

# Foreign Material Breakout: Incident Learnings & Prerequisite Programs



**Zach Cameron**  
Director  
Tyson Foods



**Sherri Trujillo**  
Head of Technical Services  
JBS USA Food Company

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# Foreign Material Control – Plant Systems Approach

# Regulatory/Financial Impact of Foreign Material



- Since 2019, there have been 44 FSIS foreign material recalls and 10 Public Health Alerts resulting in approximately 18,450,000 pounds of product recalled.<sup>1</sup>
  - “The average cost of a recall to a food company is \$10M in direct costs, in addition to brand damage and lost sales according to a joint industry study by the Food Marketing Institute and the Grocery Manufacturers Association.”<sup>2</sup>
- <sup>1</sup>USDA (2023, July 19). Recalls and Public Health Alerts. FSIS.USDA.Gov. Retrieved July 19, 23, from <https://www.fsis.usda.gov/recalls>
- <sup>2</sup>(n.d.). *Recall: The Food Industry's Biggest Threat to Profitability*. Food Safety Magazine. Retrieved July 20, 2023, from <https://www.food-safety.com/articles/2542-recall-the-food-industrys-biggest-threat-to-profitability>

MEAT INDUSTRY FOOD SAFETY CONFERENCE

# Consumer/ Customer Impact – Would you want this in your food?





# Foreign Object Control Policy

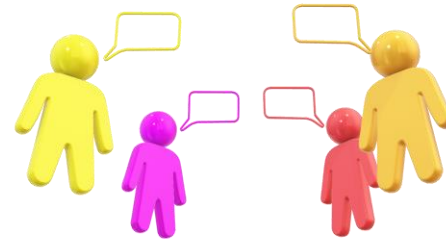
- Components and monitoring specifics should be determined by your systems and performance.
- Sets minimum expectations
- Evaluation of process and Findings
- Training and engagement



# Foreign Object Task Force (FOTF)

- Multidisciplinary team (management and hourly)
- Regular cadence
- Activities Data Driven

o Discuss



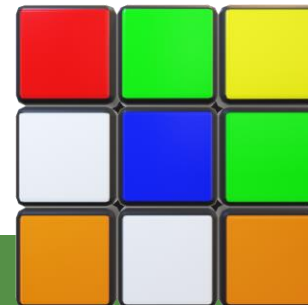
o Tour



o Investigate



o Provide Solutions





# Example of Investigation

***Problem Statement:*** *Customer found a piece of belt in trim produced from Est. X on 2/1 at 10:45*

***Why 1- Why was there a piece of Intralox belt in 50/50 combo trim?***

***Answer- Trim picker missed the piece of belt***

***Why 2- Why did the picker miss the belt piece***

***Answer – Too much trim on belt at the time coming down***

***Why 3 – Why was there too much trim coming to the picker at once?***

***Answer – There was a belt break down upstream causing product to accumulate***

***Why 4 – Why did the belt break down upstream causing product jam up***

***Answer – Belt XXX was skipping/ not running properly***

***Why 5 – Why was belt XX skipping/ not running properly ?***

***Answer – Mechanical issue with the sprocket of Belt XXX***

***Root cause – The sprocket on belt XX was incorrect size and so belt broke down and piece of belt broke off***

***Prevention – Put the correct sprocket on the belt XX to run smoothly and prevent belt breakages as well as put note in supply request matching sprocket to belt type/size.***



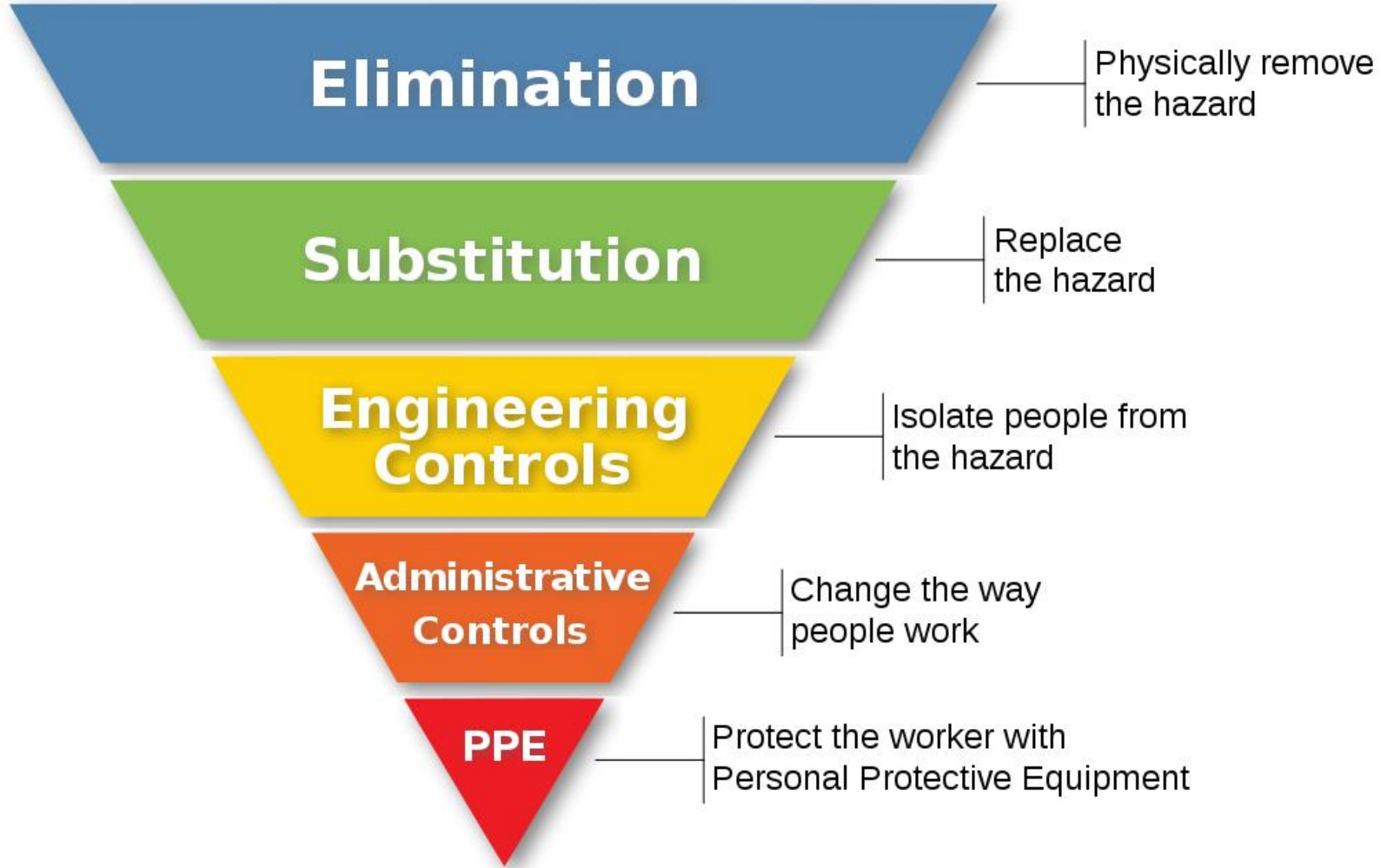


# Hierarchy of Controls

Most effective



Least effective



# Wrap-up



Be Process Driven

Utilize Hierarchy of Controls to Effect Improvement

Leads to Desired Results

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# NAMI Meat Industry Food Safety Conference

Foreign Material Break-Out Session

Incident Learnings

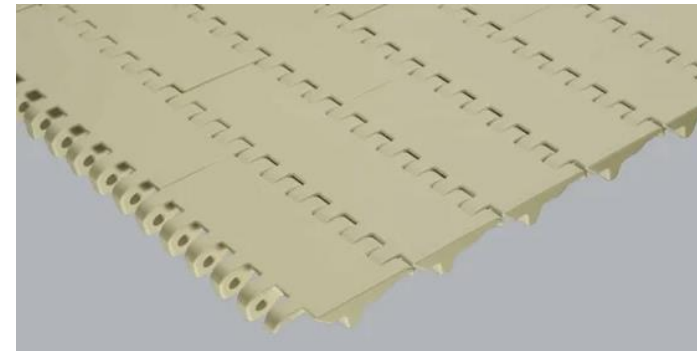
August 18, 2023

# Foreign Material (FM) Incidents

❑ What constitutes a FM Incident?



❑ When something undesirable gets into your system.



# FM Incidents

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- ❑ What happens when you don't follow your programs and procedures?



Chances of having a  
FM Incident increases.

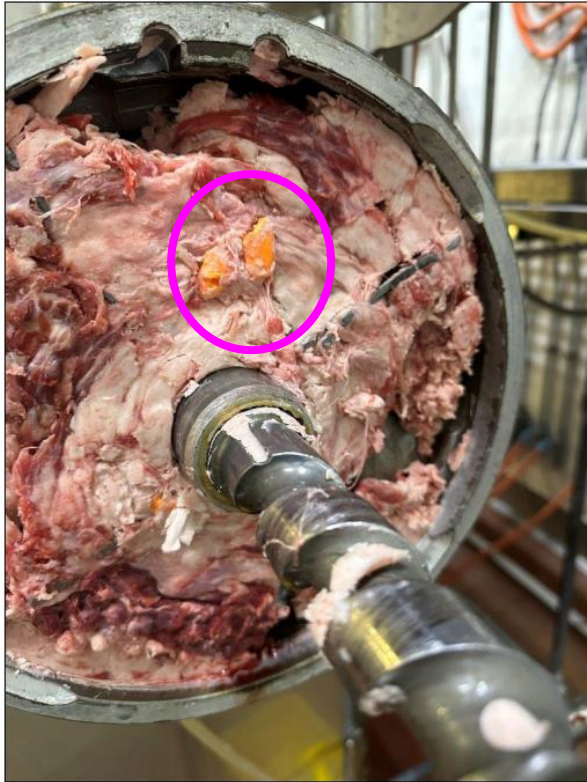
# FM Incidents

- ❑ Many different processes –
  - Whole carcasses
  - Fabrication / Trim
  - Ground Beef
- ❑ Most costly process to have a FM incident....

## **GROUND BEEF**



# FM Incidents



# Consequences of FM Incidents

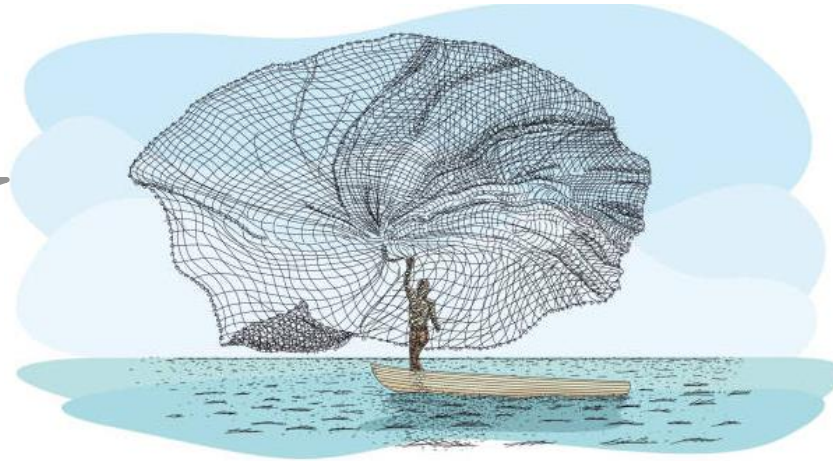
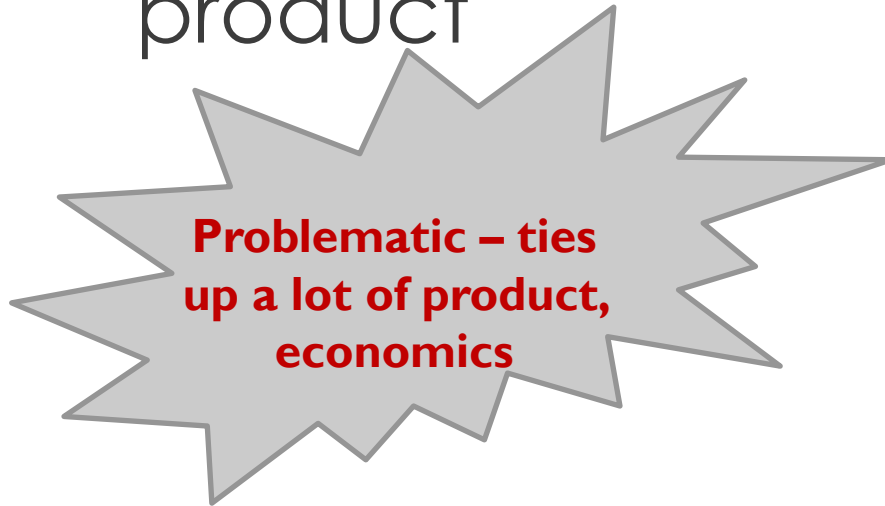
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- ❑ Affected product –
  - Raw Material
  - Work in Progress (WIP)
  - Finished Goods
- ❑ Down time –
  - Figure out what happened, when it happened, how it happened



# Affected Products

- Initially, a wide net is cast over the product



- Why?
  - Worst thing to happen is to have a FM incident and you don't hold enough finished goods **THEN** your customer / consumer gets it.....

# Mitigating Losses



- ❑ How do you mitigate product loss, down time, rework costs, etc.?
  - Sound procedures and programs
  - Execution of the procedures and programs
  - Lucky rabbit's foot, say a prayer, cross your fingers.....

# Mitigating Losses

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**OR....you might find a  
unique avenue to narrow  
affected product down**

**EXAMPLE**

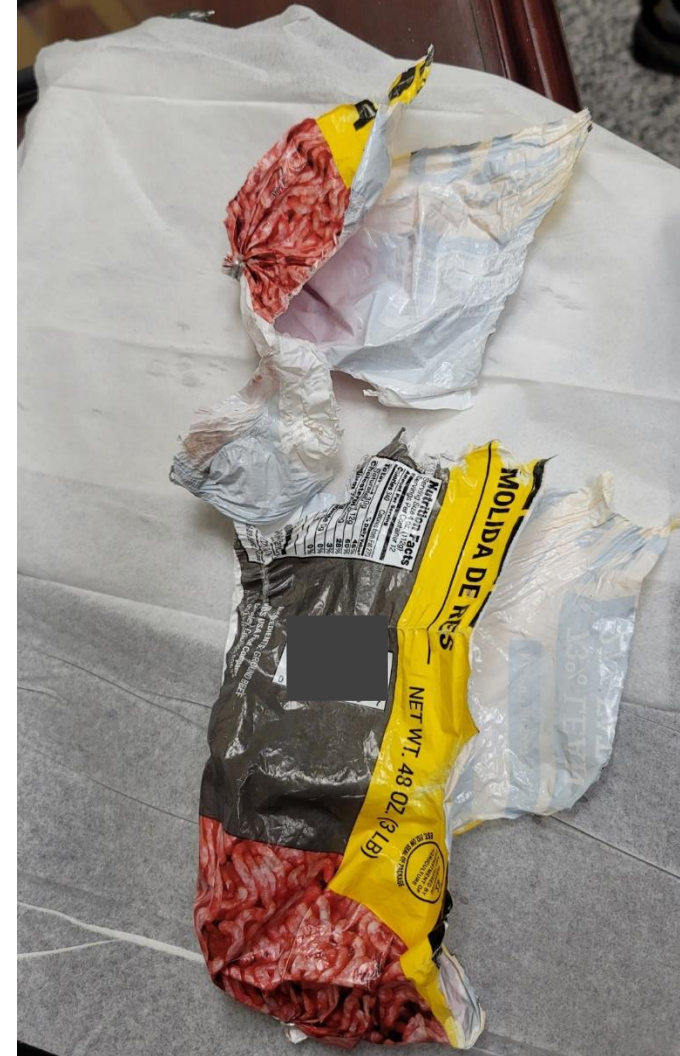
# Example Timeline

13:30 QA found plastic in the metal detector cart. Line was stopped, system cleaned out.

Plastic was identified as a printed packaging film.

Started running that product type at 07:56.

Product placed on hold from 07:56 to 13:30 – 1,600 cases, 19,200#





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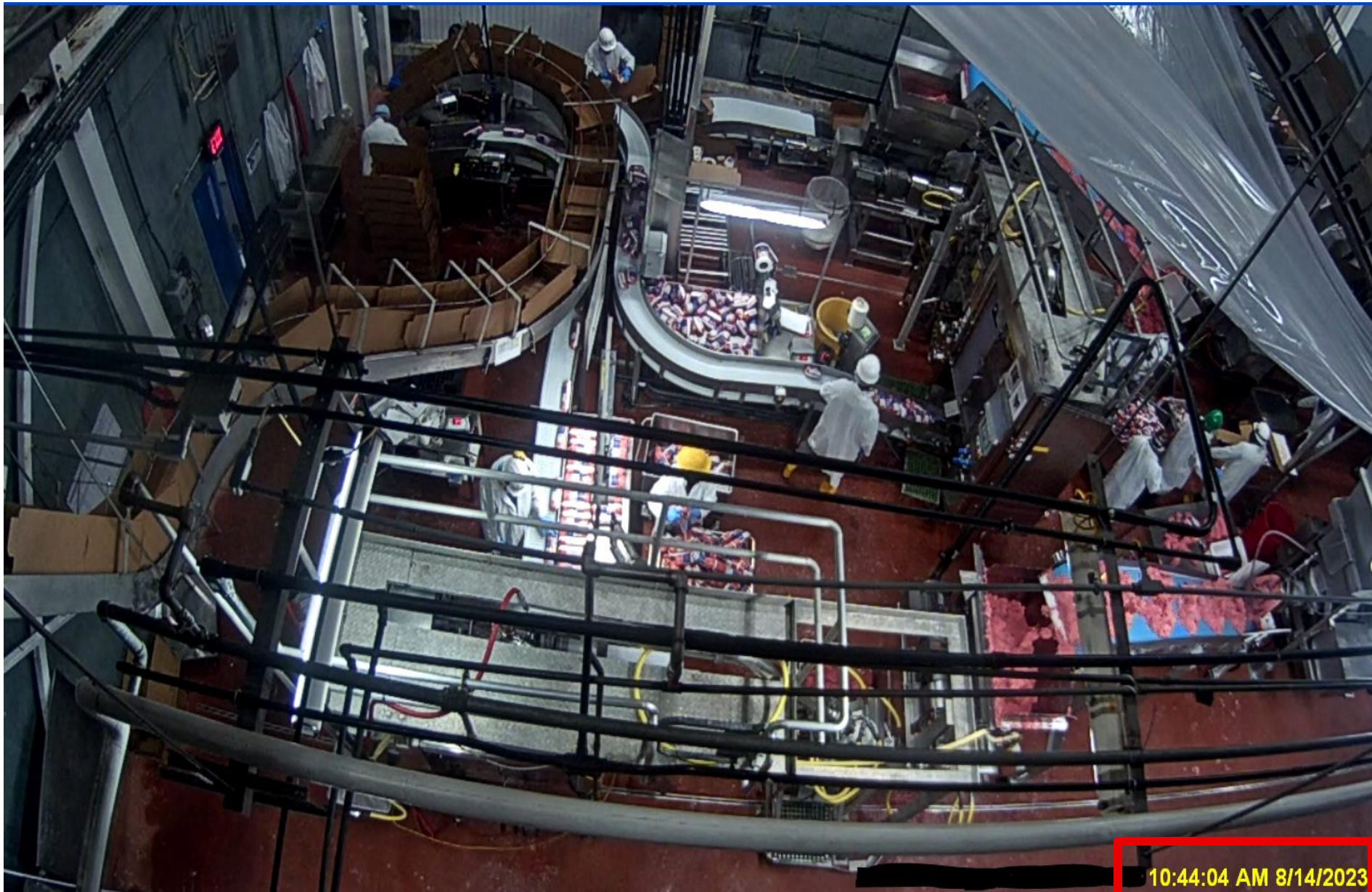
Film was introduced during the in-process rework on line 2



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## Film seen inside the Accupump





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# Example Timeline

- Time stamp on the camera allowed us to know right when the event happened.
  - Reduced affected product down to 222 cases, 2,664#



# Thoughts to Ponder

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- ❑ Properly designed procedures and programs, executed correctly will offer the **greatest protection**.
- ❑ When you are faced with a FM incident, **think outside the box** – you may find an unique solution.





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