

August 19, 2020

AMENDMENT 1

COMMODITY SPECIFICATION for SHELLED TREE NUTS APRIL 2020

The purpose of this amendment is to revise the specification for Shelled Tree Nuts. Specifically, to:

- Revise the individual requirements for Whole Shelled Almonds

New/revised text is in **blue**.

II. INDIVIDUAL COMMODITY SPECIFICATIONS

Whole Shelled Almonds

Inspection and Certification for grade must be performed before processing and must meet all of the requirements listed below, as well as the current issuances of the Commodity Specification for Shelled Tree Nuts and the Master Solicitation for Commodity Procurement – Domestic Programs (MSCP-D).

1. **Process Types:** The Whole Almonds may either be Natural (Pasteurized) **or** Roasted. The Natural and Roasted process types may not be intermingled within a truckload.
2. **Grade:** U.S. No. 1 **prior to processing**, which includes a chip and scratch allowance of 10 percent.
 - a. For all Mission types almonds must meet all the requirements of U.S. No. 1 grade **except** for an additional 10 percent chip and scratch allowance (20% total) prior to processing.
3. **Style - Whole**
4. **Types:** Nonpareil, California, and Mission.

The specific varieties classified as Nonpareil, California, and Mission, are adapted from "Almond Variety Update, 1985, by the Almond Board of California"
5. **Size:** Whole style: The following **count ranges per ounce** are permissible: 18/20, 20/22, 23/25, 25/27, 27/30, 30/32, 32/34, 34/36, 36/40, 34/40, 40/50.
 - a. When a range in count is specified, the whole kernels shall be fairly uniform in size, and the **average count per ounce** shall be within the range specified. Doubles and broken kernels shall not be used in determining counts.
 - b. Size designations may not be intermingled within a truckload.
6. **Final Package size:** 12/2 lb. For shipments of almonds between the supplier and final package point, the bulk containers may be of any size which is mutually agreeable between both parties.

7. Treatment/Fumigation/Pasteurization/Roasting: The whole natural type almonds shall be treated with Propylene Oxide (PPO), steam treatment, heat treatment, such as roasting, drying, pasteurization, or other validated methods that achieves a minimum of 4 log reduction of Salmonella bacteria. Verification that such treatment has been performed must be provided to the SCI Federal or Federal/State inspector.

- a. For natural type, the fumigation/pasteurization requirement for whole natural type almonds must occur as near as possible, but not exceed 45 calendar days prior to final packaging.
- b. Roasted product need not be fumigated but must be roasted and achieve a minimum of 4 log reduction of Salmonella bacteria, and, as near as possible, but not exceed 45 calendar days prior to final packaging.

8. Analytical and Microbiological Requirements and Methods:

A. Aflatoxin testing:

Samples for Aflatoxin testing must be drawn by the SCI Federal or Federal-State Inspection Service and certified by DFA of California (Safe Food Alliance) or a USDA approved lab. A Certificate of Conformance must be furnished to the Federal or Federal-State Inspector and are valid for 45 calendar days. Samples must be drawn prior to processing, and must meet the following requirements:

Analysis for:	Requirement	Method
Aflatoxins	<15 ppb	AOAC-RI #050901 or equivalent

USDA approved labs may be found at: [Official Listing of USDA and USDA-Approved Laboratories for Analysis of Aflatoxins.](#)

B. Analytical and Microbiological testing.

Samples for Analytical and Microbiological testing must be drawn by the SCI Federal or Federal-State Inspection Service and certified by DFA of California (Safe Food Alliance) or a USDA approved lab. A Certificate of Conformance must be furnished to the Federal or Federal-State Inspector and are valid for 30 calendar days. Samples must be drawn after roasting or fumigation and must meet the following requirements:

- a. Moisture:
 - i. Roasted (Dried): Maximum 3.5% - AOAC 930.15 or equivalent method
 - ii. Natural (Pasteurized): Maximum 6.5% - AOAC 930.15 or equivalent method
- b. Free Fatty Acids (FFA): Maximum 1.5% - AOAC 996.23 or equivalent method.
- c. Peroxide value (PV): Maximum 5.0 % - AOAC 940.28 or equivalent method.
- d. Microbiological: See below.

Analysis for:	Requirements	Method
Aerobic Plate Count	< 10,000 CFU/g	AOAC 996.23 or equivalent
<i>Salmonella spp.</i> (375g)	Negative	BAM Chp 5; AOAC 2013.01 or equivalent

<i>Listeria spp.</i> (375g)	Negative	AOAC 2004.06, 2013.10 or equivalent
<i>Staphylococcus aureus</i>	< 20 CFU/g	(BAM Chp 12) AOAC 2003.07 or equivalent
<i>Escherichia coli</i>	Negative	(BAM Chp 4) AOAC 991.14 or equivalent
Yeast & Mold	< 3,000 CFU/g	(BAM Chp 18) Pour Plate or equivalent

If bulk product is to be shipped to another facility for final packaging (12/2lb bags), the shipper will supply the final packaging facility with the Grading Certificate as well as a Certificate of Conformance showing the results of analytical and microbiological testing.

9. Roasted can be nitrogen flushed or vacuum packed.

10. Shipping, Storage, and Case markings:

- a. The packaged almonds must be shipped and held at an air temperature not to exceed 50 degrees F.
- b. At final destination, the almonds must be stored under refrigeration at 35 to 40 degrees F, and if possible, 40% to 60% relative humidity. This is to ensure an adequate shelf-life. The case markings must read: “STORE UNDER REFRIGERATION 35 TO 40 DEGREES F.”

Bulk product inspected at shipping point destined for packaging into final primary containers (12/2lb bags) must have a “Positive Lot Identified” (PLI) sticker and be received intact by a USDA employee at the receiving facility. The product must be packaged into the 12/2 lb. bags within 30 calendar days of the quality inspection. Both facilities are required to have current SCI Plant Surveys and Food Defense System Safety audits.

11. Truckload case count: 1,540 per truckload.

12. Material Codes and UPC numbers

Shelled Tree Nuts	WBSCM Material	Primary Container	Secondary Container
Almonds Roasted Whole Shelled (12/2 lb.)	100393	7 15001 00393 5	1 07 15001 00393 2
Almonds Natural Whole Shelled (12/2 lb.)	100907	7 15001 00907 4	1 07 15001 00907 1

All other terms and conditions remain unchanged.