

GMP⁺ Certification Scheme Animal Feed Sector 2006

Minimum Requirements for Inspections and Audits Including Protocol for the Measurement of Carry-Over

Appendix 4

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PART A: MONITORING PROTOCOLS

1. INTRODUCTION

Various GMP⁺ standards requires that a participant must draw up and implement a monitoring plan.

This section of this appendix includes a number of protocols for mandatory inspections of product norms (from Appendix 1, part A). In the drawing up and implementation of the monitoring plan the participant should include at least the requirements and conditions from the relevant protocols.

2. PROTOCOLS WITH RESPECT TO SALMONELLA MONITORING

2.1 *Introduction to the Salmonella protocols*

In the following protocols P1 and P2 there are extra requirements with respect to monitoring for Salmonella and Enterobacteriaceae in animal feeds for poultry, pigs, cattle and other animals. In protocols P3 and P4 there are extra requirements with respect to monitoring in feed materials, especially the monitoring requirements with respect to Salmonella-critical feed materials (P4).

All the data within the framework of this program is stored in the Product Board Animal Feed Undesirable Substances and Products Database and is accessible to those providing information, those being the feed materials suppliers and the compound feed preparers.

Classification of Salmonella-positive samples

In theory there will be classification in all cases, after the determination of Salmonella in feed materials (raw materials) for cattle farms, (serotype and possibly phage type). The protocol applies as included in Appendix I.

The poultry feeds, cattle feeds and pig feeds should be fully classified. The feed materials should be classified for the serotypes Enteritidis, Typhimurium, Infantis, Virchow, Hadar, Java and Agona.

The purpose of this classification is to establish more accurately any relationship among Salmonella types in feed materials, the compound feeds produced from them, animals and animal products. It is an aid in investigating the possible cause of Salmonella contamination in a subsequent link in the chain.

2.2 Protocol P1: Monitoring Salmonella and enterobacteriaceae in animal feeds for poultry.

1. Target group

Manufacturers of poultry compound feeds intended for delivery to livestock holders.
Suppliers of feed materials (intended for poultry) to livestock holders.

2. Products

Compound feeds and feed materials intended for poultry

3. General additional conditions

If a Salmonella-positive result is obtained then this should be classified in accordance with Appendix I.

4. Inspection frequency

The following situations are distinguished with respect to the animal feeds supplied to poultry farmers

- 4.1 Feed materials which are delivered singly to poultry farmers
- 4.2 Technologically-treated poultry compound feeds
 - A) which are delivered as such
 - B) which are delivered together with separate feed materials
- 4.3 Non-technologically-treated poultry compound feeds
- 4.4 End product check

Depending on the situation, requirements will be established for the entry check, production process control, and control in the logistical process. The frequency of inspection is dependent on previously obtained inspection results.

4.1 Feed materials for single supply to poultry farms

For feed materials which are supplied singly to poultry farms, sample taking and analysis for Salmonella should be done at least twice per year.

4.2 Technologically-treated compound feeds

Poultry feeds should be supplied Salmonella-free.

4.2.A. For producers of technologically-treated poultry feeds (for example pressing, acidification, etc.) the following requirements apply:

1. The compound feed manufacturer shows by way of an entero reduction test under which conditions the entero reduction is at least a factor 1000. These conditions should be used as set-up parameters for the production of treated poultry feed. The entero reduction test should be carried out at least twice per year. The compound feed manufacturer must be able to demonstrate that these set-up parameters are used in the production of poultry feeds. This applies from the beginning to the end of production.
2. Each company has its own responsibility and specifies the critical points for its own business situation and determines a minimum sampling plan. A process diagram should be part of the sampling plan. This shows the critical points for the process control.

The producer should apply process control at those points which are critical with respect to possible recontamination with Salmonella, including

- Coolers, inside where there are possible condensation sites
- Air supply from the cooler at places where the air is sucked in
- Each point in the production line after the press where recontamination of the product by, for example, dust, enzymes, wheat may occur.
- Inside of the ready product silo on the top.
- Each point after the production line where recontamination can occur such as open places, loading.
- Transport of the ready product to the client.

A representative number of samples should be taken and examined from the critical points mentioned above with a minimum of 10 per production line.

3. With respect to sampling the sampling protocol applies (where applicable) as specified in § 6 of this Protocol P1. Where this is not possible (because of dust, means of transport, for example) use may also be made of the sponge/swabbing method where a minimum of 200 cm² is taken (sponged/swabbed).
4. The critical points must be examined for Salmonella. The frequency of inspection must be once per month and if this is negative for a half year then the frequency can be reduced to once per two months. In the event of a positive finding analysis must be done again once per month for at least half a year. The positive samples must be classified.
5. In the event of contamination corrective measures will be taken immediately until there is demonstrable compliance with the norms.
6. At the request of the poultry farmer the research data related to the above will be made available to him or her.

4.2.B. For producers of technologically-treated poultry feeds with separate mixed feed materials the following requirements for separately mixed feed materials apply in addition to the requirements with respect to production of technologically-treated poultry feeds (see 4.2.A).

1. Only 'non-Salmonella-critical' feed materials may be mixed separately. (for Salmonella-critical feed materials see GMP Appendix 4, sec. 2.5. Protocol 4).
2. Any contamination which could possibly occur during reception, transport and storage of these (=non-Salmonella-critical) feed materials must be prevented. The critical points for recontamination with Salmonella must be checked monthly for this¹. These critical points are also indicated in the process diagram (see A2). These include as a minimum the reception of feed materials, internal transport and storage (= logistical process).
3. A representative number of samples should be taken and examined from the critical points mentioned above with a minimum of 3.
4. The critical points must be examined for Salmonella. The frequency of inspection must be once per month and if this is negative for a half year then the frequency can be reduced to once per two months. In the event of a positive finding analysis must be done again once per month for at least half a year. The positive samples must be classified.
5. In the event of contamination corrective measures will be taken immediately until there is demonstrable compliance with the norms.
6. At the request of the poultry farmer the research data related to the above will be made available to him or her.

4.3 Technologically-untreated compound feeds

Poultry feeds should be supplied Salmonella-free.

The following requirements apply with respect to the *entry check* for feed materials:

1. The compound feed manufacturer will make the following distinction in feed materials in the production of technologically-untreated poultry feed:
 - non-Salmonella-critical feed materials can be processed without an analysis of the batch in question being available
 - Salmonella-critical feed materials (see GMP Appendix 4, sec. 2.5. Protocol 4). can only be processed if the batch in question, after sampling and analysis, appears to be Salmonella-free on the responsibility of the compound feed manufacturer
 - As an exception to this Salmonella-critical feed materials may also be processed with an analysis result for the batch in question not being available if it is made demonstrable that the feed material in question is from a specific manufacturer (=origin) and/or has undergone a specific treatment and therefore complies with the norm 'non-Salmonella-critical'.

¹ This relates to a number of extra critical points in the logistical process in addition to the critical points in the production process specified in A2.

Before this exception clause can be used at least 10 consecutive deliveries must be Salmonella-negative.

After this, every 5th batch must be sampled and analysed with a negative result. In the event of a positive result each batch must again be sampled and analysed until 10 consecutive deliveries are found to be Salmonella-negative.

2. Method of sampling of feed materials:

- Salmonella-critical and non-Salmonella-critical feed materials are both sampled in the manner described in § 6 of this protocol P1.
- Sampling is done on the responsibility of the compound feed manufacturer. (N.B. the sampling may take place elsewhere, for example during the loading of the feed material)
- For batches of up to 100 tons, at least 1 sample is taken and for batches of more than 100 tons at least 5 samples are taken. For the latter a mix sample may be made for the analysis.

The following requirements apply with respect to the *process control* during the production of poultry feeds:

3. Each company has its own responsibility and specifies the (representative) critical points for its own business situation and determines a minimum sampling plan. A process diagram should be part of the sampling plan. This shows the critical points for the process control.

The critical points in the production process for recontamination of Salmonella may, for example, be:

- Internal transport from the intake point
- Each point in the production line after the grinder/mixer where recontamination of the product by, for example, dust, enzymes, wheat may occur.
- Inside of the ready product silo on the top.
- Each point after the production line where recontamination can occur such as open places, loading.
- Transport of the ready product to the client.

A representative number of samples should be taken from the critical locations in the production process and these should be examined for the presence of Salmonella with a minimum of 5 per production line.

4. With respect to sampling (where applicable) the sampling protocol applies as specified in § 6 of this Protocol P1. Where the necessary quantity of sampling material (dust and residues of feeds) can not be obtained (because of dust, means of transport, for example) use may also be made of the sponge/swabbing method where a minimum of 200 cm² is taken (sponged/swabbed).
5. The frequency of examination for these critical points must be once per month and if this is negative for a half year then the frequency can be reduced to once per two months. The critical points must be examined for Salmonella. In the event of a positive finding sampling and analysis must be done again once per month for at least half a year. The positive samples must be classified in accordance with Appendix 1.

6. In the event of contamination immediate corrective measures will be taken until there is demonstrable compliance with the norms.
7. At the request of the poultry farmer the examination data related to the above will be made available to him or her by the compound feed manufacturer.

4.4 Poultry compound feeds (end products)

The sampling and analysis of the distinguishable types of end product must be done in accordance with the minimum frequency (per company unit) indicated in the table below.

Type of compound feed	Minimum inspection frequency, calculated per 24-ton delivery
Top breeding ²	1 in 2 batches (50%)
Raising increase ³	1 in 5 batches (20%)
Increase ³	1 in 10 batches (10%)
Broilers	1 in 20 batches (5%)
Laying-hens and breeding hens	1 in 20 batches (5%)
Raising increase turkeys	1 in 5 batches (20%)
Increase turkeys	1 in 10 batches (10%)
Meat turkeys	1 in 30 batches (3 1/3%)

5. Additional corrective measures in the event of a Salmonella-positive result

-

6. Sampling method

Samples of feed materials for the entry check will be taken on reception in as proper a way as possible.

The samples of end product for process control on the basis of Enterobacteriaceae must be taken at a point that is as close as possible before loading the bulk container (or the filling of the sacks). The size of the samples to be taken is at least 60 grams, sufficient to compose a sample and a duplicate sample of 25 grams each.

The samples of compound feed or feed materials intended for single feeding should be taken from the product flow at a point as close as possible before the loading of the bulk container (or the filling of the sacks), or, in the event of process control, as close as possible to the critical point in the process.

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle "Inspection Methods".

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of Salmonella or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

² meat and egg sectors, respectively

³ If, during an uninterrupted period of 2 years inspection of the type of feed in question, no Salmonella-positive sample is found then a minimum sampling frequency may be used of 1 in 30 batches (3 1/3%) .

8. Reporting analysis results

8.1 Undesirable Substances and Products Database of the Product Board

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.

<http://dos.pdv.nl/>

8.2 Certification Body

Each Salmonella-positive result in the compound feed should be reported immediately after the result is made known. The company should also initiate an investigation for every Salmonella-positive result, take measures and immediately send a report to its certification body.

If within three months there is a repeat case of a Salmonella-positive result in a feed material intended for single feeding is observed then the company should immediately enter into consultation with its certification body on the effectiveness of the measure taken.

For every observation of Salmonella enteritidis (S.e.) and Salmonella typhimurium (S.t.) in compound feed for the egg sector there should be immediate consultation with the certification body about the effectiveness of the previous measure.

2.3 Protocol P2: Monitoring for Salmonella and enterobacteriaceae in compound feeds intended for pigs, cattle and other animal species (with the exception of poultry)

1. Target group

Manufacturers of other compound feeds including manufacturers of mixes of wet by-products than those intended for poultry.

2. Products

Other compound feeds and the feed materials processed in them including mixes of other wet by-products than those intended for poultry

3. General additional conditions

If a Salmonella-positive result is obtained then this should be classified in accordance with Appendix I.

4. Inspection frequency

The inspection of the distinguishable types of end product must be done in accordance with the minimum frequency (per company unit) indicated below. This depends on the treatment the product has had.

4.1 Salmonella reduction treatment

In the event of Salmonella-reducing treatment, testing for Enterobacteriaceae and/or Salmonella must be carried out.

4.1.1 Salmonella

If it is decided to test for Salmonella then the test should take place as follows.

Samples should be taken of feed materials and compound feeds for analysis for Salmonella. The basic principle is that at least half of the sampling should be on compound feed and the remainder from the most critical feed material and the non-salmonella-critical feed material in the judgement of the company.

The following table clarifies the number of samples to be taken.

Annual production of compound feed for other types of animal than poultry by business unit (for wet mixes: quantities of dry substance)	Number of samples per quarter
up to 2.000 tons	2
up to 4.000 tons	2
up to 6.000 tons	3
up to 8.000 tons	4
up to 10.000 tons	5
up to 20,000 tons	10
up to 30.000 tons	15
up to 40.000 tons	20
more than 40,000 tons	25

4.1.2 Enterobacteriaceae

If testing for Enterobacteriaceae has been opted for then this must be done per production line on which Salmonella-reducing treatment is carried out, through:

- sampling and analysis twice a year at the critical points in the production process in order to determine the course of the level of Enterobacteriaceae to test the production process (thermal treatment);
- 5 samples per quarter of end product per line and analysis of these samples.

In addition, at least twice a year, sampling and analysis for Salmonella must take place at critical points in the production process.

4.2 No Salmonella-reducing treatment

If no Salmonella-reduction treatment takes place then there should be an inspection as intended in § 4.1.1.

5. Additional corrective measures for a Salmonella-positive result

If a sample of end product or feed material is found to be Salmonella-positive then sampling and analysis for Salmonella should be carried out at critical points in the production process.

6. Sampling method

The samples of compound feed or feed materials intended for single feeding should be taken from the product flow at a point as close as possible before the loading of the bulk container (or the filling of the sacks), or, in the event of process control, as close as possible to the critical point in the process. The samples of end product for process control on the basis of Enterobacteriaceae must be taken at a point that is as close as possible before loading the bulk container (or the filling of the sacks). The quantity of the samples to be taken is at least 60 grams, sufficient to compose a sample and a duplicate sample of 25 grams each.

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle “Inspection Methods”.

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of Salmonella or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Reporting analysis results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.
<http://dos.pdv.nl/>

2.4 Protocol P3: Monitoring of feed materials intended for other livestock companies (not intended for poultry)

1. Target group

Producers and suppliers of feed materials intended for livestock farms (except poultry farms)

2. Products

Feed materials intended for livestock farms (with the exception of poultry farms), with the exception of primary agricultural products such as raw feeds and forage products such as:

- grains,
- untreated potatoes,
- (feed)beets, beet tails
- stubble heads and feed crops for cattle
- legumes
- wastage of vegetables and fruit (auctions)
- grass, Lucerne, grass silage and hay
- grain straw, grass seed straw and other types of straw
- (feed) beet leaf and heads
- Sprouts stems
- green maize
- grain maize
- corn cob mix (CCM), silaged

3. General additional conditions

In the case of seasonal or incidental products, a sample is taken from the first batch at the start of the production. The fixed inspection frequency is then maintained from then on.

If a Salmonella-positive result is obtained then this should be classified in accordance with Appendix I.

4. Inspection frequency

As a replacement for Salmonella testing, the participant can also carry out tests on one of the following parameters.

The participant takes one sample per quarter, per product, per supplier and has it tested for one of the applicable parameters, namely:

- pH
- delivery temperature
- Enterobacteriaceae:
- mould

In the event of the pH being measured and there is compliance with the maximum pH as specified in Appendix 1 Product Norms, monitoring for Salmonella is not mandatory.

If the producer already carries out these tests, they can replace the trader's own tests, on the condition that these results are present at the company and the results are not older than one year.

5. Additional corrective measures in the event of the norm being exceeded

In the event of violation of the norm, a new sample is taken from the same batch within 14 days and tested for the contaminant in question. If this is no longer possible, a new batch of the same origin must be sampled and analysed. This should be repeated after 14 days, a return to the regular testing can take place after two good results.

6. Sampling method

The samples of feed material intended for single feeding must be taken from the product flow, at a point that is as close as possible before loading the bulk container (or the filling of the sacks). The size of the samples to be taken is at least 60 grams, sufficient to compose a sample and a duplicate sample of 25 grams each.

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle "Inspection Methods".

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of Salmonella or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Reporting analysis results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.

<http://dos.pdv.nl/>

2.5 Protocol P4: Monitoring of Salmonella-Critical Feed Materials (Raw Materials)

Introduction

On the basis of the monitoring data for the 'output check' from producers / importers / shipping agents of feeds and the 'input check' of the GMP+-certified compound feed manufacturers the Animal Feed Product Board maintains a yearly list of Salmonella-critical feed materials.

Salmonella-critical feed materials

The following feed materials have currently been assessed as Salmonella-critical:

- South American Soya meal and flakes
- Untreated⁴ fishmeal,
- Rape seed meal and flakes
- Roasted soya beans
- European sunflower seed meal
- French wheat bran and
- Eggshells

⁴ This is fishmeal which has not had any Salmonella-killing treatment.

2.5.1 Protocol P4a: Monitoring South American Soya meal and flakes

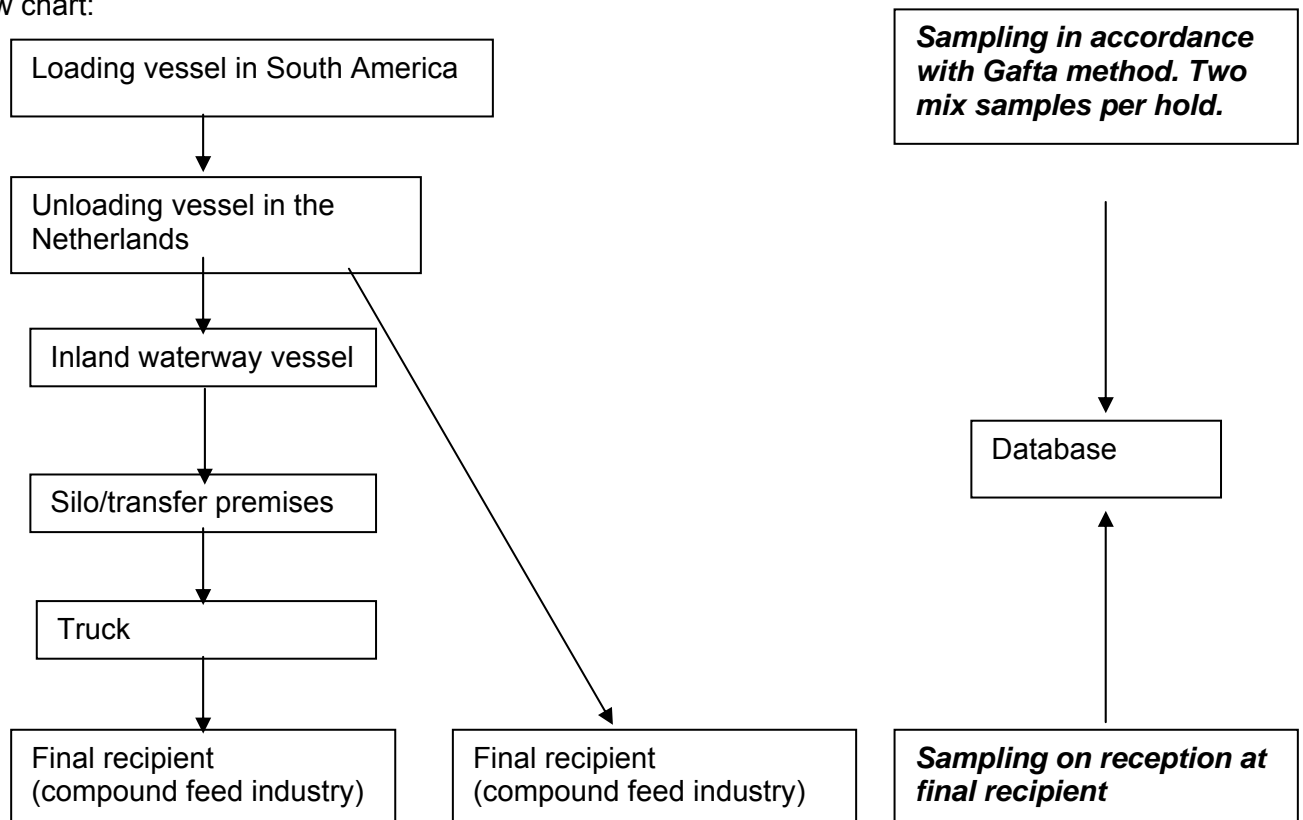
1. Target group

Suppliers of South American Soya meal or flakes (especially shipping agents / shippers) who deliver to participants in the GMP⁺ certification scheme.

2. Products

Soya meal and flakes produced in South America (incl. pellets).

Flow chart:



3. General additional conditions

If a Salmonella-positive result is obtained then this should be classified in accordance with Appendix I.

4. Inspection frequency

During loading of ship:

A sample should be taken in the loading port during loading of the ship with Brazilian Soya meal or flakes (shipper/ shipping agent).

From each hold in question (of 8,000 to 10,000 tons) at least two representative final samples are made up and inspected for Salmonella.

5. Additional corrective measures

-

6. Sampling method

During loading of ship:

- for each 500 (m) tons at least 20 random sub-samples, via 'grabs/scoops' of max. 1 kg.
- composition and mixing of all the sub-samples into 1 collective sample per hold
- at least 2 final samples to be taken from the (mixed) collective sample.

Extra conditions in addition to the above for sampling for Salmonella:

Sampling location:	As close as possible to the receiving hold (preferably in the product flow)
Instructions to personnel:	As much as possible direct from the product flow. Use sampling scoop disinfected with alcohol If the scoop is not used then store in protective bag. Use gloves for personal hygiene. Store interim samples in PE bags
Equipment:	Scoop – of stainless steel. Alcohol 95% to clean scoop in the flame
Bottles:	Sterile glass or PET of 500 CC <u>or</u>
Bags:	PE bags of 1.5 litres.
Samples:	Store interim samples as above. Mix in sterile location and in sterile conditions. Send in sterile bottle or bag as described above. Avoid contact with heat / sunlight / damp / equipment. Send samples immediately.

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle “Inspection Methods”.

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of Salmonella or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Reporting analysis results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.

<http://dos.pdv.nl/>

2.5.2 Protocol P4b: Monitoring untreated **Fout! Bladwijzer niet gedefinieerd.** fishmeal,

1. Target group

Suppliers of fish meal.

2. Products

Untreated **Fout! Bladwijzer niet gedefinieerd.** fishmeal

3. General additional conditions

If a Salmonella-positive result is obtained then this should be classified in accordance with Appendix I.

The country of production for the fish meal should always be reported to the customer when the feed is delivered.

4. Inspection frequency

A sample should be taken and analysed before the point of import into the European Union or the point of unloading from the ship with untreated fishmeal (importer)

On reception in the EU sea port / during or after unloading of ship into silos (from 200-600 tons) or inland waterway vessels / barges (from 600-1500 tons):

Basic regime: Every ship

Sampling and examination for Salmonella will be done by the veterinary authorities.

5. Additional corrective measures

If a batch of fish meal from outside the EU has a salmonella-positive result during import control then this batch should be decontaminated (heat treatment or chemical treatment) and should be Salmonella-negative when re-examined before the batch is allowed into EU trade.

6. Sampling method

On reception in the EU sea port / during or after unloading of ship into silos (from 200-600 tons) or inland waterway boats / barges (from 600-1500 tons):

During or after unloading per silo or inland waterway vessel / barge into which reception takes place:

minimum 25 sub-samples of c. 25 grams, for the first 250 (m)ton;
for every 50 (m)ton extra, 5 extra samples.

(Possible) composition of collective samples from the sub-samples in question.

Final samples: Every sample examined for Salmonella (more than one per silo or inland waterway vessel or barge) should be Salmonella-negative before the batch may be accepted into EU trade.

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle “Inspection Methods”.

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of Salmonella or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Reporting analysis results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.

<http://dos.pdv.nl/>

2.5.3 Protocol P4c: Monitoring of Rape Seed Meal and Flakes

1. Target group

Manufacturers of rape seed meal and flakes.

2. Products

Rape seed meal and flakes

3. General additional conditions

At the production location there should be a list showing the following details:

- number of vehicles loaded
- the quantity delivered per ship
- which vehicles were sampled
- the number of samples per ship
- date of sending samples to the laboratory
- results (and the classification if Salmonella-positive).

This list will be filed and made available on request to the inspector of the supervising body.

If a Salmonella-positive result is obtained then this should be classified in accordance with Appendix I.

4. Inspection frequency

For each production location at least one sample per delivery day will be examined during loading (from the factory) for the presence of Salmonella.

5. Additional corrective measures

-

6. Sampling method

Per production location a sample of at least 25 grams will be taken per vehicle of the first delivery of the day and then of every fourth vehicle delivery. If ships are being loaded then a sample should be taken per 500 tons or part thereof.

The sample material will be scooped from the product flow during loading and will be packed in sterile sample pots. The manufacturer sends the samples within 2 working days of the sample being taken and gives the laboratory the order to make a mix sample of the material and to have it analysed.

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle “Inspection Methods”.

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of Salmonella or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Reporting analysis results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.
<http://dos.pdv.nl/>

2.5.4 Protocol P4d: Monitoring of roasted Soya beans

1. Target group

Producers of roasted Soya beans (toasters).

2. Products

Roasted Soya beans

3. General additional conditions

At the production location there should be a list showing the following details:

- number of vehicles loaded
- the quantity delivered per ship
- which vehicles were sampled
- the number of samples per ship
- date of sending samples to the laboratory
- results (and the classification if Salmonella-positive).

This list will be filed and made available on request to the inspector of the supervising body.

If a Salmonella-positive result is obtained then this should be classified in accordance with Appendix I.

When delivering feed materials the name of the producer and the country of production (and possibly the production location) of the roasted Soya beans should be specified to the customer.

4. Inspection frequency

For each production location at least one sample per delivery day will be examined for the presence of Salmonella.

5. Additional corrective measures

-

6. Sampling method

Per production location a sample of at least 25 grams will be taken per vehicle of the first delivery of the day and then of every fourth vehicle delivery. If ships are being loaded then a sample should be taken per 500 tons or part thereof.

The sample material will be scooped from the product flow during loading and will be packed in sterile sample pots. The manufacturer sends the samples within 2 working days of the sample being taken and gives the laboratory the order to make a mix sample of the material and to have it analysed.

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle “Inspection Methods”.

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of Salmonella or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Reporting analysis results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.
<http://dos.pdv.nl/>

2.5.5 Protocol P4e: Monitoring of Eggshell

1. Target group

Producers of eggshells, being the egg processing industry which is registered and approved in accordance with EU Directive 89/437.

2. Products

Dried eggshells.

3. General additional conditions

At the production location there should be a list showing the following details: the number of vehicles loaded, which vehicles were sampled, date of consignment of samples to the laboratory and the result (and the classification if Salmonella-positive). This list will be filed and made available on request to the inspector of the supervising body.

If a Salmonella-positive result is obtained then this should be classified in accordance with Appendix I.

4. Inspection frequency

For each production location at least one sample per delivery day will be examined during loading (from the factory) for the presence of Salmonella.

5. Additional corrective measures

-

6. Sampling method

For each production location one sample will be taken for each vehicle axle from each load.

The sample material will be scooped from the product flow during loading and will be packed in sterile sample pots. The quantity of the samples to be taken is at least 60 grams, sufficient to compose a sample and a duplicate sample of 25 grams each. The producer will send the samples within 2 working days after taking the samples and will order the laboratory to:

- to make a mixed sample from the material if there are multiple samples per delivery day
- to analyse a single final sample for each delivery day.

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle "Inspection Methods".

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of Salmonella or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Reporting analysis results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.

<http://dos.pdv.nl/>

2.5.6 Protocol P4f: Monitoring of European sunflower seed meal

1. Target group

Manufacturers of European sunflower seed meal.

2. Products

European sunflower seed meal

3. General additional conditions

At the production location there should be a list showing the following details: the number of vehicles loaded, which vehicles were sampled, date of consignment of samples to the laboratory and the result (and the classification if Salmonella-positive). This list will be filed and made available on request to the inspector of the supervising body.

If a Salmonella-positive result is obtained then this should be classified in accordance with Appendix I.

When delivering animal feeds the name of the producer and the country of production (and possibly the production location) and the products of the customer should be specified.

4. Inspection frequency

For each production location at least one sample per delivery day will be examined for the presence of Salmonella.

5. Additional corrective measures

-

6. Sampling method

Per production location a sample of at least 25 grams will be taken per vehicle of the first delivery of the day and then of every fourth vehicle delivery.

The sample material will be scooped from the product flow during loading and will be packed in sterile sample pots. The producer will send the samples within 2 working days after taking the samples and will order the laboratory to:

- to make a mixed sample from the material if there are multiple samples per delivery day;
- to analyse a single final sample for each delivery day.

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle “Inspection Methods”.

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of Salmonella or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Reporting analysis results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.
<http://dos.pdv.nl/>

2.5.7 Protocol P4g: Monitoring of French wheat bran

1. Target group

Manufacturers of French wheat bran.

2. Products

French wheat bran

3. General additional conditions

At the production location there should be a list showing the following details: the number of vehicles loaded, which vehicles were sampled, date of consignment of samples to the laboratory and the result (and the classification if Salmonella-positive). This list will be filed and made available on request to the inspector of the supervising body.

If a Salmonella-positive result is obtained then this should be classified in accordance with Appendix I.

When delivering animal feeds the name of the producer and the country of production (and possibly the production location) and the products of the customer should be specified.

4. Inspection frequency

For each production location at least one sample per delivery day will be examined for the presence of Salmonella.

5. Additional corrective measures

-

6. Sampling method

Per production location a sample of at least 25 grams will be taken per vehicle of the first delivery of the day and then of every fourth vehicle delivery.

The sample material will be scooped from the product flow during loading and will be packed in sterile sample pots. The producer will send the samples within 2 working days after taking the samples and will order the laboratory to:

- to make a mixed sample from the material if there are multiple samples per delivery day;
- to analyse a single final sample for each delivery day.

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle “Inspection Methods”.

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of Salmonella or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Reporting analysis results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.
<http://dos.pdv.nl/>

3 OTHER MONITORING PROTOCOLS

3.1 Protocol P5: Monitoring of Feed Materials and Wet Mixes Intended for Livestock Farms

Is expired.

3.2 Protocol P6: Monitoring of Aflatoxin B1

1. Target group

Compound feed manufacturers and suppliers of feed materials for dairy cattle.

2. Products

Feed materials for dairy cattle or for the preparation of compound feeds for dairy cattle.

3. General additional conditions

-

4. Inspection frequency

The following sampling and analysis schedule must be used for testing for Aflatoxin B1 in feed materials for dairy cattle and for the manufacturing of compound feeds for dairy cattle.

A participant which delivers the following feed materials in single form to dairy farmers must provide the dairy farmer with the analysis certificate of the said (origin) batch, or of the testing based on his own sampling.

A participant which delivers compound feeds for dairy cattle must upon purchase or receipt of the following feed materials have an analysis certificate, supplied by the supplier of the said (origin) batch, or of the testing on the basis of his own sampling.

Feed materials class 1	All batches must be tested, whereby the analysis must concern (origin) batches of no more than 500 tons
	<p>The following come into this category:</p> <ul style="list-style-type: none">- Ground nut flakes and scraps, all origins- Kapok seed flakes, all origins- Cotton seed flakes and scraps, all origins- Coconut (by-)products, all origins- Maize and maize by-products, all origins except USA and EEC- Palm kernels and palm kernel by-products, unknown origin- Safflower seed scraps, all origins

Feed materials class 2	All batches must be tested, whereby the analysis must concern (origin) batches of no more than 3,000 tonnes
	The following come into this category: <ul style="list-style-type: none"> - Palm kernels and palm kernel by-products, all known origins except Indonesia and Malaysia - Rice by-products, all origins

5. Additional corrective measures in the event of deviations

-

6. Sampling method

-

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle “Inspection Methods”.

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of Aflatoxin B1 or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Provision of results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.

<http://dos.pdv.nl/>

3.3 Protocol P7: Monitoring of Animal Proteins

1. Target group

Manufacturers of compound feeds including wet mixes for ruminants.

2. Products

Compound feeds including wet mixes for ruminants.

3. General additional conditions

-

4. Inspection frequency

The following numbers of samples from feeds for ruminants must be taken for the microscopic tests for the presence of tissue proteins from mammals.

Inspection table per production location for BSE control

Production in tons per year	Samples / Quarter
< 5,000	1
5,000 < < 10,000	1
10,000 < < 20,000	2
20,000 < < 30,000	2
30,000 < < 40,000	2
> 40,000	3

5. Additional corrective measures in the event of the norm being exceeded

In accordance with animal feed legislation.

6. Sampling method

-

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle "Inspection Methods".

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme for the determination of animal proteins or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Provision of results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.

<http://dos.pdv.nl/>

3.4 Protocol P8: Monitoring of Palm Oil

1. Target group

Companies who receive cif lots of unrefined palm oil.

2. Products

Unrefined palm oil

3. General additional conditions

The palm oil which falls under this protocol must be of good merchantable quality (GHK or Good Merchantable Quality –GMQ-) as laid down in Fosfa contracts. The protocol applies to CIF contracts.

The GMP⁺ quality of palm oil for animal feed is guaranteed by a system of entry checks on import in accordance with this protocol. The main features of this are:

- entry check in the Netherlands on the basis of a risk analysis of the previous links; this means that:
 - an analysis per ships tank for possible diesel contamination and
 - a monitoring programme for pesticide residues, dioxin and heavy
 - metals will be introduced.

- quality assurance of palm oil in accordance with the Fosfa conditions; this means, among other things:
 - the obligation that the batches supplied must be of good merchantable quality (“GMQ”)
 - a list of permitted immediately preceding cargoes during sea transport
 - the use of steam and hot water as a heating agent during sea transport
 - effective cleaning of ships tanks
 - loading and unloading inspection during sea transport by certified inspectors
 - sampling in accordance with ISO methods
 - tracing back to land tanks in the export ports

- that batches which appear to be unsuitable for processing as animal feeds and foodstuffs, are kept outside these chains in the manner described in the VERNOF-document “Procedure for the disposal of contaminated oils and fats including conditions for sale by tender” of March 1990.

4. Inspection frequency

4.1 Entry check

4.1.1 Quality assurance of sea transport

During sea transport the rules apply as laid down in the manual "Fosfa qualifications and procedures for ships engaged in the carriage of oils and fats in bulk for edible and oleochemical use". Fosfa is the global trading organisation for oil seeds and oils and fats.

The rules from the manual are the basis for the Fosfa-80 contracts for CIF delivery of palm oil. With respect to quality, these rules include, among other things:

- the obligation that the batches supplied must be of good merchantable quality ("GMQ")
- the use of steam and hot water as a heating agent
- effective cleaning of ships tanks
- loading and unloading inspection by certified inspectors
- sampling
- tracing back to land tanks in the export ports
- previous cargoes:
 - in loading compartments of stainless steel or which are covered with epoxy resin or with a technically equivalent coating, then
 - the first cargo which is transported in the tank should be a foodstuff or should appear on the EU list of permitted cargoes (see section 9)
 - if the palm oil is transported in a ship with tanks of materials other than specified above then the previous three loads transported in the tank should be foodstuffs or should appear on the EU list of permitted prior cargoes;

4.1.2 Check on diesel contamination

On arrival of a seagoing ship in Rotterdam each ships tank is analysed for diesel contamination.

Substance	Diesel
Rejection limit	25 mg/kg total hydrocarbons calculated as diesel oil (PG) Modification of action plan version December '04 (= 400 mg/kg) or wait for next change?
Analysis method	GC-FID or GC-MS
Additional requirements for the analysis method	The method specified includes the use of Standard "Material 106" of the Community Office of the European Commission. This method is used by the Dr Verwey laboratory which will publish its method by the end of October 2002 at the latest. MVO will then organise a ring test which is expected to be finished by mid-2003.
Inspection frequency	Per incoming batch, each ships tank

4.2 Monitoring

Substance	Pesticides residues
Rejection limit	<p>Maximum residulimieten voor pesticiden zoals vastgelegd Ongewenste Stoffenrichtlijn 2002/32/EG en zoals geïmplementeerd in de Nederlandse Kaderwet Diervoeders:</p> <ul style="list-style-type: none"> • Aldrin + Dieldrin: 0,2 mg/kg • Camphechlor: 0,1 mg/kg • Chlordane: 0,05 mg/kg • DDT: 0,5 mg/kg • Endosulfan: 0,5 mg/kg • Endrin: 0,05 mg/kg • Heptachlor: 0,2 mg/kg • Hexachlorobenzene (HCB): 0,2 mg/kg • Hexachloro-hexane: <ul style="list-style-type: none"> - alpha-isomers 0,2 mg/kg - beta-isomers 0,1 mg/kg - gamma-isomers 2,0 mg/kg <p>Een selectie van maximum residulimieten zoals vastgelegd in 1990/642/EG en geïmplementeerd in de Nederlandse Regeling van Residuen van Bestrijdingsmiddelen:</p> <ul style="list-style-type: none"> • monocrotophos: MRL op detectiegrens (0,05 mg/kg) • methamidophos: MRL op detectiegrens (0,01 mg/kg) • acephate: MRL op detectiegrens (0,02 mg/kg*) • glyphosate: MRL op detectiegrens (0,1 mg/kg) • metsulfuron methyl: MRL op detectiegrens (0,05 mg/kg**) • deltamethrin: MRL op detectiegrens (0,05 mg/kg) • cypermethrin: MRL op detectiegrens (0,05 mg/kg) • glufosinaat: MRL op detectiegrens (0,05 mg/kg) <p>* Detectiegrens volgens EU richtlijn 90/642: 0,05 mg/kg ** Detectiegrens volgens EU richtlijn 90/642: 0,1 mg/kg</p>
Analysis method	NEN-EN 1528-1/4:1997
Additional requirements for analysis	GMP B10 certification or equivalent. The method must be proven for use with unrefined vegetable fats and oils.
Inspection frequency	Every six months

Substance	Dioxin
Rejection limit	0.75 ng WHO-PCDD/F-TEQ/kg
Analysis method	Laboratories should comply with the directives on dioxin as laid down by the European Commission (Directive 2002/70/EC).
Inspection frequency	Once per 6 months, varying origins

Substance	Heavy metals
Rejection limit	Lead: 10 mg/kg Cadmium: 1 mg/kg Arsenic: 2 m/kg Mercury: 0.1 mg/kg
Analysis method	Lead: NEN-EN-ISO 12193 Cadmium: ISO 15774 Arsenic and Mercury: Atomic Absorption Spectrophotometry (AAS)
Additional requirements for analysis	GMP B10 or Nofota certification or equivalent. The method must be proven for use with unrefined vegetable fats and oils.
Inspection frequency	Once per year

5. Additional corrective measures in the event of the norm being exceeded

Batches which do not comply with the Fosfa provisions will be kept outside the food and animal feed chain as described in the VERNOF-document "Procedure for the disposal of contaminated oils and fats including conditions for sale by tender" of March 1990.

6. Sampling method

Sampling in accordance with NEN-EN-ISO method 5555.

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle "Inspection Methods".

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme, by a certified laboratory or laboratory deemed to be an equivalent by the Product Board Animal Feed.

As far as the methods to be used are concerned, the laboratory may deviate from the methods laid down by the Product Board Animal Feed if it can be shown that the non-standard method has at least the same performance characteristics (determination limit, repeatability, reproducibility, etc.).

8. Provision of results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.

<http://dos.pdv.nl/>

9. Background information

Palm oil is important in the achievement of satisfactory fat consistency in the pig carcass which is less likely with other vegetable fats. Palm oil comes mainly from Malaysia and Indonesia. The sales of raw palm oil to the GMP+ compound feed manufacturers has stabilised at a level of 40 to 60,000 tons per year.

This volume amounts to less than 0.5% of the total exports of the oil from these countries. The total import volume of palm oil into the Netherlands grew in 2004 to more than 1 million tons. The import of raw palm oil for animal feed purposes therefore represents only a fraction of that for other applications such as foodstuffs, personal care products, washing powders and, recently, power generation.

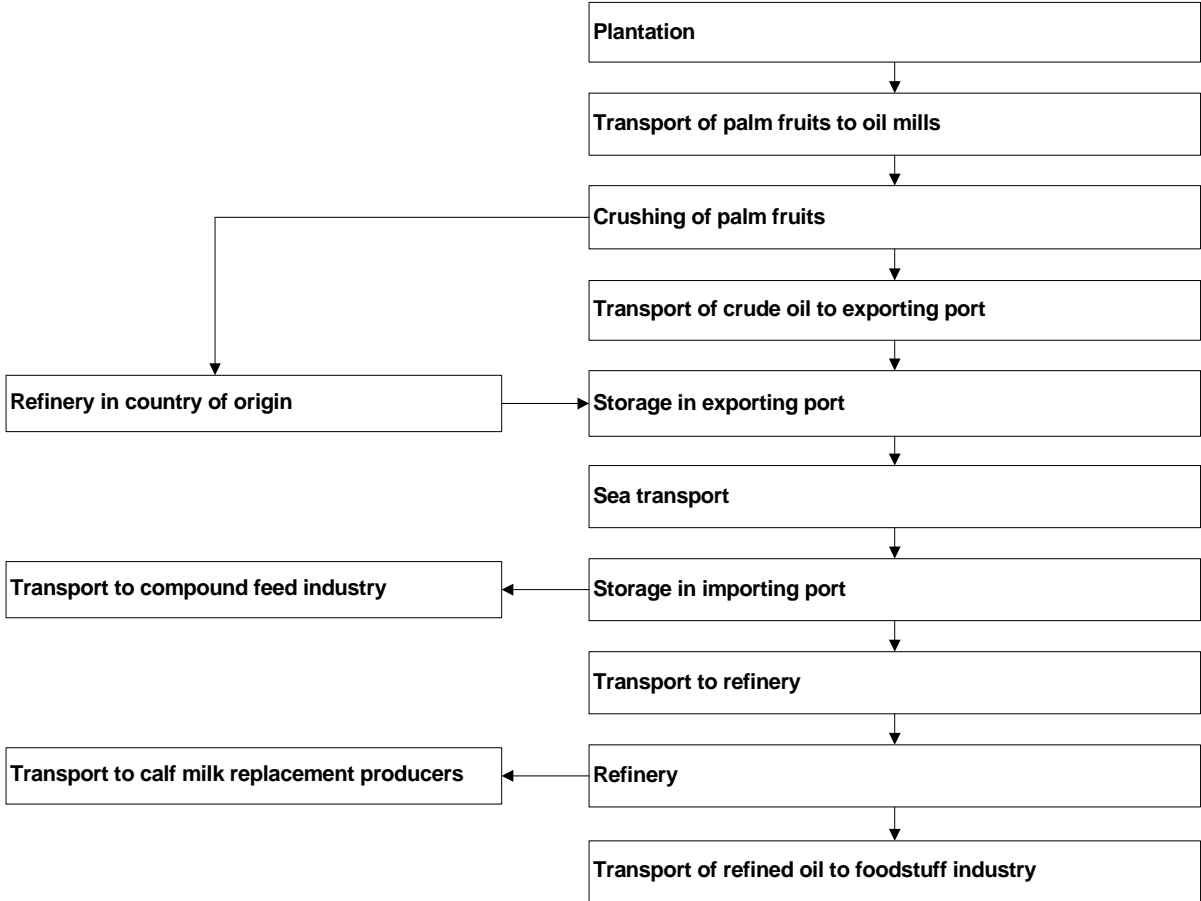
The objective is for all suppliers to be certified by an independent agency recognised for that purpose by the Product Board Animal Feed for one of the forms of quality assurance specified in the introduction.

The market position of the Dutch animal feed sector is insufficiently strong to be able to impose verifiable GMP+ requirements for palm oil on the market players in the countries of origin. This also currently applies, by the way, for the processors of palm oil for animal feed purposes (refinery industry) in the Netherlands. These parties guarantee the feed safety of palm oil by subjecting the product on being imported to the Netherlands to an entry check on the basis of a risk analysis of the links in question. Part of this is the use of worldwide standards for the safe transportation of palm oil by sea in the form of the so-called FOSFA contracts. Dutch power companies also make use of these contracts during the purchase of raw palm oil which marginalises the chances for a relatively small player such as the Dutch (or European) animal feed industry to set up its own palm oil flow

There is currently work at the European level on drawing up requirements for process and product checks in the countries of origin. The intention is that these requirements will be gradually introduced with proper inspection on the spot being a major item for attention. The first step in this process is the inspection of the arrival and storage of palm oil in the export ports. About 20% of the palm oil export from Indonesia and about 10% of the palm oil export from Malaysia goes to the EU. These are volumes which should make it worthwhile for Indonesia and Malaysia to comply with the requirements which are not applicable in other export markets for these countries.

Palm oil chain flow chart:

Flow chart: Palm oil chain



3.5 Protocol P9: Monitoring of Straw

1. Target group

The manufacturer / trader of straw

2. Products

Straw

3. General additional conditions

The trader of straw carries out a monitoring programme on the basis of the generic risk analysis which complies with the requirements in this protocol. In practice this will result in a minimum number of samples to be taken on an annual basis or per batch.

4. Inspection frequency

The manufacturer/trader takes a representative sample from every batch to be delivered. He examines it in accordance with the following table. The manufacturer/trader will take into account a spread of origin in choosing the samples to be inspected.

Parameter		Number of inspections per month	Remarks
Seeds	Enterobacteriaceae	1x	
	Salmonella	1x	
DON		1x	
Heavy metals	Arsenic	1x	
	Lead	1x	
	Cadmium	1x	

5. Additional corrective measures in the event of the norm being exceeded

In the event of non-conformities above the established norm there must be an examination of the cause and the product may not be delivered.

6. Sampling method

The sampling is in accordance with or based on a relevant ISO standard for sampling or on EU directives for sampling

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle “Inspection Methods”.

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme, by a certified laboratory or laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Provision of results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.
<http://dos.pdv.nl/>

9. Background information

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3.6 Protocol P10: Monitoring of Grains, Seeds and Legumes

1. Target group

Shipper of grains, seeds and legumes (of non-EU15 origin⁵) by ship, coaster, inland waterway lighter, train or road vehicle, etc.

2. Products

Grains, seeds and legumes of non-EU15 origin⁵.

3. General additional conditions

Within the GMP⁺ regulation the additional GMP⁺ guarantee must demonstrably apply to the shipper. The shipper is certified as such. In the event of an origin from the 10 new Member States the supplier is also certified (for example GMP B2)

Risk analysis and batch control

The shipper carries out his own risk analysis for the preliminary process (cultivation, collection, transport) on the basis of the generic risk analysis which was published on the Product Board Animal Feed website. The generic risk analysis for grains, seeds and legumes shows that the following risks are properly controllable but require attention:

- residues of pesticides
- microbiological quality
- mycotoxins
- heavy metals
- vermin control

On the basis of this risk assessment and the guarantees which can be provided by the previous links, the shipper makes a selection of the supplier and draws up a monitoring programme which complies with the requirements of this protocol. Among other things, a batch control is mandatory.

Attention: If the grain, seed or legume is demonstrably from a fully GMP-assured chain then this is actually a desirable situation. Each link (from the collector up to and including the end user) continues to comply with the required quality assurance and is certified for this. In this case the purchase does not have to take place in accordance with the requirements of this plan of action.

Transport and documentation

The transport of the grain, seeds and legumes should always take place in accordance with the provisions of the GMP⁺ standard for transport.

In addition to the relevant trading and other legally-required documents, the batches will also be accompanied in the event of transport by inland waterway vessel or vehicle by the relevant analysis certificates. These certificates will be reported in writing by the shipper to his customer by at the latest the moment of delivery. In many cases the analysis results will be reported long before the actual delivery to the customer.

⁵ EU 15 Member States: Belgium, Denmark, Germany, Finland, France, Greece, Ireland, Italy, Luxembourg, the Netherlands, Austria, Portugal, Spain, United Kingdom, Sweden (= the member states from before 1-5-2004)

If a final recipient (for example a compound feed manufacturer) ships the feed materials then he acts as shipper and should meet the requirements specified above.

4. Inspection frequency

4.1 Frequency of sampling and inspection

a) In the event of transport by sea-going ship, lighter, coaster or train:

Frequency of sampling: At least one representative final sample is put together for each hold in question of the ship.

In the event of transport by lighter, coaster or train one representative sample per lighter, coaster or train will be taken.

Frequency of inspection: All samples taken will be inspected (batch control)

b) In the event of transport by road vehicle:

Frequency of sampling: 1 representative sample will be taken for each road vehicle.

Frequency of inspection: Every twentieth sample will be examined.

It is possible to separate out a batch at a storage location within the framework of direct transport by road vehicle. An independent sample-taker can then, at the request of the manufacturer/supplier, take a representative sample from this batch. This sample can be examined and the results of the sample be considered representative for this batch. Direct delivery of this batch by road vehicle to the final recipient may then take place.

The following requirements apply:

- The batch may be max. 1000 tons.
- The batch should be kept at the storage location in quarantine (separated and identifiable).
- The location must be set up in such a way that representative (cross-section) samples can be taken.

4.2 Analysis

The samples specified above will be analysed using the following parameters:

Parameter	Animal Feed Act / GMP ⁺ (ppm) target value
Pesticides residues Crop protection agents ⁶	Animal feed legislation Foodstuff legislation ⁵
Heavy metals - Arsenic - Lead - Fluorine - Mercury - Cadmium	2 10 150 0.1 1
Contamination by toxic components (in the event of artificial direct drying) ⁷ Dioxins ⁸ PAHs	0.75 pg/g -
Microbiological quality Salmonella	0+ ⁹

Mycotoxins	DON ¹⁰	OTA	ZEN
Wheat	X		X
Barley	X	X	
Oats	X		
Rye	X		
Maize	X		X

5. Sampling method

In accordance with GAFTA sampling rules. Extra requirements in addition to these rules are:

Sampling location:

- As close as possible to the receiving hold (preferably in the flow)

Instructions to personnel:

- As much as possible direct from the flow.
- Use disinfected sampling scoop (alcohol)
- If the scoop is not used then store in protective bag.
- Personal hygiene: use sterile gloves.
- Store interim samples in PE (polyethylene) bags

Equipment:

- Scoop – stainless steel
- Alcohol 95% to clean scoop in the flame
- Bottles: Sterile glass or PET (Polyethylene Tubes) of 500 or
- Bags: PE bags of 1.5 litres.

⁶ The examination should be particularly focused on materials for which within the framework of EU foodstuff legislation or national legislation or regulations an MRL value has been established for meat, milk or eggs.

⁷ The examination of PAHs/dioxin is especially important in the case of direct drying. Maize in particular is often dried. If this PAH test is not carried out then the seller should show that there has been no direct drying.

⁸ Dioxins: expressed in pg/g WHO-PCDD/F TEQ in compound feed and feeds for all animals A screening using the Calux method is also permitted

⁹ GMP⁺ standards for contamination of poultry feeds: 0+ in VB/breed, 0+ in consumption chick feed, max 1% laying hen feed

¹⁰ DON= Deoxynivalenol; OTA=Ochratoxine A ; ZEN=Zeaoren

- Samples:
- Store interim samples as above.
 - Mix in sterile location and in sterile conditions.
 - Send in sterile bottle or bag as described above.
 - Avoid contact with heat / sunlight / damp / equipment.
 - Send samples immediately.

During the loading of domestic waterway vessels, coasters, trains or road vehicles:

Per inland waterway vessel, train, coaster at least 20 random sub-samples, via 'grabs/scoops' of max.1 kg.

by road vehicle at least 10 random sub-samples, via 'grabs/scoops' of max.1 kg.

The other working methods to be derived from the sampling method described above. The basic principle should be that a representative sample is taken.

6. Analysis method

The analyses will be carried out by a laboratory certified under the Labcode animal feed sector regulation for the analysis in question or by a laboratory deemed to be an equivalent by the Product Board Animal Feed.

As far as the methods to be used are concerned, the laboratory may deviate from the methods laid down by the Product Board Animal Feed if it can be shown that the non-standard method has at least the same performance characteristics (determination limit, repeatability, reproducibility, etc.).

7. Corrective action

In accordance with the GMP⁺ requirements.

8. Reporting analysis results

The results of the determinations should be supplied to the Product Board Animal Feed at least once per month via the procedure prescribed by the Product Board Animal Feed.

The instruction applies which relates to delivery of data to the Product Board Animal Feed Undesirable Substances and Products Database.

http://www.pdv.nl/nederland/kwaliteit/copy_DOS/page634.php

9. Background information

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3.7 Protocol P11: Monitoring of Intervention Grains

1. Target group

The 1st buyer of EU15⁴-intervention grains¹¹

2. Products

Intervention grains from EU15⁴-intervention grains¹⁰

3. General additional conditions

The 1st buyer (usually the shipper) is the 1st link in the GMP⁺ chain who has to be certified. Prior to the purchase of the intervention grain the 1st buyer carries out his own risk analysis based on HACCP principles in which he makes use, for as far as possible, of the generic risk analysis which is published on the Product Board Animal Feed website. On the basis of this risk assessment and also quality assurance, which is made or can be guaranteed by the intervention office, he will make a selection and adjust his entry check accordingly. This entry check complies with at least the requirements of this protocol.

Transport and documentation

The transport of the grain should always take place in accordance with the provisions of the GMP⁺ standard for transport.

In addition to the relevant trading and other legally-required documents, the batches will also be accompanied in the event of transport by inland waterway vessel or vehicle by the relevant analysis certificates. These certificates will be reported in writing by the shipper to his customer by at the latest the moment of delivery. In many cases the analysis results will be reported long before the actual delivery to the customer.

If a final recipient (for example a compound feed manufacturer) ships the feed materials then he acts as shipper and should meet the requirements specified above.

4. Inspection frequency

4.1 Sampling

In the event of transport by inland waterway vessel, coaster or train one representative sample per lighter will be taken.

- For inland waterway vessels, coasters or trains of less than 500 tons, every 10th sample will be analysed using the following parameters.
- For inland waterway vessels, coasters or trains of more than 500 tons, every 5th sample will be analysed using the following parameters.

¹¹ For grains from intervention stocks from the 10 new member states the same protocol applies as for the free market in those countries. See protocol P10.

In the event of a vehicle one representative end sample will be taken per vehicle. Every twentieth sample will be examined.

Batch sample from storage

Contrary to that which is stated above, use may also be made of a sample which is representative for a particular batch which is stored in a silo or shed (see also under 6). All sub-batches which are loaded from this batch should be provided with the batch certificate.

4.2 Analysis

The samples specified above will be analysed using the following parameters:

Parameter	Animal Feed Act / GMP ⁺ (ppm) target value
Heavy metals - Arsenic - Lead - Fluorine - Mercury - Cadmium	2 10 150 0.1 1
Contamination by toxic components (if artificial direct drying) - Dioxins - PAHs	0.75 pg/g
Microbiological quality o Salmonella	0+

Mycotoxins	DON Fout! Bladwijzer niet gedefinieerd.	OTA	ZEN
Wheat	X		X
Barley	X	X	
Oats	X		
Rye	X		
Maize	X		X

5. Additional corrective measures in the event of the norm being exceeded

-

6. Sampling method

During the loading or unloading of the inland waterway vessel, coaster, train or road vehicle

- per inland waterway vessel, train, coaster at least 20 random sub-samples, via 'grabs/scoops' of max. 1 kg.
- by road vehicle at least 10 random sub-samples, via 'grabs/scoops' of max. 1 kg.

The other method of working derives from that which is stated in Protocol P10 under Sampling. The basic principle should be that a representative sample is taken.

Batch sampling

A batch sample may represent a maximum of 5000 tons. A larger batch or lot should be split into batches of max. 5000 tons for batch sampling.

A representative sample should be taken of the batch by an independent sampler who is approved for that purpose.
The sampling should take place in accordance with the same principles as stated in Protocol P11 under Sampling¹².

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle “Inspection Methods”.

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme, by a certified laboratory or laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Provision of results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.
<http://dos.pdv.nl/>

9. Background information

-

¹² The German BLE has, for example, drawn up a sampling protocol on the basis of these principles.

3.8 Protocol P12: Monitoring of Intervention Dairy Powder

Is expired.

3.9 Protocol P13: Monitoring dioxin in poultry feeds

1. Target group

Producers of laying-poultry feeds

2. Products

Laying-poultry feeds

3. General additional conditions

-

4. Inspection frequency

The following numbers of samples from end feeds for laying poultry must be taken for the inspection of the dioxin level in the feed intended for laying poultry.

Inspection schedule per production location:

Scope of laying-poultry feed production in tons per year	Samples / Year
< 5,000	2
5,000 < < 10,000	4
10,000 < < 40,000	8
> 40,000	12

5. Additional corrective measures in the event of the standard being exceeded

If the level of dioxin in laying-poultry feed is just under the maximum norm then the participant should find the cause of this at the level of feed materials and take suitable measures to lower the dioxin level of the feed materials to be processed.

6. Sampling method

-

7. Analysis method

The method recorded in the Product Board Animal Feed documentation bundle "Inspection Methods".

The analysis will be carried out by a laboratory certified under the GMP⁺ certification scheme, by a certified laboratory or laboratory deemed to be an equivalent by the Product Board Animal Feed.

8. Provision of results

The results of the determinations should be provided at least once per month to the Product Board Animal Feed Database of Undesirable Substances and Products via the procedure prescribed by the PDV.

<http://dos.pdv.nl/>

9. Background information

A study was carried out by the RIKILT into "Carry-over of dioxins and PCB's from feed and soil to eggs at low contamination levels". This showed that during the feeding of compound feed containing the maximum limit for dioxin for these feeds, a theoretical infringement of the Maximum Residue Limit in eggs may occur. You can find more information on this at the following page: <http://www.pdv.nl/nederland/kwaliteit/page2366.php>

APPENDIX I: PROTOCOL FOR THE SEROTYPING OF SALMONELLA

Participants in the GMP+ certification scheme for the animal feed sector are obliged to classify Salmonella-positive samples of animal feeds or feed materials.

The poultry feeds, cattle feeds and pig feeds should be fully classified. The feed materials should be classified for the serotypes Enteritidis, Typhimurium, Infantis, Virchow, Hadar, Java and Agona. Classification should be carried out by the RIVM or by GMP⁺-B10 laboratory certified for the serological classification of Salmonella. The costs of classification will be charged to the (animal feed) company.

The procedure is as follows:

- New companies participating will report once only to the RIVM at telephone number 030-2742126.
- The RIVM will then send you a transmission medium as quickly as possible including packaging material. This is the standard RIVM packaging with white/pink forms. These forms must be replaced by the green forms for the animal feed project. These forms will be sent to newly registered companies separate from the packaging material.
- The packaging material and the new transmission medium will be returned to the sender after each submission. The green forms can be requested each time by telephone at telephone number 030-2742126. The participants who regularly submit a green form to the RIVM must from today also order these forms by telephone.
- The green RIVM form should be fully completed and sent to the RIVM together with the identified salmonella culture. The form should contain the following details:
 - o Name/address/place of the sender;
 - o Company ordering the sampling of the product (possibly in code form);
 - o Type of feed or fodder from which the salmonella was isolated;
 - o Country of origin of the feed.

For the first consignment the technique for isolating Salmonella should be specified once and also any future changes in the technique used.

PART B: PROTOCOLS FOR THE MEASUREMENT OF CARRY-OVER

1. INTRODUCTION

Section 7.12.1.4 of GMP⁺ standard B 1 requires, among other things that a participant who processes E¹³additives or veterinary medical products must measure the carry-over of the installation. This is necessary to be able to control the residue levels of additives and veterinary medical products as laid down in Appendix 1, part B (see section 7.7 of GMP⁺ standard B1).

During measurement the participant must make use of the protocols in this part of the appendix.

The reporting on the carry-over inspection must comply with further conditions. See below for a description of the methods. (see chapter 2, section: Inspection report)

N.B. In anticipation of a review of the carry-over methods, it is permissible for companies to deviate from the method laid down as long as the principle is not affected and there is a real probability that equivalent results will be obtained.

¹³ *By E-additives is meant those additives which are included in Group E (Regulation EU 1831/2003, Article 6, subsection 1e).*

2. METHODS FOR MEASURING CARRY-OVER

2.1 GENERAL BASIC PRINCIPLES WITH RESPECT TO THE MEASUREMENT OF CARRY-OVER

When measuring the carry-over of additives in an installation there must be a prior examination using the diagram and the actual situation in the factory of which parts of the factory may be relevant for carry-over.

A basic principle in determining carry-over in a company is that the degree of carry-over as a result of return flows is known and is controlled.

Carry-over points

Carry-over in a (compound feed) factory may occur in the following processes.

1. The filling of premix silos

The filling of the premix silos may be the cause of carry-over. The diagram can be used to find out whether there are reasons to suppose that carry-over occurs here. Critical points are common transport systems, chutes, separation systems and filters.

In mechanical transports such as mass transports, elevators and screw conveyors, carry-over always occurs and it is sensible to measure this carry-over. Also, sufficiently long idle times (10 minutes) should be taken into account.

For the pneumatic filling method with separate filters for each silo, no account needs to be taken of carry-over. If there is a common filter then the filter must, for at least 10 minutes after unloading, be knocked on the same silo as that in which the filling took place.

There should be an instruction for the dumping sequence so that undesired mixing does not take place.

In this situation it must be certain that unacceptable residue levels (see Appendix 1, part B) no longer occur.

2. Dosage, grinding and mixing line

The greatest amount of carry-over of additives and veterinary medical products occurs in the dosage process (addition of additives or veterinary medical products) / (possibly grinding) / mixing / transport and storage of the product in meal form in a finished product cell or a pressed meal cell.

The place where premixes are added should be as close to the mixer as possible. It is important that the measured substance is added at the same place as where the additive and veterinary medical products were added.

3. Press line

A considerable amount of carry-over can occur in the press line. The carry-over increases as the press moulds are bigger. In addition, interim bunkers containing stocks can be a source of carry-over.

An item for attention is the return flows which are brought back directly into the pressed meal silo during pelletising.

4. Loading and transport

During storage, loading and transport of a finished product there will only be carry-over of any importance for highly critical additives and veterinary medical products (for example nicarbazine and sulfa-veterinary medical products). In these cases a mandatory working sequence should be used.

An item for attention is the processing of the sievings from the bulk load. Possible processing of such sievings must at least comply with the animal feed legislation and must therefore be processed in a careful and controlled fashion. Any sievings of medicated feed may not be reprocessed.

If the undesired carry-over of critical additives and veterinary medical products may be expected then company may take the following measures:

- a. the drawing up of a mandatory production (working) sequence
- b. additional measures in the event of product changes
- c. the production of feeds with critical additives and veterinary medical products on another line
- d. switching to less critical agents.

Measurement points for carry-over

The major causes of carry-over are the dosage / grinding / mixing line and the press line. The carry-over should be known if both feeds with critical additives and veterinary medical products as feeds with a maximum carry-over level are produced on these lines. In order to establish this reliably the following measurement points are important:

After the mixer, but as close as possible to the mixer for the measurement of the output content of the mixer:

- a. at the entry to the pressed meal cell in grain production or the finished product cell in meal production, for the measurement of the carry-over on the dosage / grinding / mixing line
- b. at the entry to the finished product cell in grain production for the measurement of carry-over on the press line.

Carry-over which is determined in this way is considered to be the installation carry-over.

Possible measurement substances

For the sake of reliability it is important to choose a measurement substance which can also be analysed properly at low levels. The following measurement substances are permitted. An indication is also given of to what degree of accuracy these means can be used to determine the carry-over in an installation.

Method	Chapter	Lower limit ¹⁴ of carry-over inspection accuracy in %
Cobalt chloride 100 ppm	2.2	1
Cobalt sulphate		
- 100 ppm	2.3.1	1
- 50 ppm	2.3.2	3
- 25 ppm	2.3.3	5
Protein/Manganate	2.4	
FSS-Lake 100ppm	2.6	1
F-Lake 100 ppm	2.6	1
FSS-Lake 10 ppm	2.6	1
Methyl violet	2.7	1

Chapter 2.5 includes a method for the measurement of the carry-over for the production system for premixes and additives

Inspection report

Good reporting on the inspection is important to be able to apply the results unambiguously when determining measures and during supervision of the correct implementation. This should be based on a well thought out and properly described protocol which has been talked through in advance with those who will implement it and on a careful implementation of this protocol. At least the following items should therefore be laid down.

- date
- who is responsible for the carry-over inspection
- description of the method used
- a plan of the installation with an indication of
 - o grinding, mixing and press lines which were inspected
 - o the place where the measured substance was added
 - o sampling points
- the number and size of the samples
- the sampling time interval
- analysis results
- proper calculation of the carry-over
- any sample pre-handling such as grinding, homogenisation, splitting and/or putting together

New measurement substances

New measurement substances will be admitted on the basis of examination where there has been validation with respect to the reference method (Cobalt method). The validation report must contain at least the following elements:

¹⁴ The lower carry-over limit is the carry-over percentage on which, using the method applied, a reliable statement can still be made. If the carry-over percentage is lower then at least the carry-over percentage stated here should be used.

1. Name and address details of the submitter and inspection agency
2. Motivation/problem description
3. Characteristics with respect to the
 - a. Animal feed installation to be used (including mixer/press installation/cooler)
 - b. The reference measurement substances and the measurement substances to be examined
 - c. Sampling plan for the samples to be taken in the various flush batches
 - d. Sample preparation in the laboratory
 - e. Analysis methods to be used
 - f. Statistical methods to be used
4. Analysis results
5. Statistical processing of the analysis results
6. Conclusions
7. References

The report may be submitted for assessment by an expert panel to the Product Board Animal Feed in The Hague.

2.2 PROCESS ACCURACY CONTROL PROCEDURE WITH COBALT (REFERENCE METHOD)

1. FIELD OF APPLICATION

This testing procedure or method for the determining of the uniformity of meals and grains may be used on the usual premixes and mixes of ground compound feed raw materials in compound feed companies.

The method can also be used to obtain an indication of the carry-over which occurs in compound feed raw materials.

2. DEFINITIONS

Product installation: A product installation is an installation which is suitable for the preparation of compound feeds.

Cobalt mix: Cobalt mix is a mixture of wheat grits and Cobalt chloride hexahydrate in such proportions that the cobalt level in the cobalt mix is a minimum of 5% and a maximum of 6% and is prepared in accordance with the applicable standard working instructions as incorporated in § 17 of this inspection procedure.

3. PRINCIPLE

The control procedure for the determination of the degree of uniformity of meal mixes in the preparation of compound feeds makes use of a cobalt mix which, with respect to its properties, can replace the usual compound feed additives.

The control procedure includes the processing of three batches from the same feed mix. The first batch flushes the production installation and serves to determine the "natural" cobalt level in the feed in question. The cobalt mix (see section 2) is added to the second batch. The cobalt level of samples of meal and grains from the second batch is determined. The third production batch consists of the bare feed without the cobalt mix. The cobalt level of the meal and grain samples from this batch is also determined. This level gives a picture of the carry-over which is taking place in the production installation.

The cobalt content of the samples taken is determined using atomic absorption spectrometry (AAS) after heat destruction of the analysis sample at 550 degrees Celsius.

4. EQUIPMENT AND TOOLS

The following are required for the carrying out of the control procedure:

- 110 plastic pots with lids with a size of 500 ml for saving the samples of meal and grains
- a plastic scoop for taking the samples.

The number of pots specified is required if samples of meal are taken at one point in the production installation and samples of grains are taken at another point. For each extra sampling point 48 pots of 500 ml extra are needed.

There must be a laboratory which is able to determine cobalt level using atomic absorption spectrometry. Appointments should be made in good time with this laboratory for analyses to be carried soon after the samples are taken.

5. COMPANY DETAILS REQUIRED

The following will be requested in advance from a compound feed company at which a control procedure is to be carried out:

- a. a block diagram of the production installation in which it can be indicated during the implementation where the cobalt mix has been added and where samples are taken.

The following will be requested during the implementation of the control procedure:

- b. the computer prints or copies of them which show:
 - the composition of the feed mix
 - the batch weight requested by the computer, and
 - the actual batch weight

or, if there is no computerisation:

- the composition of the feed mix
- the calculated batch weight from the sum of the quantities weighed per component
- the read-out of the actual batch weight.

The following will be requested to be able to calculate the batch weight for the mixer and the grain press:

- c. where and how much molasses, vinasse and other liquid ingredients added to the main flow of the feed, and
- d. where and how much fats, etc., are added to the main flow. The requested addition points are shown in the block diagram.

6. ADDITION OF THE COBALT MIX

A cobalt mix (see section 2) is added to the second batch of compound feed with a nominal cobalt level of at least 5% and maximum 6%.

The place where the cobalt mix is added depends on the carry-over path to be measured (see 7.1). The place selected for the addition and for sampling should be shown in the block diagram for the product installation.

Add as much cobalt mix as corresponds to a dosage of 2.0 kg per ton of compound feed. The batch weight requested by the process computer may be assumed.

7. TAKING AND HANDLING SAMPLES

7.1 Company samples

7.1.1 Taking the samples

During the implementation of the control procedure in a compound feed company samples are taken at locations agreed in advance:

- after the mixer but as close as possible to the mixer (see 13.1)
- from the entrance to the finished product silo in the event of meal production or a pressed meal silo

- from the entrance to the finished product silo in the event of grain production
- another desired end point for the determination of the relevant carry-over path

If the meal or grain flow is not reachable at the desired locations then suitable openings should be made in consultation with the company.

Meal production

From the first batch only samples of meal immediately after the mixer are taken these being 10 samples for cobalt determination and another 4 samples for a fluid determination.

From the second batch 20 samples of meal (immediately after the mixer) and 20 samples of meal of 500 ml (from the input to the finished product silo) and 4 samples of meal (input to the finished product cell) are taken for the determination of fluid.

From the third batch 20 samples of meal (immediately after the mixer) and 20 samples of grains of 500 ml (from the input of the finished product cell) are taken for cobalt determination and another 4 samples of meal (after the mixer) and 4 samples of grains (input to the finished product cell) for the determination of fluid.

Grain production

From the first batch only samples of meal immediately after the mixer are taken these being 10 samples for cobalt determination and another 4 samples for a fluid determination.

From the second batch 20 samples of meal (immediately after the mixer) and 20 samples of grains of 500 ml (from the input of the finished product cell) are taken for cobalt determination and another 4 samples of meal (immediately after the mixer) and 4 samples of grains (input to the finished product cell) for the determination of fluid.

From the third batch 20 samples of meal (immediately after the mixer) and 20 samples of grains of 500 ml (from the input of the finished product cell) are taken for cobalt determination and another 4 samples of meal (immediately after the mixer) and 4 samples of grains (from the finished product cell) for the determination of fluid.

If a split is desired with respect to the carry-over by the dosage/grinding/mixing line on the one hand and the press line on the other hand then during the second and third batches another 20 samples of meal for cobalt determination and 4 samples of meal for fluid determination should be taken at the input to the pressed meal silo. The method of working is identical to the method for meal production.

Sample pots

All sample pots are provided with a sample code before the start of the production of the first batch of feed. Once the meal and/or grains flow starts for the batch to be inspected then 20 samples of meal and 20 samples of grains of 500ml are taken spread as well as possible over the duration of the batch. The sample pots must be filled up to the edge to avoid de-mixing (in the case of meal samples) as much as possible.

N. B.: It is very important that the samples are taken spread as well as possible over the duration of the batch in connection with the samples being representative of the batch as a whole.

7.1.2 Sample handling

Each meal and grain sample is ground in a suitable grinder. 90% of the result must pass through a 1.00 mm sieve and 50% must pass through a 0.50 mm sieve. Use sieves with round holes. Do not grind the samples finer than is necessary in order to avoid as much as possible the grinder heating up.

First grind the meal and grains samples from the first batch and then those from the third batch (carry-over batch) and finally the second batch of feed. In this way the samples are ground in ascending order of their cobalt level.

Clean the grinder after each sample using compressed air.

Clean the grinder after each group of 24 samples using both compressed air and, after disassembly of the relevant parts, by brushing clean with a brush which is not too soft. There may be no carry-over of material from the previous group of samples.

Homogenise each grinding as much as possible and then place it back in the original pot.

7.1.3 Storage of company samples

Company samples which are not inspected within a week of being taken should be stored in a refrigerated area at a temperature of 35 degrees Celsius.

7.2 Analysis of samples

The samples to be inspected which have been stored in a refrigerated area should be transferred at least 16 hours before the start of the inspection to the place where the inspection will take place. The sample packaging may not be opened during this period (see 13.2). Act as indicated below once the specified period has elapsed.

Homogenise the mix to be inspected in the sample pot as much as possible by stirring it with a spoon or spatula.

From the company sample take 2 analysis samples of the desired amount. Carry out the cobalt determination for both of the samples.

8. DETERMINATION OF THE FLUID LEVEL

The operational sample taken for the determination of fluid level is used for two analysis samples.

The fluid level is determined in the analysis samples in accordance with the method laid down in the documentation bundle "Animal Feed Inspection Methods" from the Product Board Animal Feed or in accordance with the instructions in NEN 3332.

9. DETERMINATION OF THE COBALT LEVEL

9.1 Principle of cobalt determination

The determination of the cobalt level is done with the help of atomic absorption spectrometry (AAS) after heat destruction of the analysis sample measured by a filter of 240.7 nanometers after injection of this solution into the flame of the equipment.

A calibration graph can be made with the help of previously made solutions with an accurately known cobalt content. The extinctions measured in the analysis samples are converted into cobalt levels. The cobalt levels are expressed in parts per million (ppm).

The cobalt contents assigned to the analysis samples are corrected for the “natural” cobalt content determined in the samples of meal from the first production batch.

9.2 Standard samples

In the working instruction for the carrying out of the cobalt determination using atomic absorption spectrometry includes the inclusion of standard samples with a known cobalt content in each series of analysis samples. These standard samples serve as a check on the measured cobalt level.

9.3 Non-standard results

If the cobalt level of two analysis samples from the company sample deviates by more than 5% of the average measured values then two new analysis samples should be taken from the company sample and inspected (see 13.3).

10. PROCESSING OF THE RESULTS

10.1 Non-standard results

The results of the cobalt determinations in the compound feed from the three production batches will be assessed for deviations in as far as these are company samples of which more than two determinations have been done. In such cases a selection is made from the available results for the sample company sample of the two results with the least differences between them. These two results are then also included in the calculations. This avoids an analysis of variance with unequal degrees of freedom having to be carried out.

After the addition of the cobalt mix to the feed in the second batch the cobalt level in the first samples to be taken will be lower than in the subsequent samples [2]. This is because of a degree of carry-over from a bare floor from the first to the second batch of feed.

This may not be neglected in the determination of uniformity of the feed from the second batch. Although not statistically exact, the cobalt levels of the samples from the second batch are not assessed for a non-standard, average level of the results but they are all used for the calculation of the empiric coefficient of variation of the uniformity. That which was stated in the first sentence of this section does, however, continue to apply. The fact that the spread of the average results for the twenty samples is not “normal” but somewhat distorted is ignored.

An opposite effect is seen in the samples from the third batch of feed. Now the samples show a relatively high cobalt level as a result of carry-over of feed containing cobalt from the second to the third batch [2]. Normally the spread of the cobalt levels in the samples from the third batch is considerably more distorted than in the second batch. It is for this reason that the results of cobalt level determination in samples from the third batch are not checked for deviations. There is also no calculation of an empiric coefficient of variation for uniformity and it is enough to make a graph of the average cobalt level per sample against the sample number. In as far as the samples are properly representative for the whole batch which means they have been properly spread over the total duration, the average carry-over of cobalt can be calculated either in absolute terms or as a percentage of the level in batch two.

10.2 Conversion on the dry substance

The measured cobalt contents apply for the analysis samples or the operational samples with the existing fluid content (product basis). In order to be able to work further with the cobalt levels they should all be related to the dry substance.

Use the following formula for this conversion:

$$C = \frac{100}{100 - V} \times C1$$

Where

- C = the cobalt content on the basis of dry substance in ppm
V = the fluid level of the group of operational samples involved in %
C1 = the measured cobalt level on product basis in ppm.

The measured cobalt levels for dry substance will be decreased by the “natural” cobalt level for dry substance in the bare floor from the first batch.

The cobalt levels corrected in this way for dry substance will be used for the further processing of the results.

10.3 The carry-over

The carry-over for the installation is calculated as follows in accordance with this control procedure per measurement point.

The average cobalt level for dry substance in the group of company samples from the third batch divided by the average cobalt level for dry substance in the group of company samples from the second batch. By multiplying this figure by 100 the average carry-over percentage can be calculated.

10.4 The analysis of variance

The measured, corrected cobalt levels on the basis of dry substance from the samples in the second batch are used as elements in an analysis of variance. The results for meal and for grains are analysed separately.

In this analysis of variance the following sources of variation are distinguished:

- the differences between the repetitions within the company samples, and
- the differences between the sample averages from one group of company samples.

The results of the variation analysis are:

- the standard deviation between repetitions (or within samples)
- the standard deviation between sample averages (or between samples)
- the average cobalt level per analysis sample
- the average cobalt level per group of operational samples
- the number of degrees of freedom associated with each of the standard deviations

The calculated standard deviations are converted to empiric coefficients of variation by multiplying the standard deviation by 100 and then dividing the product by the average cobalt level of the group of company samples. The empiric coefficient of variation calculated in this way between samples is a measure of the uniformity achieved at the measuring point.

This conversion is necessary because the standard deviation is greatly dependent on the cobalt level in the groups of operational samples.

The arithmetic implementation of the analysis of variance can be found in detail in nearly any manual on mathematical statistics. See, for example, [1].

The cobalt levels of the analysis samples from the third batch are shown in graph form against the number of the sample. These cobalt levels are not suitable for an analysis of variance because they can vary enormously and are usually not spread normally. The average cobalt level in the third batch can be calculated as specified in 10.3.

11. REPORTING

The following is reported for each group of company samples:

1. the average fluid content for the group of company samples (0.01%)
2. the average of the corrected measured cobalt levels on the basis of dry substance from each of the analysis samples (0.1 ppm at cobalt levels higher than 10 ppm and 0.01 ppm at cobalt levels of 10 ppm or less)
3. the average of the corrected measured cobalt levels of the company samples per group (0.1 ppm at cobalt levels higher than 10 ppm and 0.01 ppm at cobalt levels of 10 ppm or less)
4. the calculated carry-over of the installation in accordance with the control procedure.

A report is also made via each group of company samples from the first and second batches of feed of the following:

5. the standard deviations between repetitions (0.0001 ppm)
6. the standard deviation between sample averages (0.0001 ppm)
7. the number of degrees of freedom associated with the standard deviations as intended in 4. and 5.
8. the empiric coefficient of variation between repetitions (0.01 %)
9. the empiric coefficient of variation between sample averages (0.01%)

12. ASSESSMENT OF THE RESULTS

12.1 Repeatability of the cobalt determination

The empiric coefficient of variation between repetitions is a measure of the repeatability of the cobalt determination including sample treatment. The empiric coefficient of variation between repetitions amounts in properly conducted determinations to about 3 - 4% [2]. If the empiric coefficient of variation is greater then the implementation of the cobalt determination should be examined further.

The repeatability (r) is a factor 2.83 higher and therefore roughly amounts to 8.5 – 11.3%. This means that in the implementation of a determination in duplicate by the same analyst with the same equipment, on one in 20 case a difference is found between the two results which is greater than the value given for repeatability (r).

12.2 Uniformity of the material

The empiric coefficient of variation between sample averages is a measure of the uniformity of the meal mix or the grains from which the company samples have been taken. Statistically the group of company samples is not homogenous if the standard deviation between sample averages exceeds the standard deviation between repetitions by more than a given factor (F test). In very small standard deviations between repetitions this leads to a non-uniform mix although there is not yet any reason on technical grounds.

13. REMARKS:

13.1 First sample point

A feed mix is not uniform after the dosage of the various components. Even after the grinding of the raw materials in the hammer mill this is only partly the case. Often finer raw materials are led around the hammer mill and carried straight to the mixer. A uniform feed mix may therefore only be expected for the first time in the mixer. Taking samples directly from the mixer is difficult and may be dangerous and is certainly not recommended. The sample point after the mixer should therefore be used. In most companies this will be the outflow of the bunker under the mixer.

13.2 Acclimatisation of company samples

Company samples which can not be examined in the short term should be stored in a refrigerated area to prevent decay. These samples must be brought to the area where the inspection will actually take place well in advance. This allows the company sample to reach the temperature of the laboratory. This method of working prevents sample material from being exposed to condensation from the warmer air in the laboratory. Condensation makes it impossible to determine the correct fluid content of the sample. A non-homogenous distribution of the condensed fluid in the sample material will also cause a greater spread of the results of the cobalt determination.

13.3 Non-standard results of cobalt determinations

If two cobalt determinations from the analysis samples from the same company sample differ by more than 5% in value then two new analysis samples must be tested. This procedure usually results in one of the four results being rejected. In addition to company samples with results of two analysis samples there are also samples with three or sometimes four non-deviating results. This makes the implementation of the analysis of variance difficult. Statisticians have developed methods of calculation to replace more than two valid results with two results which contribute in the same way to the variance of the results.

As a judgement on whether or not a mix is uniform rests on a technological agreement on the limit value for the empiric coefficient of variation, it has been decided to simplify the method.

From the set of three or four results of which one (or two) are deviating, the deviating results are rejected. If three valid results remain then the two results with the least difference between them are used. In this way the variance analysis consists of two company samples each with two repetitions.

14. SAFETY

The control procedure is usually carried out in practice in a compound feed company.

For those who carry out the control procedure in a compound feed company the following safety rules apply:

- a. the operatives will make themselves aware before the start of the work of the safety instructions which apply in the compound feed company
- b. during their stay in the compound feed company the operatives are bound to follow the safety instructions of the compound feed company
- c. during the adding of the premix containing cobalt to the main flow of feed protective gloves and a respiratory protector in the form of a nose covering is to be worn.

15. PROCESSING OF COMPOUND FEED CONTAINING COBALT

The mix containing cobalt is added to the second batch of feed produced for the control procedure at a dosage of 2 kg per ton of feed. The compound feed will then contain about 100 ppm of cobalt. This feed should be stored in a separate cell and may not be traded.

It is recommended that the feed containing cobalt is diluted such that the cobalt concentration in the final feed intended for trading amounts to no more than 10 ppm. Account should be taken when doing this of the cobalt level already present in the raw materials.

The feed from the third batch usually contains only slight amounts of cobalt. As the degree of carry-over is not known in advance, account must be taken of fairly large deviations in the cobalt level of this feed. It is advisable also to store this feed separately and to dilute it sufficiently.

If the compound feed company does not wish to use this feed in any way then it must be treated as chemical waste and handled and removed as such.

16. LITERATURE

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17. STANDARD INSTRUCTION FOR THE PREPARATION OF COBALT MIX

Introduction

The cobalt mix for the carrying out of the control procedure is prepared wet from wheat grits and cobalt chloride hexahydrate. This ensures that the cobalt is well distributed over the cobalt mix and that the cobalt mix does not differ much with respect to its characteristics from the compound feed.

Ingredients

- wheat grits, well defined quality, as bearer
- cobalt chloride hexahydrate, minimum 99% pure
- water of at least mains water quality

Equipment

- mixing equipment, suitable for dry and wet products, for example the Nauta mixer with clump breaker
- equipment for spraying under pressure (compressed air)
- drying equipment with forced ventilation
- grinding equipment including a high-revolutions grinder
- sieving equipment.

Safety measures

When working with cobalt, especially when spraying, grinding and sieving, mouth and nose protection should be used and suitable gloves of synthetic material should be worn.

Preparation of the cobalt mix

The required amounts of cobalt chloride hexahydrate and wheat grits are weighed. The cobalt chloride hexahydrate is dissolved in about twice the amount of water. The mix is slightly warmed if necessary (max. 50 °C) until a clear solution is obtained. The solution is transferred into the pressure vessel of the spraying equipment. The weighed wheat grits are put into the mixer, the mixer is then started and the pressure vessel is put under pressure (c. 2 – 2.5 bar). The supply to the sprayer in the mixer is opened so that the solution is atomised. Once the cobalt chloride hexahydrate solution has been completely atomised, possibly in two or more steps depending on the volume of the pressure vessel, all the equipment which was used three times for the preparation of the cobalt solution and the atomisation must be flushed with a suitable amount of water. The wet cobalt mix is mixed for a further 15 minutes.

After this the mixer is emptied as much as possible and the mixture is dried for 24 hours at c. 60 °C dried???.

The dried material is ground with a high-speed grinder (for example a pin crusher) and then sieved with a mesh of maximum 500 µm. The residue from the sieving can be ground again and sieved again with the same sieve.

That which falls through is put together, homogenised in a mixer and hermetically packed, preferably in a quantity which is suitable for immediate use in the testing procedure (i.e. 2 kg/ton).

The packaging states:

- the name of the product (cobalt mix)
- filled weight
- production date and batch and report number
- the nominal cobalt concentration
- the sequence number of the packaging in the batch
- safety measures.

Account must be taken of the fact that the dried cobalt mix is to some extent hygroscopic. It is advisable to work in a dry environment with the least possible exposure to air.

Sampling and reporting

A minimum of four samples are taken from each homogenised batch during the packaging of the cobalt mix. Two of these are intended for a moisture determination and one for the determination of the particle size distribution while at least one is kept as a reserve sample.

The report on the cobalt mix prepared in this way will contain at least:

- the origin and characterisation of the wheat grits
- the origin and purity of the cobalt chloride hexahydrate
- the quantity of carrier, cobalt salt and water used
- the average moisture content of the mix after homogenisation
- the calculated cobalt level of the cobalt mix
- the particle size distribution of the cobalt mix.

2.3 TESTING PROCEDURE FOR CARRY-OVER IN COMPOUND FEED PREPARATION USING COBALT MIXES

This chapter describes a number of alternative procedures for in-company measurement of carry-over using cobalt tracer. These are a simplification of the reference method described in Chapter 2.2

On the one hand it is a procedure in which the number of samples to be taken and analysed can be considerably reduced to that which is strictly necessary for a reliable measurement of carry-over. This particularly limits analysis costs. The company is of course free to take and analyse more samples in order to gain more insight into the process accuracy of the installation.

On the other hand, two procedures are involved in which the cobalt level is lowered by a factor 2 to 4 respectively. This limits the problems of responsible processing of the batch of feed to which the cobalt has been added. It also limits, however, the sensitivity of the method. Very low to relatively low carry-over levels (< 3%, resp. < 5%) are not properly measured with this.

For in-company measurement of carry-over with a reduced cobalt level use may be made of both the reference method specified in Chapter 2.2 and the above-mentioned procedure with a reduced number of samples.

For the inspection procedures specified in both chapter 2.3.1 and chapter 2.3.2 a mix based on cobalt sulphate may be used instead of the cobalt mix defined in § 17 in chapter 2.2. The mix on the basis of cobalt sulphate should be prepared in accordance with the standard instructions in chapter 2.3.4.

2.3.1 Modification of the reference method with cobalt for the in-company measurement of carry-over of 1% and more in compound feed mixing (reduced number of samples).

Both the reference method (see chapter 2.2) and this modified procedure can be used to measure a carry-over of 1% or more in the preparation of mixed feeds. Essential in this is the minimum content of 5% cobalt in the cobalt mix to be used and the subsequent content of at least 100 ppm in the feed mix to which the cobalt mix is added.

This description indicates where and in what regard the reference method (chapter 2.2) may be modified for in-company measurement of carry-over. For the sake of simplicity the numbering of chapter 2.2 will be used. Parts of the reference method which are not mentioned remain unchanged in theory or only subject to minor, obvious amendments.

1. FIELD OF APPLICATION

This method is only intended for in-company measurement of carry-over.

2. EQUIPMENT AND TOOLS

At least 46 plastic pots of 50 ml with a lid or plastic sample bags of 1 litre are required.

3. TAKING AND HANDLING SAMPLES

3.1 Taking samples

The following schedule can be used when taking samples in which part of the sampling and/or further handling is voluntary if it is desired to obtain more insight.

1. After the first batch (without added cobalt):

- at least 4 samples at the selected control point for carry-over. Preferably after the cooler for the determination of the natural cobalt level in the feed (KAC1 – KAC4)
- at least 4 samples at the same control point for the determination of the moisture level (VAC1 – VAC4).

2. After the second batch (with added cobalt mix):

- at least 10 samples, as close as possible after the mixer and regularly distributed over the outflow of a batch for the determination of the average cobalt level (KBM1 – KBM10). Possibly (this is voluntary) 20 samples may be taken (see 7.2.3)
- at least 4 samples at the same point for the determination of the moisture level (VBM1 – VBM4)
- possibly (this is voluntary) 10 samples at the specified control point(s) for carry-over for the determination of the average cobalt level (KBC1 – KBC10).

3. After the third batch (carry-over batch)

- possibly (this is voluntary) 10 samples as close as possible after the mixer, regularly distributed over the outflow of a batch (KCM1 – KCM10)
- 20 samples at the specified control point(s) for carry-over, regularly distributed over the total duration of the batch at this point for the determination of the degree of carry-over (KCC1 – KCC20)
- at least 4 samples at the same point for the determination of the moisture level (VCC1 – VCC4).

3.2 Sample handling and destination

The technical sample handling (grinding, sequence, etc.) remains as described in chapter 2.2. The following applies with respect to the destination of the samples.

1. All moisture samples have the function that the results of the cobalt analyses for differences in moisture content may be corrected or recalculated for dry substance.
2. The samples KAC1 – KAC4 are analysed individually in duplicate. This is – especially for the third batch – of great importance because the cobalt levels in batches two and three must be corrected for the “natural” cobalt level in the feed.
3. Samples KBM1 – KBM10 can serve two purposes. Each sample can if desired be split into a ‘a’ and a ‘b’ sample, or, if 20 samples are taken instead of 10 (see 7.1.2), these can be used in turn or each can be split for one purpose or another.

Possibly (this is voluntary), one half of the samples can now be used to determine the uniformity of the mix. To do this the 10 (or 20) samples must each be analysed separately in duplicate.

A mix can be made of the other half of the 10 or 20 samples possibly after further reduction of the product which is used to determine the average cobalt level of the second batch. To do this at least two new samples are taken from the mix in which the cobalt level and the moisture level are analysed in duplicate. Naturally, the average cobalt level of batch two may also be determined by averaging the individual duplicate results of the 10 or 20 samples.

4. Using samples KBC1 – KBC190 an impression can be obtained (this is voluntary) of the extent to which the uniformity obtained immediately after mixing (KBM1 – KBM10) in the subsequent production and transport process is maintained up to the control point for carry-over. These samples must each be separately analysed in duplicate.
5. Using samples KCM1 – KCM10 a determination may possibly be made (this is voluntary) the extent to which carry-over is already occurring in the path up to the sampling point immediately after the mixer. For the analysis a choice can be made to analyse a mix sample (analysis of two samples in duplicate for the average carry-over), or of all ten samples separately in duplicate (carry-over pattern and calculation of the average).
6. The samples KCC1 – KCC20 may be mixed two at a time, thus KCC1 + 2, KCC3 + 4 etc., after which in each of the 10 new samples in duplicate the cobalt level is determined. Assuming that each of the original samples is representative for an equivalent part of the batch, the average carry-over can be directly calculated. If it is known that this is not the case, for example because of irregular time intervals between sampling, the weighted average, related to the actual time intervals, is calculated. It may also be decided to analyse each of the samples KCC1 – KCC separately and then to calculate the average as described above.

4. PROCESSING OF THE RESULTS

4.1 Variance analysis

In this simplified implementation the results are only suitable to a limited extent for statistical analysis.

In as far as there are measurement series with analyses carried out in duplicate, it is advisable in any event to calculate via a variation analysis the empiric coefficient of variation between repetitions per measurement series.

In as far as there are measurement series for which in an ideal case the results must have the same value (uniformity), an analysis of variance must be carried out with which both the empiric coefficients of variation between samples as well as between repetitions is calculated.

This applies in particular to the sample series KAC1, KAC4 and possibly for KBM1 – KBM10, KCB1 – KCB10 and KCM1 – KCM10 in as far as one takes samples from these series, individually analyses them and is interested in the degree of uniformity.

4.2 Calculation of carry-over

All cobalt levels are corrected in advance using the average results of the corresponding moisture determinations for dry substance. The carry-over for the installation is now calculated as follows on the basis of the corrected values:

the average cobalt level in the 20 samples KCC from the third batch minus the average cobalt level in the 4 samples KAC from the first batch, divided by the average cobalt level from the 10 samples KBM from the second batch, also minus the average cobalt level in the 4 samples KAC from the first batch. By multiplying the result by 100 an average percentage carry-over in the batch immediately following the batch to which the cobalt mix was added as a model for a premix with additive can be calculated.

By displaying the results of the cobalt analyses in the samples KCC1 – KCC20 (corrected for the average of KAC1 – KAC4) in graphic form, a carry-over pattern is obtained which gives in principle more information than the calculated average.

2.3.2 Modification of the measurement methods with cobalt for the in-company measurement of carry-over of 3% and more in compound feed mixing

For the in-company measurement of carry-over of 3% or more, either the testing procedure described in chapter 2.2 or the modified procedure described in chapter 2.3.1 is used. Use is made of a cobalt content in the cobalt mix as specified in section 2 of chapter 2.2 of minimum 2.5%. This realises a level of about 50 mg/kg in the second batch of feed in the testing procedure.

2.3.3 Modification of the measurement methods with cobalt for the in-company measurement of carry-over of 5% and more in compound feed handling

For the in-company measurement of carry-over of 5% or more, either the testing procedure described in chapter 2.2 or the modified procedure described above in chapter 2.3.1 is used. Use is made of a cobalt content in the cobalt mix as specified in section 2 of chapter 2.2 of minimum 1.25%. This realises a level of about 25 mg/kg in the second batch of feed in the testing procedure.

Literature

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2.3.4 Standard instruction for the preparation of a cobalt sulphate mix for the in-company measurement of carry-over

Introduction

The cobalt mix for the carrying out of the testing procedure is prepared via dry mixing from wheat grits, wheat red dog and cobalt sulphate. This ensures that the cobalt is well distributed over the cobalt mix and that the cobalt mix does not differ much with respect to its characteristics from the compound feed.

Ingredients

- wheat grits and wheat red dog, well defined quality, as bearer
- cobalt sulphate heptahydrate, minimum 98% pure

Equipment

- mixing equipment, suitable for dry products, such as Planet mixer.

Also needed as tools are, among others, suitable balances for weighing the ingredients.

Safety measures

When working with cobalt, mouth and nose protection should be used and suitable gloves of synthetic material should be worn.

Preparation of the cobalt mix

The required amounts of cobalt sulphate heptahydrate, wheat grits and wheat red dog are weighed.

The weighed quantities are mixed in a Planet mixer for 15 minutes. The mix is then measured into buckets of 2.0 kg and properly closed off with a lid.

The packaging states:

- name and code of the product (cobalt mix)
- filled weight in kg
- date of production
- the nominal cobalt concentration
- the sequence number of the packaging in the batch
- safety measures.

The closed buckets should be stored under air-conditioned conditions.

Open the packaging immediately before use.

The cobalt mix should comply with the following requirements:

- particle size: maximum 1% > 0.7 mm; maximum 10% > 0.5 mm
- cobalt level: at least 4.5%

Sampling and reporting

Four 4 samples are taken from each homogenised batch during the packaging of the cobalt mix. Of these 1 is intended for moisture determination, 1 for the determination of particle size distribution and 1 for the determination of cobalt, while 1 is kept as a reserve sample.

The report on the cobalt mix prepared in this way will contain at least:

- the origin and characterisation of the wheat grits
- the origin and characterisation of the wheat red dog
- the origin of the cobalt sulphate heptahydrate
- the amount of carrier and cobalt salt used
- the moisture content of the mix after homogenisation
- the calculated cobalt level of the cobalt mix
- the analysed cobalt level of the cobalt mix
- the particle size distribution of the cobalt mix.

2.4 TESTING PROCEDURE FOR THE CARRY-OVER IN COMPOUND FEED MIXING USING A MIX OF MANGANATE AND A PROTEIN-RICH AND A PROTEIN-POOR MIX

1. APPLICATION AREA

The testing procedure was developed for the determination of the carry-over which occurs in compound feed production companies. The carry-over of large components from the batching equipment for raw materials and the carry-over of the components which are added via the premixes are determined separately.

By collecting the samples which have been taken for the carry-over inspection at various different places in the production process, insight can be obtained into the carry-over in components of the production process (for example: grinding / mixing line to pressed meal bunker or the press / cooling line). The method is also suitable for the determination of the extent to which uniform mixes can be produced using the installation (see item 9).

2. DEFINITIONS

Carry-over

Carry-over means that part of the previous batch of feed remains in the production and transport system and gets into the following batches.

Carry-over level

The carry-over level is defined as the amount of a nutrient or component from a previous batch, expressed as a percentage, which gets into the following batch of feed (of the same size). The carry-over level can be measured for a section of the installation (for example the pressed meal bunkers) or for the whole installation.

3. PRINCIPLE OF THE TESTING PROCEDURE

The testing procedure is carried out by first fabricating a protein and Mn-rich Soya mix and immediately afterwards by fabricating a protein and Mn-poor mix on the same production line. The increase in the protein and Mn level of the maize mix during the running of the production line is caused by carry-over. By relating this increase to the protein and Mn level of the Soya mix, the carry-over level can be calculated.

Because the protein and manganese content of the maize mix progresses hyperbolically (from high levels at the beginning of the flow to lower levels afterwards), the sampling procedure must be given particular attention.

4. EQUIPMENT AND TOOLS

The following are required for the carrying out of the testing procedure:

- a quantity of manganese oxide corresponding to 0.4% of the usual batch size
- (possibly) a scoop for taking samples
- two buckets to be able to collect a number of sub-samples
- sample pots or bags which can hold at least 200 grams of material. If the carry-over inspection is carried out at two places in the production line then 20 sample pots will usually be enough (only 14 samples will actually be tested).

5. COMPANY DETAILS REQUIRED

The following must be known about the company where the testing procedure will be carried out:

- a. the block diagram of the production installation
- b. the way in which the Soya and maize mix is put together. An exact indication should in particular be given of how and where the manganese oxide is added and how any transport system for the manganese oxide to the mixer is flushed both for the Soya mix and for the maize mix.

6. IMPLEMENTATION OF THE TESTING PROCEDURE

6.1.a. Fabrication of the protein and Mn-rich Soya mix

The Soya mix (with the usual batch size) consists of 92% Soya meal, 4% fat, 3% cane molasses, 0.4% manganese oxide and 0.8% dicalcium phosphate (or chalk or salt). This mixture is batched, ground, mixed and pelletised in the usual way. Molasses and fat are added to obtain a meal with normal physical characteristics which can be pelletised properly. The Soya meal may come from more than one batching silo.

The manganese oxide comes instead of the premix and should take the same route as the premix. The manganese oxide is therefore batched into the premix weighing machine or dumping pit.

The batching should be carried out such that the manganese oxide comes virtually fully to the bottom of the premix weighing machine or dumping pit.

The manganese oxide should comply with the following requirements:

- Mn level at least 50%
- particle size: 100% should be smaller than 0.2 mm.

Normally, chalk, salt and/or feed phosphate is batched via the same weighing machine or dump pit. Because of this the carry-over of components from the premix will be less especially when first the premix and only then the other products are batched.

For the testing procedure first 0.4% manganese oxide and then 0.8% chalk, feed phosphate or salt is batched.

Once the content of the premix weighing machine (or the dumping pit) has been added to the Soya mix in the mixer, the normal mixing time is carried out. The mix is then removed to an empty pressed meal bunker and pelleted (sample).

The grinding/mixing line and the press/cooling line may not be used for anything other than the maize mix after the Soya mix.

6.1.b. Sampling of the Soya mix

When unloading the Soya pellets in the finished product silo a good mix sample is taken from the last part of the batch.

6.2.a. Fabrication of the protein and Mn-poor maize mix

The maize mix (with the same batch size as the Soya mix) consists of 92% maize, 4% fat, 3% cane molasses and 0.8% dicalcium phosphate (or chalk or salt). If it is not possible to batch 92% maize then a maize/wheat mix or another protein-poor mix may be put together (sample). The transport system between the premix weighing machine (or dumping pit) and the mixer is flushed with 0.8% dicalcium phosphate (or salt or chalk).

The mixing time starts once the feed phosphate has been added to the mix. The mix is then removed to the (empty) pressed meal bunker (sample) and then pelletised (sample).

6.2.b. Sampling of the maize mix

The following samples of the maize mix are collected:

- I the maize (and possibly the wheat) which is used for the composition of the mix
- II six samples from the maize mix at the inflow to the pressed meal bunker
- III six samples from the maize mix at the inflow to the final product silo.

The sampling procedure is important for the samples in II and III. In particular the first part of the meal or the pellets from the batch will have higher levels of protein and manganese which will then decrease relatively quickly to a lower and more constant level. It is therefore important to sample the first part of the meal or pellet flow intensively and to know to which part of the feed these samples relate.

The sampling procedure at the inflow to the pressed meal bunker (which usually lasts 3 to 5 minutes) is as follows:

- during the first 30 seconds as many sub-samples as possible are collected in a bucket; a mix sample is made from these
- for the second 30 seconds: idem
- then every 30 seconds a random sample from the flow is collected until the meal flow stops.

The total running time of the meal flow is noted and 6 samples are kept, namely the three which were taken first and three of the other samples.

The sampling of the pellets at the inflow to the finished product silo takes place in the same way. Because the total duration is usually somewhat longer the procedure is now as follows:

- during the first minute as many sub-samples as possible are collected in a bucket; a mix sample is made from these
- during the second minute: idem
- then every minute a random sample from the flow is collected until the pellet flow stops. (If the pellet flow is not continuous then the "real" duration should be used.)

Note the total duration here as well and keep six samples, namely the three which were taken first and three of the other samples.

6.3 Processing of the Soya mix in compound feed

At low carry-over levels the Soya mix has a Mn level of c. 2,000 mg/kg. In the processing of this Soya mix in compound feed account should be taken of the fact that the Mn level of compound feed may be a maximum of 250 mg/kg.

7. THE ANALYSIS OF THE SAMPLES

In total there are 14 (or possibly 15) samples collected:

1 sample of Soya pellets (+ Mn)	= A
1 sample of maize (pure) (+ possible wheat)	B
6 samples of maize mix meal (pressed meal bunker)	= C (1 to 6)
6 samples of maize mix meal (finished product silo)	= D (1 to 6)

All samples are analysed for RE and Mn.

Half of the samples of maize meal mix and maize mix pellets are analysed for moisture; this is in order to find out whether the moisture content has changed during pelletising. If the moisture content has clearly changed during pelletising then the RE and Mn levels of the maize mix pellets should be corrected for the moisture content of the maize mix meal.

8. THE CALCULATION OF THE CARRY-OVER PERCENTAGES

The carry-over percentages can be calculated from the levels of RE and Mn in the samples taken. Suppose that the following levels are found:

Soya pellets: 420 grams RE and 2,006 mg Mn/kg

Pure maize: 86 grams RE and 4 mg Mn/kg

samples maize mix (above the pressed meal bunker)

1.	mix sample (0.5 min.)	160 grams RE and	400 mg Mn/kg
2.	mix sample (0.5 min.)	100 grams RE and	60 mg Mn/kg
3.	random sample	90 gram	and 27 mg
4.	random sample	85 grams (avg. 88)	and 30 mg (avg. 28)
5.	random sample	88 gram	and 28 mg
6.	random sample	89 gram	and 27 mg

The total duration of the meal flow in the pressed meal bunker = 5.5 min.

Expected levels of maize mix (92% maize and 3% molasses with 40 grams RE and 25 mg Mn/kg):

RE	=	$0,92^* 86 + 0,03^* 40$	=	80,3	gram/kg
Mn	=	$0,92^* 4 + 0,03^* 25$	=	4,4	mg /kg

The average levels of RE and Mn in the maize mix are calculated as follows:

RE	=	$0,5/5,5^*$	$160 + 0,5/5,5^* 100 + 4,5/5,5^*$	88	=95.6 grams/kg
Mn	=	$0,5/5,5^*$	$400 + 0,5/5,5^* 60 + 4,5/5,5^*$	28	= 64.7 mg/kg

(samples 1 and 2 each have a duration of 0.5 minutes from a total duration of 5.5 minutes. For samples 3 to 6 the average level is calculated; the duration of this is $5.5 - 2 \times 0.5 = 4.5$ minutes).

The carry-over percentage (Vs-%) is now calculated as follows:

$$Vs-\% = \frac{\text{avg. level in maize mix} - \text{expected level in maize mix}}{\text{avg. level in Soya pellets} - \text{expected level in maize mix}} \times 100$$

The carry-over percentages are then (up to the pressed meal bunker)

$$\text{for RE} = \frac{95,6 - 80,3}{420 - 80,3} \times \frac{1.530}{339,7} \times 100 = 4,5\%$$

$$\text{and for Mn} = \frac{64,7 - 4,4}{2.006 - 4,4} \times \frac{6.030}{2.001,6} \times 100 = 3\%$$

The carry-over percentages at the inflow to the finished product cell are calculated in the same way.

The carry-over percentage of the RE relates to the feed as such, from the batching equipment. The carry-over percentage for the Mn gives an indication of the carry-over of components from the premix.

9. THE MEASUREMENT OF UNIFORMITY

In order to determine the extent to which the installation produces uniform mixes, at least 10 samples should be collected from the Mn-rich Soya mix and analysed for Mn. The spread of the Mn levels of these samples (standard deviation or the difference between the highest and lowest value) is a measure of uniformity.

When taking the samples from the Soya mix one should ensure that the whole flow of the mix is sampled. Because it is often not known exactly how long the meal flow will last, it is desirable in the first instance to take a generous number of samples of which only a part (namely 10) need to be tested.

The uniformity test may be carried out at many places in the installation. If the samples are taken immediately after the mixer then a good picture is obtained of the functioning of the mixer. If, on the other hand, samples are taken at other places in the installation (but after the mixer) then the uniformity will generally be less than immediately after the mixer.

This is because in this case de-mixing and carry over also play a role. Because the Mn-rich Soya mix is always produced after a "normal" compound feed with much lower Mn levels, the first samples of the Soya mix will be contaminated with a certain amount of compound feed and will therefore contain less Mn. The subsequent samples will be contaminated with less and less normal compound feed and will have higher and higher Mn levels.

10. ERRORS DISCUSSION

Table 1 shows which Mn and protein levels are to be expected in the maize mix at the various carry-over percentages, assuming 80 grams RE and 5 mg Mn/kg maize mix (pure) and 400 gram RE and 1,800 mg Mn/kg Soya mix.

Table 1 Effect of carry-over percentage on Mn and protein level of the maize mix.						
Carry-over %	0	1	3	5	10	15
MN from basis*	5	5	5	5	5	5
From Soya	0	18	54	92	180	270
	5	23	59	95	185	275
* effect of thinning discounted						
RE from basis	80	79,2	77,6	76	72	68
From Soya	0	4	12	20	40	60
	80	83,2	89,6	96	112	128

On the basis of the analysis accuracy of the Mn and RE determination an estimate can be made of the accuracy with which the carry-over percentage can be determined.

For the 6 maize samples to be tested it is assumed that the average Mn-level found in 95% of the cases will lie between 95 and 105% of the actual level; for levels < 60 mg/kg the absolute interval is made equal to the interval for 60 mg/kg, thus +/- 3 mg/kg.

For the Soya mix it is assumed that the Mn level found in the analysis will deviate by a maximum of 100 mg/kg from the actual level.

For the protein it is assumed that the average level found for the 6 maize samples will in 95% of cases lie between 99 and 101% of the actual level and that the level found for the Soya mix will deviate by a maximum of 2% from the actual level.

The results of the calculations are shown in Table 2.

It may be concluded that low carry-over percentages can be determined fairly reliably. For low carry-over levels Mn seems to comply better than the RE; at high carry-over levels, on the other hand, the protein gives better results than the Mn.

Table 2: Effect of the analysis accuracy on the carry-over percentage to be established				
		Maize mix		
Carry-over level		Calculated	Interval analysis	Carry-over percentage*
Mn	0	5 mg/kg	2 - 8 mg/kg	0,16 - 0,18%
	1	23	20 - 26	0,8 - 1,2
	3	59	56 - 62	2,7 - 3,4
	5	95	90 - 100	4,5 - 5,6
	10	185	176 - 194	9 - 11,1
	15	275	261 - 289	13,5 - 16,7
On the basis of 1800 mg Mn/kg Soya mix (variation 1700-1900, at low Mn in maize there is a calculation of high Mn in Soya, and vice versa).				
		Calculated	Interval analysis	Carry-over %*
RE	0	80 g/kg	79.2 - 80.8 g/kg	- 0,25 - 0,25
	1	83,2	82,4 - 84,0	0,7 - 1,3
	3	89,6	88,7 - 90,5	2,6 - 3,4
	5	96	95,0 - 97,0	4,5 - 5,5
	10	112	110,9 - 113,1	9,4 - 10,6
	15	128	126,7 - 129,3	14,2 - 15,8
On the basis of 400 g RE/kg Soya mix (variation 392-408, at low RE in maize there is a calculation of high RE in Soya, and vice versa).				

2.5 TESTING PROCEDURE FOR THE MEASUREMENT OF CARRY-OVER IN PREMIX AND ADDITIVES INSTALLATIONS

1. SYSTEM

The method of measurement of carry-over in premix and additives installations corresponds as far as the systematics are concerned to Chapters 2.2 to 2.4.

2. CARRY-OVER PROCESS

- The carry-over process to be measured relates to the point where the additives and/or animal veterinary products are added to the bulk vehicle load or the bag filling.
- Measurement of the carry-over should be carried out for each production line in the installation.
- The measurement should be carried out with a quantity of mix which is equal to the smallest batch which in practice may be produced on the production line in question.

3. TRACER SUBSTANCE TO BE USED

The following tracer substance can be used for the measurement of carry-over: cobalt mixes in accordance with Chapter 2.2 or 2.3.4 with a cobalt concentration of at least 200 mg/kg. At cobalt concentrations of 2,000 mg/kg or more use may also be made of pure cobalt sulphate. In addition the microtracers FSS-Lake and F-Lake and methyl violet can be used in the dosage of 10 mg/kg. Otherwise there should be compliance with Chapter 2.3.4.

4. DETERMINATION OF CARRY-OVER

The measurement of carry-over is done by taking the mix in which the carry-over occurs into consideration as a whole. This means that the average level in this mix is the departure point for determining the carry-over. The carry-over is measured as follows:

- a. mix the whole mix again
- b. take and analyse 5 samples from this mix (V1 to V6). The average level is calculated from this
- c. The carry-over is measured as follows:

$$\frac{\text{(average quantity in mix in which carry-over occurs)}}{\text{(batching in previous mix from which there is carry-over)}} \times 100\%$$

2.6 CHECKING PROCEDURE FOR THE PROCESS ACCURACY OF COMPOUND FEEDS WITH MICROTRACERS

1. FIELD OF APPLICATION

This testing procedure or method for the determining of the homogeneity of meals and grains may be used on the usual premixes and mixes of ground compound feed raw materials in compound feed companies.

The method can also be used to obtain an indication of the carry-over percentage which occurs in compound feed raw materials.

2. DEFINITIONS

Production plant: A production plant is an installation which is suitable for the preparation of compound feeds.

Microtracer mix: For the testing of a compound feed the microtracer mix contains 4 kg feed lime or wheat grits and 100 g microtracer. Therefore 100 g microtracer is mixed with 1 t compound feed, which corresponds to a mixing accuracy of 1:10 000.
For the testing of a premix the microtracer mix contains 4 kg feed lime or wheat grits and 10 g microtracer. Therefore 10 g microtracer is mixed with 1 t compound feed, which corresponds to a mixing accuracy of 1:100 000.

3. PRINCIPLE

So-called microtracers are used as a measuring substance. These are elementary iron particles which are coated with a feed colourant in order to be able to count the colour points in the analysis. An average number of particles per mg is indicated in the analysis certificate for the microtracer used. For the microtracer particles it is a case of particle distribution thus the average number of particles varies depending on the microtracer batch. In order to determine the number of particles in question in the test a microtracer mix is produced in which the average number of particles is determined exactly for the microtracer used (see 17).

Two different microtracers are suitable for the homogeneity and carry-over analysis. These are distinguished by their particle size and therefore the number of particles per mg. Microtracer F consists of particles with a size distribution of 150 – 300 µm and have been used for some time in the feed industry. The somewhat finer microtracer FSS with a size distribution of 75 – 150 µm was specially developed for chicken feeds to decrease the test quantity used.

The required accuracy for the determination of carry-over of 1% is achieved in both microtracer F and FSS. In order to achieve a statistically accurate assessment, a minimum number of 15 particles must be present per filter. Only then can an accurate assessment of homogeneity be made for the first production batch.

Method	Average number of particles per milligram [mg]	Test quantity for the assessment of homogeneity [g]	Average expected number of particles in the tested quantity	Test quantity for determination of carry-over [g]	Accuracy of the carry-over examination in %	Average expected number of particles in the tested quantity
FSS-Lake 100 ppm	200	2	40	200	1	40
F-Lake 100 ppm	25	20	50	2000	1	50
FSS-Lake 10 ppm	200	25	50	2500	1	50

Table 1:

The control procedure for the determination of the degree of homogeneity of meal mixes in the preparation of compound feeds makes use of a microtrace mix which, with respect to its properties, can replace the usual compound feed additives.

The control procedure includes the processing of two batches from the same feed mix. The microtrace mix (see section 2) is added to the first batch. The number of particles of microtracer in the samples of meal and grain from the first batch of feed is then determined. The second production batch consists of the bare feed without the microtracer mix. The microtracer level of the meal and grain samples from this batch is also determined. This level gives a picture of the carry-over which is taking place in the production installation.

The number of particles of microtracer in the samples which were taken is determined by separating the microtracer particles from the other feed particles using a rotary detector and by using the feed colourant to make the separate microtracer particles visible on a sheet of filter paper.

4. EQUIPMENT AND TOOLS

The following are required for the carrying out of the testing procedure:

- 40 plastic sample bags for keeping the samples of meal and grain each with a capacity of twice the quantity of the sample (see table 2)
- 40 plastic sample bags for keeping the samples of meal and grain each with a capacity of twice the quantity of the sample (see table 2)
- one small and one large plastic scoop for taking the samples.

The number of bags specified is required if production plant samples of meal are taken at one point in the production installation and samples of grains are taken at another point. For each subsequent sampling point 40 bags extra are needed.

Method	Sample quantity to be taken from production batch 1 for the determination of homogeneity	Sample quantity to be taken from production batch 2 for the determination of carry-over
FSS-Lake 100 ppm	≥ 4 g	≥ 400 g
F-Lake 100 ppm	≥ 40 g	≥ 4,000 g
FSS-Lake 10 ppm	≥ 50 g	≥ 5,000 g

Table 2:

A laboratory must be available where microtracer analyses can be done. Appointments should be made in good time with this laboratory for analyses to be carried soon after the samples are taken.

5. COMPANY DETAILS REQUIRED

The following will be requested in advance from a compound feed company at which a control procedure is to be carried out:

- a. a block diagram of the production installation in which it can be indicated during the implementation where the microtracer mix has been added and where samples are taken.

The following will be requested during the implementation of the control procedure:

- b. the computer prints or copies of them which show:
 - the composition of the feed mix
 - the batch weight requested by the computer, and
 - the actual batch weightor, if there is no computerisation:
 - the composition of the feed mix
 - the calculated batch weight This weight is obtained by adding the weights of the components
 - the read-out of the actual batch weight.

The following will be requested to be able to calculate the batch weight for the mixer and the grain press:

- c. where and how much molasses, vinasse and other liquid ingredients added to the main flow of the feed, and
- d. where and how much fats, etc., are added to the main flow. The requested addition points are shown in the block diagram.

6. ADDITION OF THE MICROTRACER MIX

The microtrace mix (see section 2) is added to the first batch. The place where the microtrace mix is added depends on the carry-over path to be measured (see 7.1). The place where the addition of the microtrace mix must be done should be indicated in the block diagram for the production plant.

The place where the addition of the microtrace mix must be done should be indicated in the block diagram for the production plant. The batch weight requested by the process computer may be assumed.

7. TAKING AND HANDLING SAMPLES

7.1 Analysis samples

7.1.1 Taking the samples

During the implementation of the control procedure in a compound feed company samples are taken at locations agreed in advance:

- after the mixer but as close as possible to the mixer (see 13.1)
- from the entrance to the finished product silo in the event of meal production or a pressed meal silo
- from the entrance to the finished product silo in the event of grain production
- another desired end point for the determination of the relevant carry-over path

If the meal or grain flow is not reachable at the desired locations then suitable openings should be made in consultation with the company.

Twenty samples are taken each time per sampling point. The statistical certainty is increased through the rise in the number of samples. The increase in the number of samples from 30 to 40 is, however, voluntary.

Meal production

From the first batch 20 samples of meal (immediately after the mixer) and 20 samples of meal (from the input to the finished product silo) are taken for the microtracer analysis (the sample quantity to be taken, see table 2).

From the second batch 20 samples of meal (immediately after the mixer) and 20 samples of grain (from the input to the finished product silo) are taken for the microtracer analysis (the sample quantity to be taken, see table 2).

Grain production

From the first batch 20 samples of meal (immediately after the mixer) and 20 samples of grain (from the input to the finished product silo) are taken for the microtracer analysis.

From the second batch of feed 20 samples of meal (immediately after the mixer) and 20 samples of grain (from the input to the finished product silo) are taken for the microtracer analysis (the sample quantity to be taken, see table 2).

If a split is desired with respect to the carry-over by the dosage/grinding/mixing line on the one hand and the press line on the other hand then during the first and second batches another 20 samples of meal for microtracer determination should be taken at the input to the pressed meal silo. The method of working is identical to the method for meal production.

Sample bags

All sample bags are provided with a sample code before the start of the production of the first batch of feed. The sample bags must be filled up to the edge and sealed air-tight to avoid de-mixing (in the case of meal samples) as much as possible.

Sampling

1. Production batch: Once the meal and/or grains flow starts for the batch to be inspected then 20 samples of meal and 20 samples of grains are taken spread as well as possible over the duration of the batch.
2. Production batch: Due to the irregular distribution to be expected of the microtracer particles in the carry-over batch (in the beginning very high numbers of microtracer particles and at the end very low numbers of microtracer particles) the sampling is done in a different way. The first three samples are continuously collected in a large collection container. The first sample represents the sampling time from 0 to 0.5 min, the second sample 0.5 to 1.0 minutes and the third sample 1.0 to 1.5 minutes in the feed flow. A sample is taken from each of these three collection samples via sampling splitting (quartering method). The other samples are taken as random samples every 0.5 minutes. For a total duration of the feed of 10 minutes there will be 20 samples collected of which the first three are collective samples and the other 17 are individual samples. For lesser durations the sampling intervals must be modified accordingly.

N. B.: It is very important that the samples are taken spread as well as possible over the duration of the batch in connection with the samples being representative of the batch as a whole.

7.1.2 Preparation of the samples

Each meal and grain sample is ground in a suitable grinder.

First grind the samples of meal and grain from the second batch (carry-over batch) and then those from the first batch. This ensures that the samples are ground in ascending order of their microtracer level.

Clean the grinder after each sample using compressed air.

Clean the grinder after each group of 20 samples using both compressed air and, after disassembly of the relevant parts, by brushing clean with a brush which is not too soft. There may be no carry-over of material from the previous group of samples.

Homogenise each grinding as much as possible and then place it back in the original bag.

7.1.3 Storage of analysis samples

Analysis samples which will not be tested within a week of being taken should be stored dry.

7.2 Analysis of samples

The sample packaging may not be opened during this period (see 13.2).

Homogenise the mix to be inspected in the sample bag as much as possible by stirring it with a spoon or spatula.

A sample of the desired size is taken from the sample to be analysed and subjected to a microtracer analysis.

7.3 Archiving

The filters with the colour points from the individual microtracer particles must be archived. A minimum archiving period of 1 year is suitable. The filter sheets can, however, be retained for more than 10 years.

8. DETERMINATION OF THE MICROTRACER PARTICLES

The microtracer particles from a sample are isolated because of their magnetic properties by way of filtering through a rotary detector with a rotary magnet. Other magnetic particles are also filtered out at the same time. The identification of the microtracer particles takes place by way of a bonding colouring agent which causes a chromatographic effect (= colour point) on a filter sheet after treatment with a developer. In order to make the colour points visible the filter is dampened with the developer, the microtracer particles are transferred quantitatively to the filter sheet and the colour development is stopped by then laying the filter sheet on a heated plate.

Other magnetic particles do not develop colour points and are removed from the filter sheet with a brush. The colour points developed on the filter sheet are counted. The microtracer level is indicated as the number of particles per gram of sample.

9. PROCESSING OF THE RESULTS

9.1 Non-standard results

After the addition of the microtracer mix to the feed in the first batch the microtracer level in the first samples to be taken will be lower than in the subsequent samples. This is because of a degree of carry-over of bare feed from the feed batch prior to the batch with microtracer.

An opposite effect is seen in the samples from the second batch of feed. Now the first samples show a relatively high microtracer level as a result of carry-over of feed containing microtracer from the second to the third batch. Normally the spread of the microtracer levels in the samples from the third batch is considerably more distorted than in the second batch. There is also no calculation of a probability for homogeneity and it is enough to make a graph of the average microtracer level per sample against the sample number. In as far as the samples are properly representative for the whole batch which means they have been properly spread over the total duration, the average carry-over of microtracer can be calculated as a percentage of the microtracer level in batch one.

9.2 The carry-over

The carry-over for the installation is calculated as follows in accordance with this control procedure per measurement point.

The average microtracer level of the analysis samples from the second batch divided by the average microtracer level on the basis of dry matter from the analysis samples from the second batch. By multiplying this figure by 100 the average carry-over percentage can be calculated.

9.3 The test for homogeneity

The following statistical data will be determined for the evaluation:

- average number of particles
- standard deviation for the number of particles
- χ^2 (chi squared) – value
- Probability p in % as an indication of the homogeneity
- Microtracer recovery percentage in %.

The probability is determined using the determined chi squared value and the number of degrees of freedom (see table 3). Values between 0.999 and < 0.0005 can be found. The assessment of the homogeneity is recorded by definition. The probability is calculated using an Excel table.

χ^2	1	2	3	4	5	6	7	8	9
1	.317	.607	.801	.910	.963	.986	.995	.998	.999
2	.157	.368	.572	.736	.849	.920	.960	.981	.991
3	.083	.223	.392	.558	.700	.809	.885	.934	.964
4	.046	.135	.261	.406	.549	.677	.780	.857	.911
5	.025	.082	.172	.287	.416	.544	.660	.758	.834
6	.014	.050	.112	.199	.306	.423	.540	.647	.740
7	.008	.030	.072	.136	.221	.321	.429	.537	.637
8	.005	.018	.046	.092	.156	.238	.333	.433	.534
9	.003	.011	.029	.061	.109	.174	.253	.342	.437
10	.002	.007	.019	.040	.075	.125	.189	.265	.350
11	.001	.004	.012	.027	.051	.088	.139	.202	.276
12	.001	.002	.007	.017	.035	.062	.101	.151	.213
13	**	.002	.005	.011	.023	.043	.072	.112	.163
14	**	.001	.003	.007	.016	.030	.051	.082	.122
15	**	.001	.002	.005	.010	.020	.036	.059	.091

Table 3: Table for the determination of probability, horizontal: number of degrees of freedom, vertical: chi squared values

10. REPORTING

The following is reported for each group of feed samples:

1. For the calculation of the homogeneity of the first batch of compound feed, the average number of microtracer particles in whole numbers
2. For the calculation of the homogeneity of the first batch of compound feed, the number of degrees of freedom of the system Number of analysed samples n-1
3. for the calculation of the homogeneity in the first batch of compound feed, the chi squared value (calculated from the empiric coefficient of variation for the analysed samples times the number of data divided by the average number of particles in the analysed samples)
4. from the number of degrees of freedom and the chi squared value, the probability as a percentage of the analysed samples $[(\text{Chiwert (chi squared; degree of freedom)} \times 100) \times 100]$
5. the calculated recovery percentage of the microtracer particles in the first batch of feed in relation to the number of microtracer particles in the added microtracer mix
6. The calculated carry-over in the installation from the number of microtracer particles in the second batch of feed in relation to the number of microtrace particles in the first batch

11. ASSESSMENT OF THE RESULTS

Homogeneity of the material

The calculated probability as a percentage is a measure for the homogeneity of the meal mix or grains in question from which the samples were taken. The probability indicates how probable it is that the tested sampled corresponds to a perfect mix.

If the value found in the test is identical with a probability of more than 5 % (0.05) then it may be assumed on the basis of the probability calculation that there is a "perfect mix".

If the value found in the test is identical with a probability of between 1% and 5% (0.01 to 0.05) then it may be assumed on the basis of the probability calculation that there is a "probable significant deviation from a perfect mix". This refers to a borderline case about which no unambiguous statement can be made. The test must be repeated.

If the value found in the test is identical with a probability of less than 1% then it may be assumed on the basis of the probability calculation that there is a "probable significant deviation from a perfect mix".

A key feature of the poisson distribution is that when there is a "perfect mix" the standard deviation of a test series must be (on average) equal to the square root of the average.

Two examples follow of the calculation of a homogenous and a non-homogenous mix.

Example 1: Homogeneous mix

Sample number	Number of particles counted, x	Average m	Difference $x_n - d_n$	Square of difference d_n^2
1	47	50	3	9
2	53	50	3	9
3	45	50	5	25
4	55	50	5	25
5	50	50	0	0
Average $x=50$			Sum $d_n^2=S=68$	

Table 4: Example of the calculation for a homogenous mix

Number of samples: $n=5$

Chi squared value χ^2 : $S: x = 1$ ($68: 50 = 1.4$)

Table values from table 3:

horizontal: $n - 1 = 4$

vertical: 1

calculated probability: 0.910

calculated probability in %: 91.0%

Result: The calculated probability is greater than 5 %; there is therefore a homogenous mix.

Example 2: Non-homogenous mix

Sample number	Number of particles counted, x	Average m	Difference $x_n - d_n$	Square of difference d_n^2
1	43	53	10	100
2	57	53	4	16
3	70	53	17	289
4	35	53	18	324
5	61	53	8	64
Average x=53			Sum $d_n^2 = S = 793$	

Table 5: Example of the calculation for a non-homogenous mix

Number of samples: $n=5$
Chi squared value χ^2 : $S: x = 15$ ($793: 53 = 15$)
Table values from table 3:
horizontal: $n - 1 = 4$
vertical: 15
calculated probability: 0.005
calculated probability in %: 0.5%

Result: The calculated probability is less than 1 %; there is therefore a non-homogenous mix.

12. NOTES

12.1 First sampling point

A feed mix is not homogenous after the dosage of the various components. Even after the grinding of the raw materials in the hammer mill this is only partly the case. Often finer raw materials are led around the hammer mill and carried straight to the mixer. A homogenous feed mix may therefore only be expected for the first time in the mixer. Taking samples directly from the mixer is difficult and may be dangerous and is certainly not recommended. The sampling should therefore be done after the mixer. In most companies this will be the outflow of the bunker under the mixer.

12.2 Storage of the samples

Samples which can not be examined in the short term should be stored in a dry area to retain sufficient free-flow for the test.

13. SAFETY

The control procedure is usually carried out in practice in a compound feed company.

For those who carry out the control procedure in a compound feed company the following safety rules apply:

- a. the operatives will make themselves aware before the start of the work of the safety instructions which apply in the compound feed company
- b. during their stay in the compound feed company the operatives are bound to follow the safety instructions of the compound feed company

14. PROCESSING OF COMPOUND FEED CONTAINING MICROTRACER

No special instructions.

15. LITERATURE

1. The use of Microtracers to determine Completeness of Mix

The use of microtracers for the determination of the homogeneity of mixes
David A. Eisenberg, President of Micro Tracers, Inc. of San Francisco

2. Mix with Confidence

Safe mixing

David A. Eisenberg, President of Micro Tracers, Inc. of San Francisco
International Milling Flour&Feed, June 1994

2.7 CONTROL PROCEDURE FOR THE MEASUREMENT OF CARRY-OVER IN ANIMAL FEED PREPARATION USING METHYL VIOLET

This text will be added later.