



Commodity Specification

**CANNED BONED WHITE
TURKEY MEAT**

July 2005



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I. GENERAL

A. Product Description

Canned boned white turkey meat (commodity) produced from the classes of ready-to-cook turkeys (poultry) described in this Specification will be packaged and packed in the following form as specified in the contract:

Canned Boned Turkey (213224) – Canned boned white turkey meat produced from ready-to-cook young, yearling, or mature turkeys. Twenty-nine ounces (822 g) of commodity must be packaged in a 401 x 411 size metal can and packed 24 cans per fiberboard shipping container. A purchase unit will consist of 840 shipping containers totaling 36,540 pounds (16,574 kg).

B. Food Security Requirements

Contractors and subcontractors participating in the commodity purchase program must have a documented food security plan that provides for the security of a plant's production processes and includes the storage and transportation of finished product after production. The plan shall address the following areas: (1) food security plan management; (2) outside and inside security of the production and storage facilities; (3) slaughter and processing, including all raw material sources; (4) shipping and receiving; (5) storage; (6) water and ice supply; (7) mail handling; (8) personnel security; and (9) controlled access to production and storage areas. Prior to the initial commodity production run, the food security plan shall be made available to USDA certification agents and thereafter, upon request.

C. Commodity Complaints

The contractor/producer must immediately report all complaints received on the commodity to the Contracting Officer.

II. COMMODITY SPECIFICATION

A. Basic Requirements

1. Date Processed. The commodity must not be processed and packaged more than 30 calendar days prior to the date of the contract.

2. Poultry Kind and Class. The commodity must be produced from young, yearling, or mature turkeys (AMS § 70.202).

3. Origin of Poultry. The commodity must be produced from poultry that was produced, raised, and processed in the United States, its territories or possessions, the Commonwealth of Puerto Rico, or the Trust Territories of the Pacific Islands. If the contractor processes or handles poultry carcasses and parts originating from sources other than the United States, its territories or possessions, Puerto Rico, or the Trust Territories of the Pacific Islands,

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the contractor must have an acceptable identification and segregation plan for these poultry carcasses and parts to ensure they are not used in the commodity produced under this Specification. This plan must be made available to a representative of the Grading Branch, Poultry Programs, Agricultural Marketing Service (AMS), United States Department of Agriculture (USDA) (Grader), and the Contracting Officer or agent thereof upon request. The contractor must ensure that both the contractor and subcontractor(s) maintain records such as invoices, or production and inventory records evidencing product origin, and make such records available for review by the Grader or other Government official(s) in accordance with Article 76 of USDA-1.

4. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 CFR Part 381) and be under the supervision of a representative of the USDA's Food Safety and Inspection Service (FSIS) (inspector). Inspection for contract and specification compliance will be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 CFR Part 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*) under the supervision of a Grader. The Grader will be responsible for certification of compliance with the requirements of this Specification for poultry; cooked poultry carcasses and parts; formulation of commodity; canned thermal-processed commodity; drained weight and net weight; packaging and packing; labeling and marking; sampling; and checkloading.

5. FSIS Requirements. The commodity must be produced and processed in an FSIS federally inspected establishment, be accurately marked and/or labeled, and meet all FSIS regulatory requirements, including all microbiological testing requirements, currently in place.

6. Poultry from Other Plants. Frozen and chilled poultry and poultry parts may be transferred or obtained from other plants, provided they: (a) have been processed, handled, and identified in accordance with this Specification, and (b) comply with the organoleptic and other applicable requirements of this Specification as evidenced by USDA certification.

a. Type, kind, and class of poultry; date slaughtered or date placed in frozen storage, as applicable; and USDA-assigned plant number must be shown on each shipping container.

b. The poultry must be at an internal product temperature not higher than 40 °F (4.4 °C) when shipped from the origin plant and when received at the destination plant.

7. Frozen Poultry. Frozen poultry and poultry parts may be used if they have been: (a) packaged to protect the product from freezer burn, dehydration, and quality deterioration during storage; (b) labeled as to kind and class of poultry and identified so the time in storage can be determined; and (c) held in frozen storage not more than 60 days.

8. USDA Sampling Option. USDA may select additional product for further inspection or may draw samples for laboratory analyses.

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B. Prerequisites for Poultry

1. Unacceptable Meat. Dark turkey meat, mechanically separated turkey meat (comminuted), giblets, and kidneys cannot be used in preparing the commodity.

2. Organoleptic Requirements. The poultry and poultry parts will be examined on a continuous basis for the following organoleptic requirements: poultry and poultry parts must be free of rancidity; free of fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, chlorine, or other off-odors; free of foreign materials (e.g., glass, paper, rubber, metal); must show no evidence of mishandling or deterioration; and must have a bright color and show no evidence of freezer burn or dehydration, or thawing and refreezing. Any sample of poultry that does not comply with the organoleptic requirements will be rejected for use under this Specification.

3. Meat and Skin Requirements. All meat and skin used in the commodity must meet requirements listed in Table 1.

a. White turkey meat. The following kinds of boneless, skinless breast meat, in the amounts specified, must be used to prepare the raw turkey portion (meat block) of the commodity:

(1) Breasts. Boneless, skinless, outer pectoral whole or half breasts must be used in the commodity.

(2) Optional - tenderloins. Whole or half tenderloins may be used in the commodity.

(3) Optional – scapula meat. Up to 10 percent of the meat portion in the formula may consist of turkey scapula meat.

(4) Optional – wing meat. Up to 7.5 percent turkey wing meat (first and second wing portion only) with attached skin or 5 percent wing meat without attached skin may be used.

b. Skin defects. All skin must be removed from each part or meat portion, except wings as provided in II.C.1.a. If skin is attached to the cooked wing meat, 10 wings will be examined for skin defects shown in Table 1. The frequency of sampling will be as outlined in Poultry Programs' acceptable quality level (AQL) Sample Plan 2 found in the Poultry Graders Handbook. If any sample has more defects than the maximum tolerance for the AQL, the product the sample represents will be rejected.

Table 1. Turkey Meat Organoleptic Requirements and Defects

	Defect
Organoleptic Requirements:	Meat is rancid ; has fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign or off-odors; contains foreign materials (e.g., glass, paper, rubber, metal); shows evidence of mishandling or deterioration; or does not have a bright color or shows evidence of dehydration or freezer burn or thawing and refreezing.
Boneless, Skinless Breast or Tenderloin. Boneless, Skinless Wing and Scapula Meat:	Fatty blubber , spongy fat, and membranes from the crop area. Skin exceeding an aggregate area equivalent to the area of a circle with a diameter of 0.50 inch (1.27 cm).
Breasts:	Whole breast with more than $\frac{3}{4}$ of the meat missing (half of a half-breast).
Tenderloins:	Tenderloin with more than one-half of the meat missing.
Wings with Skin Attached:	The presence of feathers, hair, and areas of moderate discolorations exceeding an area equivalent to the area of a circle with a diameter of 1 inch (2.54 cm).

C. Processing, Formulation, and Requirements for Commodity

1. Processing Requirements

a. Boneless, skinless turkey breast meat (meat from “breasts” as defined in 7 C.F.R. § 70.210); turkey scapula, up to 10 percent of the total weight for meat; and up to 7.5 percent turkey wing meat (first and second wing portion only) with attached skin, or 5 percent wing meat without attached skin may be used.

b. The commodity must be prepared from: (1) boneless skinless breast meat, tenderloins, boneless scapula meat, boneless wing meat with or without attached skin, water, and salt; or (2) cooked boneless skinless breast meat, cooked boneless scapula meat, cooked wing meat with or without attached skin, broth from cooked poultry or water, and salt. The use of the words “white meat/meat and broth” in this section means boneless skinless breast meat, boneless scapula meat, and/or boneless wing meat with or without attached skin; and poultry broth prepared from one of the kinds and classes of poultry specified in II.A.2.

2. Cooking

a. Poultry without giblets and poultry parts may be: (1) cooked with water without pressure, or (2) pressure cooked. During pressure cooking, the products do not need to be covered with water when there is a system for collecting broth. The method of cooking must

II.C.2.a.

produce a cooked product free of overcooked, burnt, scorched, bitter, metallic, cardboardy, rancid, or other flavors or odors foreign to properly cooked turkey.

b. Cooked meat may be held at 40 °F (-17.8 °C) or lower for not more than 5 days from time of cooking until canned, or the chilled cooked meat may be frozen and held at an internal product temperature of 0 °F (-17.8 °C) or lower.

3. Cooked Meat Defects

a. Organoleptic defects. The cooked meat will be examined on a continuous basis for compliance with the organoleptic requirements shown in Table 2. If the cooked meat or skin does not comply with the organoleptic requirements, it will be rejected for use under this Specification.

b. Defect examination. The cooking method used in the production of the commodity will determine at which point the poultry and poultry parts will be examined for cooked meat defects. As an option to cooking prior to thermal processing, cans may be filled with meat, and broth or water solution, and the commodity cooked during thermal processing. If this method is selected, meat will be examined for defects after thermal processing.

(1) Poultry meat that is canned and then cooked shall be examined after canning and thermal processing for defects listed in Table 2.

(2) Poultry meat that is cooked and then canned shall be examined in the cooked state prior to canning for defects listed in Table 2.

Table 2. Cooked Poultry Meat Organoleptic Requirements and Defects

Organoleptic Requirements:	The meat must be free of foreign materials (e.g., glass, paper, rubber, metal) and odors, which are not characteristic of properly cooked and handled poultry meat; for example, rancid, metallic, stale, sour, or scorched.
Meat Defects:	Areas of moderate discolorations exceeding an area equivalent to the area of a circle with a diameter of 1 inch (2.54 cm).

4. Size Reduction of Meat. The meat must be processed in a manner that will minimize stringy texture. The larger pieces of meat must be cut into chunks, which are a maximum of 1.25 inches (3.18 cm) in size. The meat must not be ground or shredded.

II.C.

5. Formulation. The following proportions of meat, salt, and broth or water must be used in preparing the commodity:

	<u>Percent by Weight</u>
Meat (may include up to 10 percent scapula meat and up to 5 percent skinless wing meat (see II.C.1. and II.C.5.b.))	95.00 – 99.00
Broth or Water (maximum)	4.50
Salt	<u>0.50</u>
	100.00

a. The amount of scapula meat, wing meat, and broth or water may be reduced and replaced with additional boneless skinless breast meat.

b. As an alternative, the wing meat portion may include up to 7.5 percent wing meat with attached skin, or 5 percent wing meat without attached skin.

6. Broth or Water

a. Broth or potable water must be used in the commodity. Broth used must be a flavorful broth from the unpressurized cooking of not less than two or more than four batches of poultry in the same broth. A continuous cooking method may be used, provided water is added during the cooking operation and the process results in a broth equivalent to that described in the preceding sentence. Broth from one batch of pressure-cooked poultry may be used. Broth produced by cooking only fat and bones cannot be used. Broth must be maintained at a temperature of 160 °F (71.1 °C) or higher or must be cooled to and maintained at a temperature or 40 °F (4.4 °C) or lower within 4 hours of preparation. Broth may not be held more than 48 hours unless the broth is frozen or dried.

b. Other methods of preparing broth or handling the broth may be approved by the Deputy Administrator of Poultry Programs, in writing. (Approvals will be granted on an individual plant basis after a review of the process and when the resulting method is found acceptable by supervisory personnel of the Grading Branch, Poultry Programs.)

c. Broth must be free from bitter, rancid, metallic, cardboardy, soapy, scorched, burnt, overcooked, stale, and other off-odors or off-flavors foreign to properly processed turkey broth.

7. Mixing. Salt must be thoroughly mixed with water or broth prior to being added as a solution to the meat. Incorporation of the water/salt solution must be accomplished without grinding or shredding the meat.

II.C.

8. Packaging. All packaging materials must be clean and in new condition and must not impart odors or flavors to the product. A supplier of packaging material must furnish a guaranty that the packaging material complies with FSIS regulations.

a. Packaging material. The commodity must be packaged in cans. The cans must be metal, round, and open-style with welded side seams. They must be equivalent in construction, base plate (tinplate or chromium-coated steel), and enamel coating to those in commercial use for the commodity specified in this Specification.

b. Filling cans

(1) Filling. Cans may be filled by:

(a) First adding the homogenous mixture of meat to each can and then adding the broth or water solution to each can, or filling with homogenous mixture of meat, and broth or water solution; or

(b) First adding the homogenous mixture of cooked meat to each can and then adding the broth or water solution to each can, or filling with homogenous mixture of cooked meat, and broth or water solution.

(2) 29-ounce cans. Twenty-nine ounces (822 g) net weight of commodity must be packed in 401 x 411 size metal cans.

9. Net Weight. The net weight of the commodity will be determined in accordance with Poultry Programs' procedures.

D. Thermal Processing

1. The filled can must be vacuumized, hermetically sealed, and thermal processed in accordance with FSIS regulations. The thermal-processed commodity must have a stable shelf life under the conditions of long-term, nonrefrigerated storage and transportation. The exterior of the can must be dry, clean, and free from rust, fat, and grease before packing into shipping containers.

2. If the meat is not cooked prior to thermal processing, the thermal processing step must provide a cooked commodity in accordance with this Specification. Additionally, meat defects will be examined for this product after thermal processing in accordance with II.C.3.b.1.

E. Lots, Sublots, and Sampling

1. Definition of a Lot

- a. A lot is defined as the amount of commodity produced during a processing shift.
- b. Unless otherwise specified, the commodity will be: (1) sampled, examined, and tested; and (2) accepted, rejected, or accepted subject to a price discount on a lot basis.

2. Definition of a Sublot

- a. A lot may be separated into sublots for the purpose of sampling, determining drained weight, and compliance with organoleptic and commodity defect requirements
- b. Commodity sampled and analyzed on the basis of sublots will be accepted, rejected, or accepted with a discount on a subplot basis.

3. Definition of a Sample

- a. A sample is one 29-ounce (822-g) can of commodity or its equivalent.
- b. The Grader will draw samples at random for compliance with the organoleptic requirements, and determination of drained weight after thermal processing.
- c. Commodity that is cooked after canning shall be examined for organoleptic requirements, drained weight, and commodity defects after thermal processing.
- d. For commodity that is cooked prior to canning, the Grader will collect sample cans from each lot or subplot at random **prior to** or **after** thermal processing to examine for the commodity defects (see II.F.3.), as determined by the contractor/processor. The contractor/processor must select a sampling option (either option I or option II) prior to the start of production.

(1) If the contractor/processor elects to sample cans **prior to** thermal processing (option I), the number of samples from a lot for the drained weight and the determination of organoleptic requirements and defects will be as detailed in Table 3.

(a) For the determination of organoleptic requirements and defects under option I, no additional separation of the lot into sublots will be allowed.

(b) Samples for organoleptic requirements (see II.F.2.) and drained weight determination (see II.F.1.d.) will be drawn after thermal processing and will represent 1 day's production.

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Table 3. Samples Drawn Online from a Lot or Sublot - Option I

29-ounce (822-g) cans		
Lot or Sublot	Organoleptic Requirements and Defects	Drained Weight
Lot	2 cans per sampling interval	10 cans
Sublot*	2 cans per sampling interval	5 cans

* The total number of samples drawn from all sublots in a lot must be equal to or greater than those specified for a lot.

(2) If the contractor/processor elects to sample cans **after** thermal processing (option II), the sampling of commodity from a lot or a sublot will be as detailed in Table 4:

Table 4. Samples Drawn from a Lot or Sublot - Option II

29-ounce (822-g) cans		
Lot or Sublot Total No. of Cans	Drained Weight	Organoleptic Requirements and Defects
	Number of Cans	
Lot Total = 16 cans	First 10 cans	First 10 + 6 cans
	16 cans total	
Sublot * Total = 8 cans	First 5 cans	First 5 + 3 cans
	8 cans total	

* The total number of samples drawn from all sublots in a lot must be equal to or greater than those specified for a lot.

F. Requirements for Thermal-Processed Commodity

1. Drained-Weight Requirements and Determination

a. Samples. After thermal processing, the Grader will randomly draw sample cans (as defined in II.E.3.a.) to determine drained weight. The 29-ounce (822-g) filled cans from a lot or sublot must average not less than 20.0 ounces (567 g) of commodity on a drained-weight basis.

b. Discounts. Lots or sublots of commodity with a drained weight averaging:
 (1) greater than or equal to 18.7 ounces (530 g) and less than 20.0 ounces (567 g) will be accepted with the deviations subject to the price discount indicated in Table 5.

II.F.1.

c. Rejections. A lot or subplot of filled cans with a drained weight averaging less than the weights indicated in Table 5 will be rejected.

Table 5. Drained Weights and Discounts

Drained Weight Basis Average for Lot or Sublot	Applicable Discount (Percent of Contract Price)	Rejected Lot or Sublot
29-ounce (822-g) cans		
Greater than 19.4 oz. (550 g) and less than 20.0 oz. (567 g)	2.25 percent	Average less than 18.7 oz. (530 g)
Greater than or equal to 18.7 oz. (530 g) and less than or equal to 19.4 oz. (550 g)	4.50 percent	

d. Determination. The drained-weight of the sample cans will be determined 24 to 72 hours after the day of the processing shift in which the product was produced. The contents of each sample can shall be weighed after draining product, with a No. 8 sieve, for 2 minutes for a 29-ounce (822-g) can. The temperature of the commodity at time of weighing must be 75 ° ± 5 °F (23.9 ° ± 2.8 °C). The average drained-weight results will be reported to the nearest 10th of an ounce on the USDA shipping certificate.

e. Rejected product. If the commodity in a lot or subplot is rejected for drained weight, the contractor/processor may request an appeal, which must be performed within 6 calendar days from the end of the processing shift on which the product was produced. The contractor/processor may remove cans suspected of being out of compliance and reoffer the balance of the lot or subplot once for acceptance. Those cans determined out of compliance with drained weight requirements will be rejected but may be reworked in accordance with II.F.4.

2. Organoleptic Requirements. After thermal processing, the commodity will be sampled (as defined in II.E.3.) and examined for compliance with the following organoleptic requirements: The commodity must have an appetizing appearance, odor, flavor, and texture, and must be free of off-flavor or off-odors; for example, overcooked, burnt, scorched, sour, stale, cardboardy, metallic, bitter, or rancid. A lot or subplot of commodity that does not comply with these organoleptic requirements will be rejected for use under this Specification.

3. Commodity Defects. The contractor/processor may select one of the two options (II.F.3.a. or b.) for the examination of commodity defects. Once an option is selected, the contractor/processor may not change options until the end of 1 day's production. Samples of commodity with more defects than the maximum tolerance for either option will result in rejection of the lot or subplot the samples represent. Product cooked after canning is not eligible for commodity defect sampling under option 1.

II.F.3.

a. Option I - Examination prior to thermal processing. The samples (see II.E.3.d. (1) for sampling) will be randomly selected online prior to canning or thermal processing and examined for the defects shown in Table 6.

(1) The number of defects allowed will be those outlined in Poultry Programs' SPL-2 found in the Poultry Graders Handbook. Separate examinations will be made for: (a) bone and (b) other defects.

(2) Regardless of the kind and number of defects (within Table 6) found, any sample with bone or hard bone-like material greater than 0.40 inch (1.02 cm) will be cause for the rejection of the product the sample represents.

(3) If the number of bone defects exceeds the "target" level for the respective sample number, or results in a rejection, the frequency of sampling for bone defects will be increased to a sample drawn twice each sampling interval until the cumulative number of bone defects reverts back to the "target" level.

(4) If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

Table 6. Commodity Defects - Option I

Meat Defects:	A defect for meat is the presence of:
Bone:	Bone or hard bone-like material in a sample greater than 0.40 inch (1.02 cm) (see II.F.3.a.(2)). Bone or hard bone-like material in a sample less than or equal to 0.40 inch (1.02 cm).
Other:	Dark colored (due to blood) vein or artery more than 1 inch (2.54 cm) in length; or Bruises, blood clots, and moderate discolorations that exceed an area equivalent to a circle with a diameter of 0.30 inch (0.76 cm).

b. Option II - Examination after thermal-processing

(1) After drained weight determination, the samples (see II.E.3.d.(2) for sampling) will be examined for the defects shown in Table 7.

(2) Separate examinations will be made for: (a) bone and (b) other defects. The number of defects allowed in a sample representing a lot or subplot will be as shown in Table 7.

II.F.3.b.

(3) Regardless of the kind and number of defects (within Table 7) found, any sample with bone or hard bone-like material greater than 0.40 inch (1.02 cm) will be cause for the rejection of the product the sample represents.

(4) If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

Table 7. Thermal-Processed Commodity Defects Allowed - Option II

	Criteria	Tolerance
Meat Defects:	A defect for meat is the presence of:	Rejected. See II.F.3.b.(3).
	Bones: Bone or hard bone-like material * in a sample greater than 0.40 inch (1.02 cm).	
Other:	Bone or hard bone-like material * in a sample less than or equal to 0.40 inch (1.02 cm).	6 bones permitted per lot
	Dark colored (due to blood) vein or artery more than 1 inch (2.54 cm) in length.	3 bones permitted per subplot
Other:	Bruises, blood clots, and moderate discolorations that exceed an area equivalent to a circle with a diameter of 0.30 inch (0.76 cm).	10 defects permitted per lot
		5 defects permitted per subplot

* Bone or hard bone-like material is material that does not break up or disintegrate when subjected to pressure from a spatula, flat side of a knife, or fork.

4. Reworked Commodity

a. Sample cans examined by the Grader or product rejected for defects exceeding the maximum tolerances; or unsatisfactory due to drained weight; may be reworked and incorporated into formulated batches of cooked product, prior to thermal processing, provided:

- (1) The defects are removed from the product;
- (2) The product is incorporated at a maximum of 5 percent of the formulated batch; and
- (3) The product is removed from cans and reworked into a batch within 72 hours.

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b. X-ray equipment may be used to examine product to be reworked provided:

(1) The equipment and x-ray examination procedures are found to be in compliance with FSIS regulations and procedures; and

(2) A Grader monitors the x-ray and rework procedure.

(3) The contractor/processor may remove product cans from a lot or subplot suspected of containing defects after the x-ray examination and the balance of the lot or subplot may be reoffered for acceptance. Product containing defects may be reworked once.

5. Contaminated Commodity. A lot or subplot of commodity that contains foreign matter--for example, paper, plastic, rubber, or metal--will be handled by FSIS. Samples that contain dark turkey meat, comminuted meat, giblets, or kidneys will result in rejection of the lot or subplot the samples represent.

6. Packing. All packing materials must be clean and in new condition and must not impart odors or flavors to the product.

a. Shipping containers. Shipping containers must: (1) be good commercial fiberboard containers that are acceptable by common or other carrier for safe transport to point of destination; (2) be of such size to pack the commodity without slack filling or bulging; (3) withstand the stresses of handling, shipping, stacking, and storage; and (4) be closed by commercially acceptable methods and materials. Steel or wire straps or staples must not be used for the final closure. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. However, staples may be used to manufacture and to assemble the fiberboard shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.

b. 29-ounce cans. Twenty-four 29-ounce (822-g) cans of commodity must be packed four in length, three in width, and on end in two layers in each shipping container.

III. LABELING

Commercial labeling (III.A. and III.E.-F.) or USDA, AMS labeling (III.B.-F.) must be used. When commercial or USDA, AMS (USDA) labeling is selected, both the packages and shipping containers within a purchase unit must be labeled in that format. **THE CONTRACTOR MUST USE THE SAME LABEL FORMAT (EITHER COMMERCIAL OR USDA) WITHIN A PURCHASE UNIT.**

III.

A. Commercial Labeling Requirements

Commercially labeled packages and shipping containers must be labeled in accordance with FSIS requirements. Labeling must be approved by FSIS prior to acceptance for use under this Specification.

1. Distributor Labels. Commercial labels must be the processor's own commercial label. Distributors' labels will not be allowed.

2. Traceable Product. The processor must establish a product identification and record system that clearly links product by place and time of manufacture to specific USDA contracts and destinations. When the company uses the same commercial label for the product certified as complying with this Specification and commercial product, the identification system must differentiate between USDA and non-USDA products. An alpha numeric code may be used for information that is in addition to FSIS labeling requirements. The required product identification and record system, including codes, must be reviewed by USDA, AMS before production begins for the contract(s).

B. USDA Labeling Requirements

When USDA labeling is used, any deviation from labeling requirements in this Specification must be approved by the Contracting Officer, in writing, prior to the start of production. Labeling and marking of the shipping containers must be in accordance with this Specification. Labeling and marking information must be water-fast, nonsmearing, of a contrasting color, clear, and readable.

C. USDA Labeled Packages

1. Requirements. The information in the form and arrangement illustrated in EXHIBIT 1 must be legibly labeled, printed, or lithographed on each can. The label consists of two separate panels and may be applied as a wraparound label. Additionally, the following is required on each 29-ounce (822-g) can:

2. Universal Product Bar Code

a. A Universal Product Code (UPC), code and symbol, must appear on each 29-ounce (822-g) can and each shipping container with 29-ounce (822-g) cans. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop indicators must be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance with UPC guidelines published by Uniform Code Council, Inc., Princeton Pike Corporate Center, 1009 Lenox Drive, Suite 202, Lawrenceville, NJ 08648.

III.C.2.

b. The contractor must use the code furnished by USDA. USDA has acquired a unique manufacturer's identification number for the commodity purchase programs and will use a unique item code number for the commodities purchased under this Specification. The contractor need not join the Uniform Code Council, Inc.

c. The 12-digit UPC code for 29-ounce (822-g) cans is 7 15001 01554 9.

3. Plant and Lot Number. The USDA-assigned plant number and the lot number of the commodity must be embossed, stamped, or printed on each individual can or on one end of each can.

D. USDA Labeled Shipping Containers

1. Labeling and Marking Information

a. Requirements. Labeling and marking information must be: (1) preprinted, stamped, or stenciled on each shipping container; or (2) printed on a pressure-sensitive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 2 and 3.

b. Nutritional labeling. A nutritional label, indicating the nutrient content of the commodity, is required on the principle display panel of each shipping container of 29-ounce (822-g) cans. This nutritional facts information or "nutrition facts panel" must be preprinted on the principle display panel of each shipping container, or printed on a pressure-sensitive label and applied to the principle display panel of each shipping container. The pressure-sensitive label must not cover or conflict with the labeling requirements of this Specification.

c. Universal product bar code

(1) A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on each shipping container. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop indicators will be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance with UPC guidelines published by Uniform Code Council, Inc., Princeton Pike Corporate Center, 1009 Lenox Drive, Suite 202, Lawrenceville, NJ 08648.

(2) The contractor will use the code furnished by USDA. USDA has acquired a unique manufacturer's identification number for the commodity purchase programs and will use a unique item code number for the commodity purchased under this Specification. The contractors need not join Uniform Code Council, Inc.

(3) The 14-digit UPC code for shipping containers of 29-ounce (822-g) cans: 1 07 15001 01554 6.

III.D.1.c.

(4) The UPC code must be placed in the lower right-hand corner of the principle display panel of each shipping container.

2. Recycle Symbol and Statement. The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 4. The statement “PLEASE RECYCLE” is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.

3. Inventory Control Label. The processor may use a pressure-sensitive label to place any additional information (including bar codes) for processor inventory control purposes. This label may be applied somewhere on the surface of the shipping container. The label must not cover or conflict with the labeling requirements of this Specification.

E. Additional Labeling Issues

The following are not acceptable for use under this Specification:

1. Commercial labels that do not have a processor traceability system and code.
2. Commercial labeling traceability coding and systems that have not been reviewed by a representative of Poultry Programs, Grading Branch.
3. Distributor commercial labels.
4. Two or more different commercial labels in the same purchase unit.
5. Commercial labels and USDA labels in the same purchase unit.

F. F.a.s. Vessel Deliveries

F.a.s. vessel deliveries that are not source loaded in a seavan are required to show the final destination’s overseas address as provided in the Notice to Deliver. The address must be clearly printed on at least two sides of each pallet.

IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY

A. Verification of Materials and Defects

1. Verification of Packaging and Packing Materials

The contractor must verify compliance with packaging, packing, and marking material requirements by furnishing the Grader the following certification on company stationery signed by a person authorized to do so by the contractor:

IV.A.1.

"(I) (We) certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under the terms of the Commodity Specification for Canned Boned White Turkey Meat, dated July 2005, comply or will comply with the terms of this Commodity Specification."

Name _____

Title _____

One certification is adequate for all production under this Specification.

2. Container, Labeling, and Marking Defects

a. Defects. Cans and shipping containers will be examined for container, labeling, and marking defects in accordance with the United States Standards for Condition of Food Containers and the USDA publications "Procedures for the Inspection of the Condition of Food Containers" and "Visual Aids for Inspection for Metal Containers."

b. Tolerance for defects. If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable Poultry Programs' sample plan, the delivery unit will be rejected.

B. Inspection and Checkloading

1. Requirements. Inspection for contract compliance will be made by a USDA representative, in accordance with 7 CFR Part 70, FSIS regulations, and this Specification, at site of processing, both during and after processing and packaging. A USDA representative may select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination. Inspection records must be complete and made available to USDA, as requested, to assure contract compliance.

2. Procedures. The inspection and checkloading required by Article 54 and 55 of USDA-1 must be performed by the Grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest Grading Branch field office or the Chief, Grading Branch, Poultry Programs, AMS, USDA, Room 3938-S, STOP 0258, 1400 Independence Avenue, SW, Washington, D.C. 20250-0258, telephone (202) 720-3271. The quality, quantity, weight, packaging, packing, and checkloading of the commodity must be evidenced by USDA certification. The contractor must not ship the commodity unless informed by the Grader that the designated lot or subplot to be shipped meets contract specifications.

V. UNITIZATION

Each delivery unit of canned boned poultry must be unitized (palletized and stretchwrapped) and comply with the following:

A. Pallets

Pallets must be good quality, wood, 48 inches x 40 inches, nonreversible, flush stringer, and partial four way entry. Each pallet of shipping containers must be stretchwrapped with plastic film in a manner that will secure each container and layers of containers on the pallet. Palletized product must be loaded in a way that will prevent shifting and damage to containers of product. Pallet loads shall be stacked in a manner that minimizes the overhang of the shipping containers over the edges of the pallets and exposes the principal display panels to facilitate certification examinations.

B. Pallet Exchange

Contractors may arrange for pallet exchange with consignees; however, USDA is in no way responsible for such arrangements.

VI. SHIPMENT AND DELIVERY

Shipment and delivery must be made in accordance with this Specification, the applicable Announcement and Invitation, and Articles 56, 57, and 64 of USDA-1, as amended by the Announcement. In addition, the contractor must adhere to the following provisions:

A. Contract Compliance Stamp

Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number. A Grader, or other authorized personnel under the supervision of the Grader, will stamp one end of each shipping container prior to shipment. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

B. Grading Certificate

A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading must accompany each shipment.

1. Railcar or Piggyback. If shipment is by rail or piggyback, the certificate must be placed in the railcar or trailer for easy access to the Grader, warehouseman, or consignee, as applicable.

2. Trucks. If shipment is by truck, the driver must, upon delivery, give the certificate to the Grader, warehouseman, or consignee, as applicable.

VI.

C. Loading and Sealing of Vehicles

Loading must be in accordance with good commercial practices and the sealing must be done at origin under the supervision of a Grader.

1. Railcar. Each railcar must be sealed. The contractors are responsible for arranging railcar deliveries of more than one delivery unit so that each delivery unit contained in the same railcar can be completely separated and sealed.

2. Truck or Piggyback. Truck or piggyback shipments must be sealed at origin. A delivery unit shipped by truck or piggyback which includes split deliveries to multiple destinations will not require separation by sealing each drop.

D. Delivery Notification

Notwithstanding the provisions of Article 56(c) of USDA-1, as amended by the applicable Announcement, the contractor must follow the instructions in the Notice to Deliver issued by the Kansas City Commodity Office (KCCO) concerning delivery notification. Such notification and information of impending delivery is vital in proper execution of delivery. The contractor must notify the State distributing agency and the consignee of shipment per instructions in the Notice to Deliver. For rail or piggyback shipments, notification shall be made on the day of shipment. For truck shipments, notification of the estimated arrival time should be made as far in advance of delivery as possible. In addition, for truck or piggyback shipments, the contractor must request and keep scheduled appointment(s). Unloading appointments for truck or piggyback shipments must be requested from the consignee contact party(ies) at least 24 hours in advance of delivery.

1. In-Plant Deliveries. When in-plant delivery is made, the contractor must notify the appropriate resident Grader and furnish applicable information.

2. Delivery in Storage. Delivery may be made in store provided the destination in the Notice to Deliver and the place the contractor has the commodity in storage are the same. Inspection and certification by a Grader are also required for transfers in store.

E. Split Deliveries

The contractor is responsible to deliver the quantity stated on each Notice to Deliver to each destination. Contractors must provide to the Grader, at time of shipment, the number of boxes and pounds for each destination. At the option of the contractor, a purchase unit with two or more Notices to Deliver (split deliveries) for multiple destinations may be delivered on separate trucks provided each truck ships the total quantity stated on the Notice to Deliver. Any additional costs will accrue to the contractor's account.

Craig A. Morris
Deputy Administrator
Poultry Programs

EXHIBIT 1

Label Information for 29-Ounce Cans of White Turkey Meat

The USDA-assigned plant number and the lot number of the commodity must be embossed, stamped, or printed on each individual can or on one end of each can.

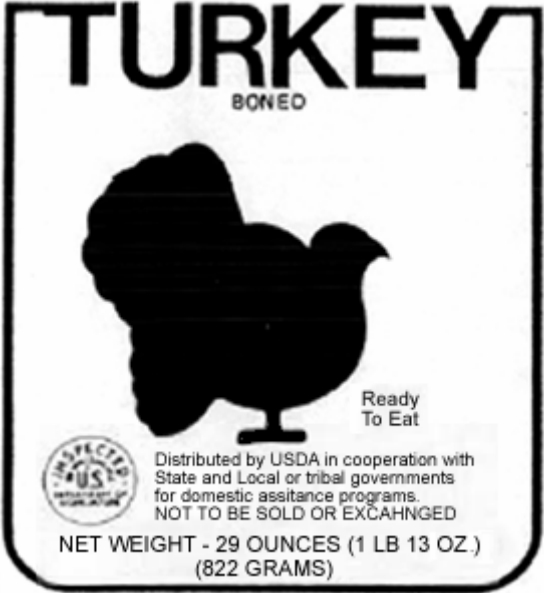

	<p>Nutrition Facts Nutrition Facts must comply with USDA-FSIS regulation 9 CFR 381.400 for poultry.</p> <p>Ingredients: White turkey meat-not less than 95%; Turkey broth-not more than 4.50%; Salt-0.50% (flavor).</p> <p>Name and Address of Contractor</p>	 <p>Bar Code: 715001015549</p>
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EXHIBIT 2

USDA Labeled Shipping Containers

Marking Information: Shipping containers must be marked substantially as shown below. Detailed USDA labeling information is provided in Exhibit 3. Markings must be preprinted, stamped, stenciled on containers, or printed on a separate pressure-sensitive label and applied to containers. The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height and must be printed on the “TOP PANEL” or principle display panel. The processor’s name, address, and phone number must be printed on the “TOP PANEL” or principle display panel. The processor name and address info must indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.

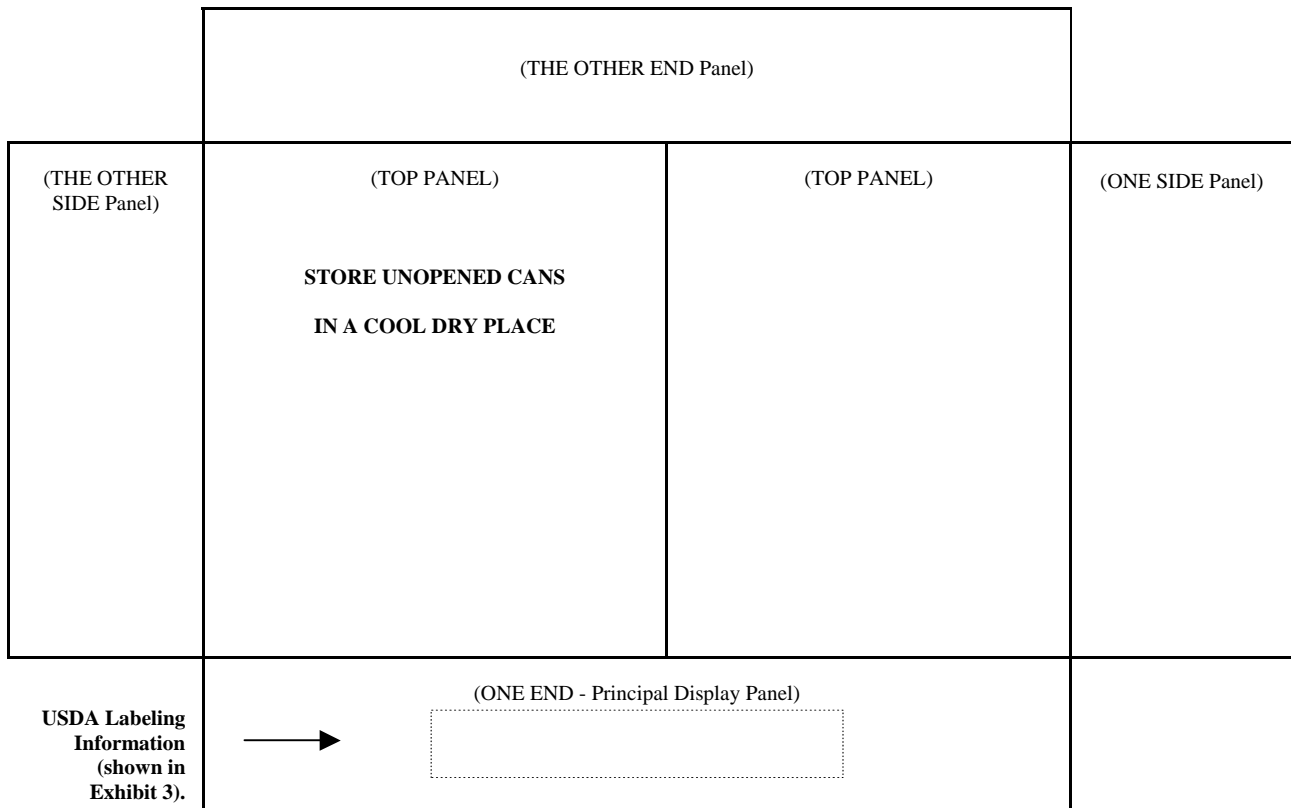


EXHIBIT 3

USDA Label Information for Canned Boned Turkey

Marking Information: USDA labeling information must be printed on the principal display panel of each shipping container as provided in Exhibit 3. Markings must be legibly preprinted, stamped, stenciled on containers, or printed on a separate pressure-sensitive label applied to containers. The applicable product name “CANNED BONED WHITE TURKEY MEAT” must be shown. The applicable UPC 14-digit I 2/5 code, symbol and code, must be shown in the lower right-hand corner of the principal display panel. The USDA symbol copy on back of Specification, must be a minimum of 2.25 inches (5.72 cm) in height and must be printed on the “TOP PANEL” or principal display panel. The processor’s name, address, and phone number must be printed on the “TOP PANEL” or principal display panel. The processor name and address info must indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.



**CANNED BONED WHITE TURKEY MEAT
FULLY COOKED**

Ingredients:

Processor’s
Name, Address, and Phone Number

Nutrition Facts Panel
May Be Placed Here
(as applicable)

**Store Unopened Cans In A
Cool Dry Place**

24/29-Ounce (822-g) Cans
Net Weight 43.50 LBS. (19.70 KG)

CONTRACT NO. _____
DATE PACKED Month, Day, and Year

UPC Symbol and Code

EXHIBIT 4

“Please Recycle” Symbol and Statement



**PLEASE
RECYCLE**

USDA SYMBOL

