

Establishment Number	Establishment Name	Inspection Date	Description
P7669	Turkey Valley Farms, Inc.	28-Jun-24	<p>The following Good Commercial Practices incident was addressed at the weekly meeting with the establishment.</p> <p>On Tuesday 6/25/2024 at approximately 0430 hours while conducting antemortem, all of the birds were observed panting heavily, drooling, and vocalizing. Some of the birds appeared lethargic with their heads hanging down. A few birds inside some of the coops appeared as though they may have been DOA, this was more apparent on the toms rather than the hens. We have been experiencing warmer temperatures than normal. Overnight temperatures Monday evening into Tuesday morning were in the mid to upper 70's and daytime temperatures were in the 90's Monday and mid 80's Tuesday. On Wednesday, 6/26/2024 while reviewing DOA counts from the previous day, lot #1 of heavy toms from producer REDACTED/ REDACTED out of St. Joeseph, MN had 18 DOA out of 248 head or 7.25%. Lot # 5 of heavy toms from producer REDACTED/REDACTED out of Springfield, MN had 1043 DOA out of 6917 head or 15.07%.</p> <p>I communicated my observations with Live Production Coordinator, REDACTED. Ms. REDACTED said that REDACTED from Tuesday were the last of that barn and were birds that didn't get on Sunday's trucks. Typically, the last of the barn is a weaker animal. It took a little longer to load the birds due to the small amount left because they were manually loaded at the farm. In addition, she said the REDACTED birds were bigger birds which typically are affected more by heat. She observed the first 3 trucks in the yard before she left</p>

		<p>around 4 PM and the birds didn't seem distressed at that time. They were panting a little, but alert and non-vocal. The misters were on in the barn, and the farm was spraying the birds outside as they were loading them. On Tuesday when the REDACTED birds were loaded for slaughter on Wednesday, the temps were still in the 80's but the heat index was much lower. DOA's were not an issue for that flock on Wednesday. Ms. REDACTED said she went through the cooling shed on Monday afternoon to check fans. She noticed some needed to be cleaned and requested to have that done, and it was handled promptly. She also spoke with maintenance and was told is a daily check.</p> <p>On Thursday, June 27 at approximately 0430 hours while conducting antemortem inspection, I observed that 4 of the fans in row #13 of the live haul shed were not operating. Three other fans in different areas of the shed were also not operating and two fans were operating but appeared to be slow. I spoke with Evisceration Superintendent, REDACTED about my observations. Mr. REDACTED said he was going to do a walkthrough of the shed and address any issues as needed.</p> <p>At the weekly meeting Plant Manager, REDACTED, said he agreed with Ms. REDACTED assessment. He added that there may be additional measures they could take to mitigate mortality during very hot weather, such as running the toms which are more susceptible to heat first in the morning or if possible, bringing them in on a different day. Maintenance Manager, REDACTED, said the establishment would be regularly checking the fans for any needed maintenance.</p>
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P7669	Turkey Valley Farms, Inc.	6-Oct-23	<p>On Tuesday, October 3, 2023 for lot #4 of breeder toms from REDACTED, REDACTED out of Motley, MN we had 9 DOA out of 531 head or 1.6%. Not necessarily an extremely high number for breeders, but slightly higher than average.</p> <p>On Wednesday, October 4, 2023 for lot #3 of toms from REDACTED, REDACTED out of Raymond, MN one-half of the passenger side for trailer #208 was paneled. I'm not sure why this was done. Although there was some rain, the temperatures only got down into the mid 50's. Even if it was paneled due to the rainy conditions, they probably should have been removed once the trailer was parked and stationary.</p> <p>This morning, Thursday, October 5, 2023 for lot #2 of light hens from REDACTED, REDACTED out of Morton, MN all of the trailers for the lot were overcrowded. Birds were pushing up against the sides and front of coops. Some birds were observed sitting on top of other birds due to lack of room. There was also one partial load. Although most of that trailer was empty, the individual coops with birds were overcrowded. I spoke with Plant Manager, REDACTED this morning, and we both went out to look at the trailers. As you're aware, this has been a reoccurring issue. Please let me know of any measures implemented to prevent future recurrence.</p> <p>I emailed Live production Coordinator REDACTED about my observations. I also copied General Manager, REDACTED, Plant Manager, REDACTED and QA Director, REDACTED in the email.</p>
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P7669	Turkey Valley Farms, Inc.	22-Mar-23	<p>Est. 7669p Turkey Valley Farms, March 22nd, 2023</p> <p>At approximately 1407 hours, while performing a Good Commercial Practices verification task, I observed 1 out of REDACTED carcasses showing signs of consciousness (blinking eyes, raised head, opening and closing mouth/beak) proceed onto the scalders. As the bird approached the secondary stunner, it raised its head avoiding the stun plate. Evisceration Superintendent, REDACTED, was notified immediately. While Mr. REDACTED was present, three additional birds with signs of active movement (blinking eyes, raised head),</p>

			<p>were observed to proceed on to the secondary stunner. Mr. REDACTED slowed the line speed to allow additional bleed time. Mr. REDACTED also raised the secondary stunner to ensure better contact and informed Hang/Pick/Kill Supervisor, REDACTED. Mr. REDACTED counseled the back-up killer to watch for any birds showing activity. A recheck of 200 carcasses was conducted at 1428 hours with no carcasses showing signs of consciousness.</p>
P7669	Turkey Valley Farms, Inc.	8-Mar-23	<p>Est. 7669p Turkey Valley Farms, March 8th, 2023</p> <p>At approximately 1530 hours, while performing a Good Commercial Practices verification task, I observed 1 out of REDACTED carcasses showing signs of consciousness (blinking eyes, raised head, opening and closing mouth/beak) proceed onto the scalders. As the bird approached the secondary stunner, its head was raised avoiding the stun plate. Evisceration Superintendent, REDACTED, was notified immediately. Mr. REDACTED then informed Hang/Pick/Kill Supervisor, REDACTED. Mr. REDACTED found that the birds were not following the guide bar for the automatic kill machine correctly and made adjustments to correct the issue. At approximately 1534 hours a bird with reddening on the neck, wings and breast area was observed prior to the hock cutter. A further inspection of the carcass showed that it had been cut but may not have been cut deep enough to fully bleed out. A recheck of 200 carcasses was conducted at 1540 hours with no carcasses showing signs of consciousness.</p>
P7669	Turkey Valley Farms, Inc.	30-Jan-23	<p>While conducting antemortem inspection on Monday, 1/23/2023 for lot #1 of breeder hens from producer REDACTED, REDACTED, out of Motley, MN I</p>

		<p>observed several DOA's on the trailers prior to unloading. The trailer coops appeared to be loaded unevenly with some coops having fewer birds and others appearing to be crowded. A few birds were observed sitting/standing on top of other birds. The birds that were being sat on appeared to be DOA. The birds in general were in poor condition. They appeared to be in full molt with little to no feathers. Several birds were observed with visible sores or open wounds and smeared blood was observed on the floor and ceiling of some of the coops. Temperatures the previous evening were extremely cold, averaging between -2- and -6-degrees Fahrenheit. Some of the birds were observed shivering and some were extremely lethargic. Poultry lot records indicted there were 700 DOA out of 6750 head or 10.37% for the lot. There were also 92 carcasses condemned at postmortem inspection as cadavers in the lot. Many of the cadavers appeared to be cut but did not have sufficient bleed-out. Many of the viscera were also observed to be cool/cold to the touch indicating potential hypothermia.</p> <p>Similar issues were observed on Monday, 1/23/2023 for lot 3# breeder hens from producer REDACTED, REDACTED, out of Mt. Vernon, MO and Friday, January 13th, for lot #1 of breeder hens from producer REDACTED, out of Pierce City, MO. For those lots we had 7.57% DOA and 4.12% DOA respectively. Cadavers indicate the birds died from causes other than slaughter. If birds hung on the slaughter line die before slaughter because of mishandling, or if birds are being killed in a manner that does not comply with GCP as defined in 9 CFR 381.65(b), the resultant product is adulterated under</p>
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			the PPIA. This includes the treatment of all birds brought onto the official premises of a slaughter plant, not just those entering production. Compliance with these requirements helps ensure that poultry are treated humanely. In general, poultry should be handled in a manner that prevents needless injury and suffering in order to produce a commercially marketable product.
P7669	Turkey Valley Farms, Inc.	26-Jan-23	<p>Est. 7669p Turkey Valley Farms, January 26th, 2023</p> <p>At approximately 1530 hours, while performing a Good Commercial Practices verification task, I observed 1 out of REDACTED carcasses showing signs of consciousness (blinking eyes, raised head, opening and closing mouth/beak) proceed onto the scalders. As the bird came to the secondary stunner it lifted its head avoiding the stun plate. Evisceration Supervisor, REDACTED, was notified immediately. Mr. REDACTED immediately raised the stunner to ensure better contact. A recheck of 200 carcasses was conducted at 1539 hours with no carcasses showing signs of consciousness.</p>
P7669	Turkey Valley Farms, Inc.	24-Jan-23	<p>While conducting antemortem inspection on Monday, 1/23/2023 for lot 3# breeder hens from producer REDACTED, REDACTED, out of Mt. Vernon, MO I observed several DOA's on the trailers prior to unloading and some of the trailer coops appeared fairly crowded with birds. Some birds were observed sitting/standing on top of other birds. Several of the birds that were underneath (being sat on) appeared to be DOA. Poultry lot records indicated there were 481 DOA out of REDACTED head or 7.57% for the lot. There were also 101 carcasses condemned at postmortem inspection as cadavers in the lot. Many of the cadavers appeared to be cut but did not have sufficient bleed-out. Many of the</p>

			<p>viscera were also observed to be cool/cold to the touch indicating potential hypothermia.</p> <p>Similar issues were observed on Friday, January 13th, for lot #1 of breeder hens from producer Select Genetics/Hillcrest, out of Pierce City, MO. For that lot we had 4.12% DOA. Similar dispositions of elevated cadavers symptomatic of hypothermia were also observed at premortem and postmortem inspection. I informed Live Production Coordinator, REDACTED of my observations on January 13th. At that time Ms. REDACTED stated that there were some weather issues with mixed precipitation (rain/sleet/snow) during load-out. She said the growers were aware of the weather issue and delayed loading by two hours to hopefully mitigate stress and mortality.</p> <p>I understand that the transportation of live birds poses several challenges including weather, distance traveled, flock age and general bird health. However, 7.57% DOA or even 4.12% seem above what would be considered an acceptable number, particularly when also taking into consideration the high number of cadavers. Please keep in mind that if birds hung on the slaughter line die before slaughter because of mishandling, or if birds are being killed in a manner that does not comply with GCP as defined in 9 CFR 381.65(b), the resultant product is adulterated under the PPIA. This includes the treatment of all birds brought onto the official premises of a slaughter plant, not just those entering production.</p>
P7669	Turkey Valley Farms, Inc.	31-Oct-22	<p>Est. 7669p Turkey Valley Farms, October 31, 2022</p> <p>At approximately 1345 hours, while performing a Good</p>

			<p>Commercial Practices verification task in the pinning room, I observed 100 carcasses. One of the carcasses was observed blinking its eyes. It then proceeded onto the secondary stunner, lifted its head above the stunner and showed additional signs of consciousness (blinking eyes, open mouth breathing, raised head, and wing movement) and proceed into the scalding. I immediately informed REDACTED, REDACTED. REDACTED REDACTED then adjusted the secondary stunner. At approximately 1350 hours both REDACTED REDACTED and I observed an additional 200 carcasses. One of the carcasses was observed with blinking eyes. The carcass proceeded onto the secondary stunner making sufficient contact so that no signs no signs of consciousness were observed when as it exited the stunner. REDACTED REDACTED and I then observed an additional 200 carcasses with none showing signs of consciences.</p>
P7669	Turkey Valley Farms, Inc.	7-Oct-22	<p>While conducting antemortem inspection on Wednesday, October 5th I observed some overcrowded coops on trailers REDACTED, REDACTED REDACTED and REDACTED for lot #2 of light hens from producer REDACTED, Ager, out of REDACTED. The trailers as a whole weren't overcrowded but, there were some individual coops (approximately three per trailer) full to the point that some of the birds didn't have enough room and some were sitting/standing on top of other birds. It appeared as though some of the bottom birds were DOA, perhaps due to suffocation.</p> <p>I communicated my observations with establishment management via email. On Thursday, October 6th at the weekly meeting with the establishment, REDACTED, REDACTED, said that he had forwarded the email I had</p>

			<p>sent him to the farms manager but, he had not gotten a response back as of yet. I also contacted REDACTED, REDACTED, who said she followed up with the REDACTED. She said the REDACTED had responded that there was a new employee in training on the automated loader. She also told me that the owners/growers had recently changed from using “Agri Temps” in Willmar, MN as their contracted load-out crew to a new loading crew from “Team up”. I shared with REDACTED REDACTED that on Thursday, October 6th antemortem was much better and there were no issues with overcrowding on any trailers. Although they were from a different grower, lot #2 on Thursday was also light hens, which is the class of birds where we are seeing the most problems. She said she would pass along the information.</p>
P7669	Turkey Valley Farms, Inc.	12-Sep-22	<p>On Monday 09/12/22 while conducting antemortem inspection for lot #3 producer REDACTED/REDACTED, REDACTED; I observed that all five of the trailers for that particular lot were significantly overcrowded. The birds were pushing up against the sides and front of the trailer coops and some birds were observed standing on top of each other inside the coops due to lack of room. Several birds (more than 20 per trailer) had their head/neck sticking out of the coops and one had a foot sticking out of the front of the coop. At least two birds were observed with their heads hanging down and appeared to be DOA.</p> <p>At approximately 1200 hours while the establishment was processing lot #3 REDACTED, REDACTED, called me down to evisceration. He had a carcass hung back for disposition. Upon examination the carcass had signs</p>

		<p>consistent with a cadaver, or a bird that was near death at the time of slaughter. The carcass was dark pink to light red in color, the viscera and fat were reddish in color, and you could see coagulated blood around the neck. REDACTED, REDACTED, informed me he had previously observed three additional carcasses with similar characteristics the lot. At approximately 1215 hours I went into the pinning room and observed two carcasses on the floor that had been removed prior to the hock cutter. The carcasses were similar in appearance to the one REDACTED, REDACTED, had hung back for disposition. At approximately 1230 hours REDACTED, REDACTED, had another carcass hung back that was similar in appearance to the others. The carcasses that were examined appeared to be cut properly, but did not sufficiently bleed out. This would be constant with a bird that was near death at the time of slaughter or was killed by means other than slaughter. Extreme overcrowding could create conditions resulting in mortality or extreme distress due to lack of oxygen.</p> <p>I communicated my observations with establishment management via email. I also spoke with both REDACTED, REDACTED and REDACTED, REDACTED. REDACTED REDACTED responded that the establishment was aware of the issue and that the load head count numbers were figured on a 12.9-pound average she had received on the premarket form from the farm. She explained that she spoke with the grower, and they have made truck and loading adjustments based on the truck numbers that came in last night. She said that this evening Monday, September 12, 2022, they will load</p>
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			2376 head per trailer vs the 2700 from the previous evening Sunday, September 11, 2022.
P7669	Turkey Valley Farms, Inc.	2/15/2022	At approximately 1355 hours, while performing a routine Good Commercial Practices verification task, I was observing the live hangers unload a trailer from lot #3 of heavy hens. One of the live hangers took a live turkey and slammed the bird against the live line shackles. The bird hitting against the shackles made a loud crashing sound. The live hanger then proceeded to hit the turkey against the shackles two more times before hanging the bird on the live line. I immediately informed, REDACTED, REDACTED, of my observations. At this time REDACTED went to investigate the issue. I then went and immediately informed REDACTED, REDACTED of what I had observed. Upon finishing his investigation REDACTED came to my office at approximately 1415 hours. He informed me that he had spoken with all the live hangers and given them a verbal warning. He said he had informed them that any further incidents could lead to disciplinary action including termination. I then informed him that the incident would be documented.
P7669	Turkey Valley Farms, Inc.	7/26/2021	Est. 7669p Turkey Valley Farms, July 26th, 2021 At approximately 0445 hours while conducting antemortem inspection, cracked flooring was observed on live haul trailer #201. The crack in the flooring created a gap large enough that a turkey had gotten its leg caught in the opening. I informed REDACTED, REDACTED, REDACTED, REDACTED, and REDACTED, REDACTED, of my observations. REDACTED. REDACTED said that he would tag and hold trailer #201. Damaged flooring was also noted on trailers #187 and #185. On Thursday, 07/22/2021, during the weekly

			<p>USDA meeting with the establishment, I informed REDACTED. REDACTED that while I was conducting antemortem inspection on Wednesday 07/21/2021 broken flooring was observed on live haul trailers #204 and #201. The same damaged flooring was noted in a previous weekly meeting on Thursday 07/15/2021. Additionally, a GCP MOI was documented on Friday 07/16/2021 where a bird had become caught in the same broken flooring on trailer #201. The flooring had not been repaired and the coups were still being used to hold birds. The establishments verbal corrective actions included communicating with the Grow-out Manager, REDACTED. REDACTED, and taking pictures of the damaged flooring to ensure repairs were made. The corrective actions were either not implement or were not sufficient to prevent recurrence.</p>
P7669	Turkey Valley Farms, Inc.	7/16/2021	<p>Est. 7669p Turkey Valley Farms, July 16th, 2021 At approximately 0445 hours while conducting antemortem inspection, cracked flooring was observed on live haul trailer #201. The crack in the flooring created a gap large enough that a turkey had gotten its foot wedged in the opening. I informed REDACTED, REDACTED, of my observations from this mornings antemortem inspection. On Thursday, 07/15/2021, during the weekly USDA meeting with the establishment, I informed REDACTED. REDACTED that while I was conducting antemortem inspection that week, three live haul trailers were noted to have floor damage. This included trailer #201. However, the damaged flooring noted on Thursday was in a different area from the damage observed this morning. After the weekly meeting REDACTED. REDACTED had contacted Grow-out Manager, REDACTED. REDACTED, who said they would try to get some</p>

			pictures of the damage so that they could have a better idea what was observed and get needed repairs done.
P7669	Turkey Valley Farms, Inc.	7/13/2021	Est. 7669p Turkey Valley Farms, July 13th, 2021 At approximately 1250 hours, while performing a Good Commercial Practices verification task, I observed 1 out of 100 carcasses showing signs of consciousness (blinking eyes, raised head, and wing movement) proceed onto the secondary stunner. The bird made initial contact with the stunner while its head was raised and then lifted its head further to avoid being stunned and was observed to proceed into the scald tank. REDACTED, REDACTED, was notified immediately. REDACTED. REDACTED then raised the height the secondary stunner to ensure better contact with the birds. A recheck of 200 carcasses was conducted at 1258 hours with no carcasses showing signs of consciousness. As similar incident of a bird showing signs of consciousness entering the scald tank was previously observed and documented in an MOI on 6/9/2021.
P7669	Turkey Valley Farms, Inc.	6/9/2021	Est. 7669p Turkey Valley Farms, June 9th, 2021 ..At approximately 1150 hours, while performing a Good Commercial Practices verification task, I observed 1 out of 100 carcasses showing signs of consciousness (blinking eyes, raised head, and wing movement) proceed onto the scald tank. The establishment was running a clean-up load from one of the barns. There was a significant degree of variation in the bird size with several of the birds being very small. The bird that was observed proceeding into the scald tank with signs of consciousness was so small that with its head lifted it completely avoided the secondary stunner. REDACTED, was notified immediately. REDACTED immediately went to the killer and

			<p>informed him that if he was having difficulties keeping up due to variation in bird size, he should stop the line if needed. He also said that if significant variation in bird size was observed, the stunner would be adjusted to accommodate the smaller sized birds. A recheck of 200 carcasses was conducted at 1200 hours with no carcasses showing signs of consciousness.</p>
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