Trader Joe's for example, refrigerated cases are full of packages of everything from marinated chicken breasts to grill-ready beef and vegetable skewers.

In fact, the Freedonia Group, a market analyst group, predicts overall demand for meat, poultry and seafood packaging will grow by three per cent annually through 2015. Flexible packaging will continue to outpace rigid types, bolstered by good opportunities for high-barrier film and pouches. Added-value features that preserve quality and promote ease of opening will also, along with consumer demand, contribute to growth.

Meat and poultry packers will be able to explore all types of technologies that contribute to the production and distribution of case-ready products at PACK EXPO International 2012, which will take place Oct. 28 to 31 at McCormick Place, in Chicago. This includes everything from pumping and conveying product to packing and labelling it. The following examples are just a glimpse of what to expect in Chicago this fall.

## Behind-the-scenes efficiency improvements

One trend meat and poultry processors are experiencing is the need for higher throughput.

"Processors are being challenged to get more product out of existing equipment," says Sam Raimond, applications engineering supervisor with Fristam Pumps USA (Middleton, Wisconsin; Booth #7430). "When throughput is increased, system pressure increases. As a result, process pumps need to have higher pressure capabilities."

To address this, Fristam's FKL series positive displacement pump is designed to be exceptionally robust and is manufactured of 316L stainless steel.

"Its heavy-duty construction, which includes large shafts and balanced rotors, allows it to withstand differential pressures up to 500 psi," he says.

"Another current trend is the need to pump highly viscous products, such as mechanically deboned meat," Raimond adds. "To meet this demand, the FKL is offered with vertically mounted, large rectangular inlets. These large rectangular inlets are much less restricted than standard fittings and allow viscous product to enter the pump even when low amounts of inlet pressure are available."

With the steady increase in meat and poultry processing volumes, there has been a corresponding increase in concentrations of wastewater pollutants. Poultry processing in particular uses a relatively large amount of water.

Processing one five-pound, average-size broiler chicken, for example, requires five to 10 gallons of water — and turkey processors use considerably more.

“This water is laden with proteins, fats and carbohydrates from meat, fat, blood, skin and feathers,” says Steve Hughes, CEO of Lyco Manufacturing Inc. (Columbus, Wisconsin; Booth #7336). “The water is also polluted with a fair amount of grit and other inorganic matter.

“Poultry processors are required to remove the majority of the soluble and particulate organic material in their wastewater prior to discharge from the plant in order to achieve compliance with local, state and federal environmental regulations,” says Hughes. “The problem is that few screening systems are really capable of continuously cleaning out all of this material to a level within the standards of municipalities. Further, the vast majority of these are single-screen applications.”

With the advent of double-screen technology, processors can capitalize on a much more efficient and cost-effective system for their wastewater treatment.

“Lyco’s Double Drum screen uses rotary action to separate waste solids from liquids in one step, eliminating the need for two sequential, single-stage screens,” notes Hughes. “Primary screening takes place when the wastewater enters the inner drum from the inside and screens out solids longer than 0.08 inches. Secondary screening follows as the wastewater passes through the outer drum, screening particles as small as 0.02 inches. The net result is that more solids are screened out of the wastewater.”

Harsh elements such as meat byproducts, fat, grease and oil can also make their way onto surfaces inside processing plants, creating a slippery work environment and a safety hazard for employees.

“SlipNOT products can assist with employee safety as well as proper sanitation,” says Sarah Johnson, marketing assistant of SlipNOT Metal Safety Flooring (Detroit, Michigan; Booth #108). “Our stainless steel flooring products are chemical and corrosion resistant, providing a sanitary and slip-resistant surface.”

Applications include platforms, crossovers, stair treads, catwalks, mezzanines, drain covers, ladder rungs/covers, flooring and countless others.

“Easily cleaned by power washing and a stiff bristle brush, SlipNOT products increase productivity in high-speed meat processing facilities, poultry plants and many other types of food processing facilities.”

*(Continued on page 28)*

## Where there's smoke, there's Zesti.

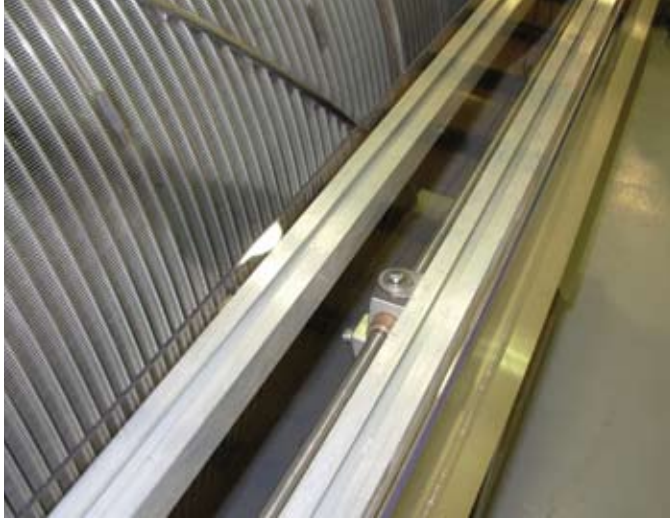


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Lyco's Double Drum screen uses rotary action to separate waste solids from liquids in one step.

To help meat and poultry packagers comply with the Food Safety Modernization Act regulations, Triangle Package Machinery Co. (Chicago, Illinois; Booth #713) designs its X-Series VFFS Baggers, including the forming tube, to meet USDA and 3A sanitation standards.

"This cleaner design is a result of a collaborative effort with our customers, as well as regulators," says Bob Williams, vice president of sales and marketing at Triangle. "By focusing on USDA and 3A requirements, we designed critical control points out of the machine and were able to incorporate many sanitary features for a cleaner machine design."

These features include a continuously welded, electro-polished frame, stainless steel and dye-filled film rollers and food-grade/wash-down servo motors.

"We have also eliminated the use of wire ties," says Williams.

### This protein is clear of foreign objects

Meat and poultry processing creates many byproducts, particularly bone fragments, which have the potential to remain with the product during further processing and packing.

Unlike traditional foreign object X-ray detection systems, the new Thermo Scientific EZx 465 Touchless X-ray from Thermo Fisher Scientific (Minneapolis, Minnesota; Booth #1230) has been engineered without the shielding curtains typically used to block radiation, while still complying with all global safety standards.

"Heavy curtains frequently prevent lightweight meat products from being conveyed through the X-ray chamber, resulting in production line jams and downtime," explains Bob Ries, Thermo Fisher's lead product manager of metal detection and X-ray inspection. "The EZx 465 Touchless X-ray system eliminates shielding curtains by conveying

the product through the inspection chamber via a series of small slopes. Additionally, the unit also features an aperture with reduced height to ensure that X-ray scatter does not escape from the system."

The new line of Dual X Technology from Anritsu Industrial Solutions USA (Elk Grove Village, Illinois; Booth #7952) analyzes two different X-ray energy signals, allowing it to distinguish between product and contaminant and enabling a higher detection rate of low-density items compared to conventional X-ray technology.



The Freedonia Group, a market analyst group, predicts overall demand for meat, poultry and seafood packaging will grow by three per cent annually through 2015.

"The Dual X system is optimal for use in the poultry industry and is also well-suited for detecting rubber, stone, bone and other detectable, dense contaminants," says Christopher Young, business development manager at Anritsu.

Mettler-Toledo Safeline (Tampa, Florida; Booth #706) its Safeline PowerChek Plus X-ray inspection system was designed specifically to meet the product contamination inspection needs of volume producers of meat products, detecting contaminants including metal, stone, glass and bone. Allen Bradley controls ensure reliable performance and elevated AMI sanitary requirements provide maximum results.

Also, the Mettler-Toledo Safeline PowerPhasePRO electronics software delivers unrivalled levels of detection sensitivity that enables the detection of even difficult-to-find non-magnetic stainless steels. PowerPhasePRO metal detectors offer the unique benefit of an advanced change-free running mode that enables multiple products to be run at a single setting, eliminating the need to reset during product changeovers.



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## Keep product moving after inspection

Packing and labelling technologies should function at the same rate as the previous processes, says John Fini, vertical marketing manager of food at Videojet Technologies Inc. (Wood Dale, Illinois; Booth #1534), or the packer might be forced to dispose of unpackaged meat.

"The challenge for the packer is that once the packaging process has started, the production line has to continue. Any extended downtime could risk product safety," he says "Wait too long, and the financial impact could be significant, due to disposing of unpackaged meat."

Clearly, it is critical that packers have the most efficient and reliable coding system in place, the one that functions best on specific packaging materials, in particular flexible packaging. The movement to flexible packaging is continuing, because it allows for highly convenient, eye-catching packaging options, while providing great shelf stability.

"Flexible packaging growth provides great opportunities for improvements in coding technologies to meet new food safety requirements while providing easier-to-read solutions for busy consumers," says Fini.

"Videojet's new DataFlex Plus Thermal Transfer Overprinter (TTO) delivers high-resolution images on flexible packaging, while minimizing downtime and costs associated with ribbon breaks and production changeovers," he adds. "The system is highly efficient in marking variable information such as date, time, batch code, ingredients, logos and marketing information onto flexible film packaging, labels or glossy cards."

The new generation of continuous inkjet printers allows for even more uptime than previous models, enabling greater productivity and continuous operation for a wide range of coding and marking applications.



Mettler-Toledo Safeline's Safeline PowerChek Plus X-ray inspection system & Fristam Pump's FKL series positive displacement pump.

Today's coding and marking systems are also available in IP-rated versions, for enhanced protection against dust and water, making them ideal for the wash-down environments that exist in meat and poultry applications.


Videojet national account manager Eric Davis adds laser marking systems might be the labelling system of choice.

"We have a new system that offers a clear, easily legible, quality laser marking on almost any material, giving a wide range of application options," he says. "The advantages of laser marking systems are high speeds, consistent print quality, printing on extremely small areas and operation in almost any environment."

Food manufacturers see case-ready, chilled prepared foods as an area for growth. These fresh meal solutions, such as fajita kits, chicken nuggets and meatloaf, are appealing to today's not-enough-hours-in-the-day mentality.

"Packaging is often a plastic bag or a chipboard paper box. TTO is a good solution for simple bags, while gusseted and preformed bags are typically coded with inkjet," says Davis. "And chipboard cartons are typically coded with laser or inkjet."

PMMI is a trade association of nearly 600 member companies that manufacture packaging, processing and related converting machinery in the United States or Canada; machinery components and packaging containers and materials. PMMI organizes the PACK EXPO trade shows: PACK EXPO International, PACK EXPO Las Vegas and EXPO PACK México, connecting participants in the packaging and processing supply chain with their customers around the world.

For more information about PACK EXPO International 2012, visit [www.packexpo.com](http://www.packexpo.com). 

- PMMI



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# Mitigating Risk and Leveraging Expertise

What every entrepreneur and small business owner needs to know.

By Beckie Scarrow

**ENTREPRENEURS AND SMALL** to mid-sized business owners value their independence. It's the reason why so many set off on their own to begin with. While this independence is exciting and empowering, it doesn't mean that small businesses should always "go it alone."

In fact, this approach can actually be detrimental. A joint study by RSA, a leading small business insurer, and Queen's School of Business reveals that many small businesses are missing out on valuable and strategic counsel right now.

Such strategic counsel can come from an insurance broker. However, insurance is often the first thing that small business owners let slide when money is tight, according to the study. Yet there is nothing worse for a small to mid-sized business than to have to consider closing up shop for any amount of time after a major event – especially if it could have been prevented with the right insurance policy.

For this reason, a conversation with a trusted advisor can alleviate some of the stress and worry and can even prevent major headaches down the road.

For example, a general property policy only covers damage to machinery by an insured peril, however every business is in danger of having its work interrupted by breakdown of its critical equipment. To safeguard the exposures that threaten ongoing operations, any time a business operates very specific and expensive equipment like meat grinders, meat presses, cutting machinery, sausage making equipment, along with other meat processing equipment, it should consider having Equipment Breakdown Insurance (EBI).

This policy provides coverage for the cost to repair/replace production machinery damaged by a sudden and accidental failure, the loss of business income, and the extra expense incurred to resume business. The potential impact of a major loss to an operation's equipment can be more far-reaching than one might expect – it could impact a company's ability to retain current and future customers.

Below are some other important types of insurance or risk mitigation steps small businesses should consider:

- **Commercial General Liability:** Consider what amount of liability coverage you need for both your business and your operations. If a customer suffers a serious injury on your property and sues, and you don't have enough coverage, you could end up paying out of pocket. In some cases this could result in a significant financial loss and risk to your business.
- **Business Interruption:** This coverage is designed to provide protection for loss of earnings and necessary continuing operating expenses following material damages from events such as a fire or water damage from a pipe burst. In other words, it will provide you with support when your business is temporarily unable to operate as it normally does.
- **Property Coverage:** It's extremely important that small business owners have coverage in place to protect their stock and equipment, and the building itself if they own it.
- **Loss Control benefits:** Taking proactive steps to protect

your property is one of the most important steps you can take in mitigating risk. If you install an alarm system, you may prevent or significantly reduce the financial impact of a fire or burglary. An alarm may also reduce the cost of your insurance as you may qualify for an alarm discount – this discount may offset the cost of installing the alarm system.

- **OPCF 43 – Removing Depreciation Deduction:** This addition to your automobile policy covers the depreciation of new private passenger vehicles and many light commercial vehicles when you are the original purchaser/lessee. If, within the first 24 months of owning your vehicle, you are involved in an accident resulting in your vehicle being




Insurance is often the first thing that small business owners let slide when money is tight...

written off, you'll be reimbursed for the non-depreciated value. This will help reduce the financial impact if there is a significant difference between the amount owed on a vehicle and the straight actual cash value, which can leave you short.

When looking for an advisor, small business owners should keep the following in mind:

- **Qualifications** – Ensure your advisor has the appropriate qualifications. This could include an insurance broker licence, lawyer's or accountant's professional degree, a university degree in the area of expertise, or some other professional training relative to the area of work.
- **References** from other small business owners/managers.
- **Expertise** – Factors like the degree of expertise, the number of years experience as an advisor, and percentage of time spent practicing in that area are critically important.
- **Fees** – It is important to feel comfortable with the fee being charged, and the payment terms. Are they fair, competitive, and affordable? Do they match the person's qualifications and experience?

Protecting your business means investing in future growth. Finding the right advisor and leveraging their expertise can help you develop strategies for growth while identifying and minimizing risk to the business you work so hard to build. 

*Beckie Scarrow is currently the director of commercial underwriting at RSA Canada ([www.rsabroker.ca](http://www.rsabroker.ca)). She has worked in the insurance industry for over 25 years and during her career, Beckie has held various senior roles in Head Office, Underwriting and Operations with several leading insurers in various Canadian regions.*

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# Large Shoes to Fill

## New president settles into role at CFIB.

By Dan Kelly

IT'S NEVER EASY to follow a dynamic leader, let alone two living legends; believe me, I know. As I settle into my new role as president and CEO of the Canadian Federation of Independent Business (CFIB), I'm more than a little intimidated by the legacy that I've inherited.

Throughout CFIB's 41-year history, we've only had two other presidents. Our first was John Bulloch, a true visionary who built CFIB from scratch in order to fight a federal budget that would have raised effective taxes on small business to 50 per cent – double the rate of large firms. John held rallies, sold memberships and spoke to an incredible 420 Rotary Club meetings in our first 15 years. Needless to say he won that battle and CFIB was created. I've been fortunate enough to get to know John, and he's still a big part of CFIB.

John was succeeded as president by the indefatigable Catherine Swift. Under Catherine's 17-year leadership, CFIB has grown to 109,000 small and medium-sized business



When I think about what entrepreneurs do every day in taking risks to create jobs and grow our economy, my job doesn't seem that scary.

members and we are arguably the largest and most high-profile business association in Canada.

I've always admired Catherine's incredible courage. Catherine provided leadership to a very successful organization and led it to even greater heights. She took on such powerful interests as the banks and public sector unions, all the while raising two children.

One of the things that union leaders never understood about Catherine is that every threat or personal attack just motivated her to defend our members' interest even harder. There's no doubt that Catherine leaves some incredibly big shoes to fill. And while my wife tells me I don't have the legs for Catherine's heels, I'm committed to doing my best to follow in her footsteps.

My new role happened after years of careful planning by Catherine and CFIB's board of governors. Given CFIB's research and excellent member tools on the subject of succession planning, we've made this a priority at all levels



throughout the organization. Part of this process included spending several weeks visiting business owners to ask them to join CFIB and meeting with existing members to ask them to renew their memberships. Voluntary membership fees are CFIB's only source of revenue. Unlike unions, CFIB does not have any legislated "rand" formula compelling everyone to belong or pay dues — nor would we ever ask for such a rule. I'm proud to say 18 new businesses joined in the Ottawa valley during my two weeks focusing on new memberships.

Many have asked how CFIB will continue to grow under new management. My response is that we must always reach out to CFIB's greatest strength: our members all across this great country. That means serving small and medium-sized business owners the way they want to be served. And it means empowering members to grow their businesses, and staying relevant to the next generation of entrepreneurs.

One of the ways we plan to help our members grow is by launching "Small Business Saturday." Shortly, we will be formally announcing the details of a new initiative to encourage consumers to shop at small, local independent businesses. We're building an online tool that will allow business owners to offer special deals to consumers and other business owners.

The first Small Business Saturday will be held on Oct. 20 at the end of Small Business Week. We're partnering with Interac to also promote the benefits to consumers and small businesses of paying with Interac debit instead of high-cost credit cards. You can advance register now at [shopsmallbiz.ca](http://shopsmallbiz.ca).

We're also going to continue to do what we do best: standing up for job creators in the corridors of power, and speaking out on the issues that matter — unsustainable public sector pension schemes, unfair credit card fees, time-consuming red tape, payroll tax grabs or the growing shortage of labour.

If I do begin to get nervous in this job, all I need to do is think about some of the members I've met over the 18 years I've been at CFIB: the Quebec business owner who recently remortgaged his house to try to expand the business; the Nova Scotia woman who took no personal income from her business during the recession so she could continue to pay her staff; or the B.C. business owner who had to pay more than \$100,000 in legal bills to fight a government department that nearly shut-down her business with ridiculous red tape. When I think about what entrepreneurs do every day in taking risks to create jobs and grow our economy, my job doesn't seem that scary. **M**



Dan Kelly is the president and CEO of the Canadian Federation of Independent Business (CFIB), which represents the interests of small- and medium-sized business and lobbies on behalf of its 109,000 members at the federal, provincial and municipal levels. Follow Dan on Twitter @CFIB. This column first appeared in the *Financial Post* on July 3, 2012.

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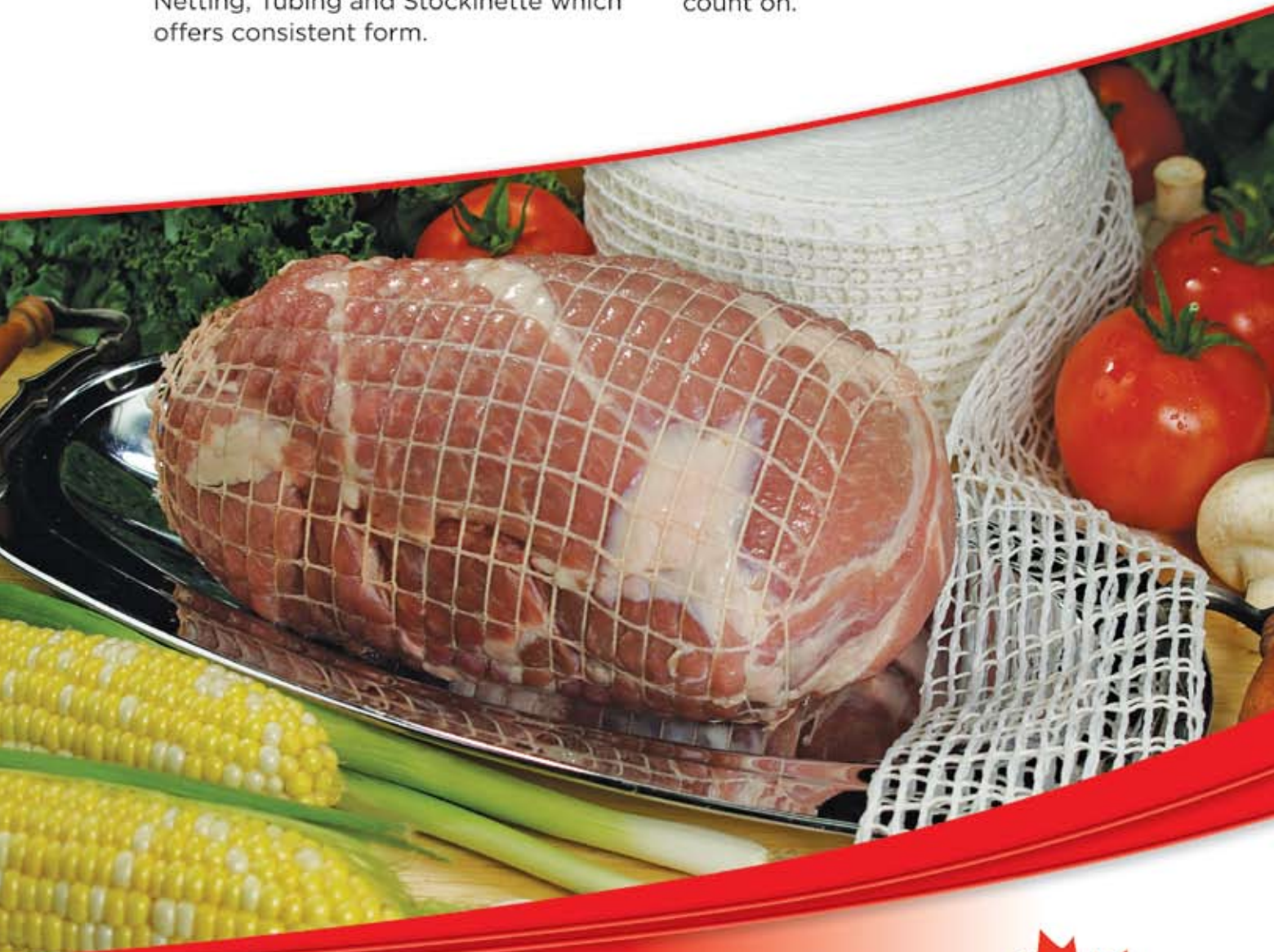
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