



## **Agricultural Marketing Service**

### **Commodity Specification**

# **TURKEY AND TURKEY PRODUCTS**

**APRIL 2013**

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## **I. GENERAL**

### **A. Product Description**

Young turkeys or turkey roasts (commodity) produced from ready-to-cook young turkeys under this Specification will be packaged and packed in the following forms as specified in the contract:

Consumer Pack (100123) - Consumer packaged, frozen young turkeys without necks and giblets, basting optional. Turkeys must weigh not less than 12 pounds (5.44 kg) and not more than 22 pounds (9.98 kg) per carcass weighed without necks and giblets. Turkeys must be packed with not more than four turkeys weighing up to 14 pounds (6.35 kg) per container or not more than two turkeys weighing over 14 pounds (6.35 kg) per container. The difference between individual carcass weights per container must be no more than 2 pounds (0.91 kg). The 2-pound (0.91 kg) increments must be: 12-14, 14-16, 16-18, 18-20, or 20-22 pounds. (Metric equivalency of increments: 5.44-6.35, 6.35-7.26, 7.26-8.16, 8.16-9.07, and 9.07-9.98 kg). A purchase unit will total 38,000 pounds (17,237 kg). A purchase or delivery unit may consist of shipping containers that cover two consecutive weight ranges only, except that delivery units with turkeys from the 12-14 pound (5.44-6.35 kg) weight range must contain turkeys weighing 12-14 pounds (5.44-6.35 kg) only.

Bulk Pack (100124) - Bulk packed for further processing, chilled young turkeys without necks and giblets, non-basted. Frozen may be specified in the Solicitation. The individual turkey weight range must be 18 pounds (8.16 kg) and higher per carcass weighed without neck and giblets. The commodity must be packed in commercial containers as required herein. A purchase unit will total 36,000 pounds (16,329 kg). Under Substitution Regulations, bulk pack turkeys may be delivered in compliance with the Standard Yield Program.

Roasts (100125) - Frozen ready-to-cook young turkey roasts must weigh not less than 8 pounds (3.63 kg) and not more than 12 pounds (5.44 kg). Roasts must be packaged in elasticized netting and moisture proof casings or plastic film bags and packed four roasts per fiberboard shipping container. A purchase unit will total 40,000 pounds (18,144 kg).

### **B. Food Defense Requirements**

Contractors and subcontractors participating in the commodity purchase program must have a documented food defense 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. The food defense plan shall be made available to Department of Agriculture's (USDA) Agricultural Marketing Service (AMS) Auditor immediately upon request. Verification of the Food Defense

Program at the processing, storage, and distribution facility will be conducted by the USDA/AMS Auditor.

C. Commodity Complaints

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

D. Humane Handling

All poultry shall be humanely handled in accordance with all applicable USDA/Food Safety and Inspection Service (FSIS) regulations, directives, and notices.

## II. COMMODITY SPECIFICATIONS

A. Basic Requirements

1. Date Processed. The consumer pack turkey and turkey roasts must not be processed and packaged more than 90 calendar days prior to the first date of the delivery period. The bulk pack turkeys must not be processed prior to the date of the contract.

2. Origin of Turkeys. Ready-to-cook turkeys and turkey roasts must be produced and processed from young turkeys which were 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 turkey 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, the contractor must have an acceptable identification and segregation plan for those turkey carcasses and parts to ensure they are not used in the commodities produced under this Specification. This plan must be made available to a representative of the Grading Division, LPS Program, AMS, 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).

3. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 CFR part 381) and be under the supervision of a representative of USDA/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 ready-to-cook turkey carcasses and parts; consumer pack and bulk pack; preparation, formulation, and fabrication of turkey roasts; packaging and packing; freezing; labeling and marking; sampling; net weight; and checkloading.

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

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

6. Organoleptic Requirements. The chilled (or frozen for roasts) turkey carcasses and parts will be examined on a continuous basis for the following organoleptic requirements: Chilled young turkey carcasses and parts must be free of rancidity; free of fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, chlorine-like, or other foreign or off-odors; free of foreign materials (e.g., glass, paper, rubber, plastic, metal, wood); must show no evidence of mishandling or deterioration; and must have a bright color with no evidence of dehydration or freezing and thawing. Any turkey carcasses and parts that do not comply with the organoleptic requirements will be rejected for use under this Specification.

7. Definition of a Lot. A lot is the amount of packaged commodity produced during a processing shift.

## B. Commodities

### 1. Commodities - Summary Table.

	<b>a. Consumer Pack</b>	<b>b. Bulk Pack</b>	<b>c. Roasts</b>
<b>Type:</b>	Frozen	Chilled or Frozen	Frozen
<b>Class:</b>	Young	Young	Prepared from breast meat, thigh meat, and skin of young ready-to-cook turkeys
<b>Style:</b>	Ready-to-Cook, Whole, Basting optional (approximately 3% basting ingredients added), provided in accordance with 9 CFR part 381.169	Ready-to-cook, Whole (non-basted)	Ready-to-Cook
<b>Neck and Giblets:</b>	Without neck and giblets	Without neck and giblets	N/A
<b>Weight Range:</b>	Weigh not less than 12 lbs. (5.44 kg) and not more than 22 lbs. (9.98 kg) per whole, ready-to-cook carcass weighed without neck and giblets	Weigh 18 lbs. (8.16 kg) and up, weighed without neck and giblets	Weigh not less than 8 lbs. (3.63 kg) and not more than 12 lbs. (5.44 kg)
<b>U.S. Grade:</b>	U.S. Grade A (Grade B as permitted)	U.S. Grade B or better	U.S. Grade A

### 2. Types.

a. Frozen consumer pack and bulk pack. Turkeys must be chilled (internal product temperature lowered to 40 °F (4.4 °C) or lower) immediately after processing. The chilled turkeys must be processed, packaged and packed, and placed in a freezer within 7 calendar days after the date of slaughter. Within this 7-day timeframe, the commodity must be placed in a freezer within 48 hours of packaging and packing. If the chilled turkey carcasses are not placed in a freezer immediately after packaging, the turkey carcasses must be held at a temperature not higher than 36 °F (2.2 °C) and not lower than 26 °F (-3.3 °C). The packaged turkey carcasses must be frozen (internal product temperature lowered to 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer). When packaged turkey carcasses are held at a temperature below 26° F (-3.3 °C), the turkeys will be considered to be in a freezer and subject to the 72-hour

freezing requirement that begins at the end of the shift the turkey carcasses enter the 26 °F (-3.3 °C) or lower temperature facility.

b. Chilled bulk pack.

(1) The turkey carcasses must be chilled (internal product temperature lowered to 40 °F (4.4 °C) or lower) immediately after processing.

(2) Chilled bulk pack turkey carcasses must be delivered to destination within 5 calendar days after the date of slaughter.

c. Frozen roasts. Packaged roasts must be placed in a freezer within 48 hours of fabrication and must be frozen by lowering the internal product temperature to 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If the packaged roasts are not placed in a freezer immediately after packaging, the roasts must be held at a temperature not higher than 36 °F (2.2 °C) and not lower than 26 °F (-3.3 °C). When packaged roasts are held at a temperature below 26 °F (-3.3 °C), the roasts will be considered to be in a freezer and subject to the 72-hour freezing requirement that begins at the end of the shift the roasts enter the 26 °F (-3.3 °C) or lower facility.

3. Class. Young turkeys must conform to the definition for the class in AMS 70.202. Young turkeys may be of either sex.

4. Style.

a. Individual carcasses of turkeys must conform to definitions and standards found in AMS 70.210.

b. Clips, tags, or bands must not be attached to the carcasses. (NOTE: This restriction does not apply to any devices allowed by FSIS for styling the product; for example, hock locks.)

5. Basting Options.

a. Basted. As an option, consumer pack turkeys may be injected with basting ingredients (approximately 3 percent basting ingredients (lot average not more than 3.3 percent and not less than 2.7 percent) added). Basted turkeys must be in the weight range specified for consumer pack turkeys with the net weight including the basting ingredients.

b. Non-basted. No solution or ingredients can be added.

6. U.S. Grade. Grading must be in accordance with 7 CFR part 70 and AMS 70.200 *et seq.* Grading must be under the supervision of a Grader using LPS Program's Sample Plan Level 1 (SPL-1) for consumer pack turkeys and Sample Plan Level 2 (SPL-2) for bulk turkeys and turkey roasts.



7. Individual Carcass Weight. Consumer pack and bulk packed turkey carcasses will be examined for compliance with the weight range requirements. Consumer pack turkeys will be examined after basting. A sample of 10 carcasses will be randomly drawn, weighed for individual weight, and must comply with the following:

a. Consumer pack. Each individual carcass in the sample must weigh not less than 12 pounds (5.44 kg) and not more than 22 pounds (9.98 kg), per ready-to-cook whole carcass, without necks and giblets.

b. Bulk pack. Each individual carcass in the sample must weigh a minimum of 18 pounds (8.16 kg) per ready-to-cook whole carcass, without necks and giblets.

c. Weight determination. Compliance with individual weight requirements will be made prior to packaging. The frequency of sampling will be according to Poultry Programs' SPL-2. If any sample does not comply with the weight requirements, the product the sample represents will be rejected.

#### C. Consumer Pack, Packaging and Packing

All packaging and packing materials must comply with the requirements in section III. See sections IV. through VIII. for other requirements.

1. Packaging. Each turkey must be individually packaged in a heat-shrinkable, plastic-film bag with good oxygen and moisture barrier properties; tensile and impact strength; tear resistance; and stability to protect product during frozen storage. The air must be removed from the bag, and the bag must be sealed and shrunk so that it snugly adheres to the turkey.

2. Packing. Packaged turkeys must be packed into shipping containers with: (a) not more than four turkeys weighing up to 14 pounds (6.35 kg) per container; or (b) not more than two turkeys weighing over 14 pounds (6.35 kg) per container (see V.A.2.).

#### D. Bulk Pack, Packaging and Packing

Product must be packaged and packed in commercial containers that comply with section III. and the requirements listed below. See sections IV. through VIII. for other requirements.

1. Chilled Bulk Pack. Bulk pack chilled turkey carcasses must be: (a) packed in wax-coated fiberboard containers with a commercial cooling medium, (b) packed in covered combo bins as loose chilled pack, or (c) packaged in plastic-film bags and packed in fiberboard shipping containers.

2. Frozen Bulk Pack. Bulk pack frozen turkeys must be either: (a) packaged in plastic-film bags or packed in containers lined with plastic-film bags, or (b) packed in fiberboard containers or commercial bulk containers.

3. Plastic-film Bags for Bulk Pack. Plastic-film bags used for bulk pack turkeys must have tear resistance; tensile and impact strength; and the stability to protect the product during handling and storage. More than one turkey may be packaged in a bag, and the bag does not need to be shrunk or vacuum packed. Plastic-film bags must be closed by commercial methods and materials.

#### E. Roasts

##### 1. Sources of Meat and Skin for Roasts.

a. Breast and thigh meat (meat) and skin must be from non-basted (no solution or ingredients added), young turkeys and turkey parts. The chilled turkey breasts and thighs, meat, and skin must be deboned and used in the turkey roast within 7 calendar days after the date of slaughter.

b. Chilled meat from boneless breasts and thigh, and skin from previously frozen turkeys may be used when: (1) the frozen turkeys have been packaged to protect them from freezer burn and dehydration during storage, (2) the turkeys have not been held more than 180 days in frozen storage and have been identified so the class of turkey can be determined, and (3) the resultant meat from boneless breasts and thighs, and skin are processed into the roasts (without refreezing) within 48 hours from the time of deboning.

c. Frozen boneless breasts and thighs, meat, and skin may be used when: (1) produced from freshly slaughtered turkeys, (2) packaged to protect against quality deterioration during storage and identified so the time in storage and the class, kind, and specific deboned turkey product can be determined, and (3) held not more than 180 days in frozen (0 °F or -17.8 °C) storage. After tempering, the meat must be used in the production of turkey roasts within 48 hours. The temperature of the meat must not exceed 40 °F (4.4 °C) during the process.

2. Turkey from Other Plants. Chilled and/or frozen turkey carcasses and parts may be transferred or obtained from other processing plants to produce roasts, provided they: (a) have been processed, handled, and identified in accordance with this Specification, and (b) comply with the organoleptic, non-basted, and other applicable requirements for turkey carcasses and parts to be used in roasts as evidenced by a USDA certification.

a. Type, class, and specific name of the product, part, boneless part or meat; date slaughtered, or date placed in frozen storage, as applicable; and the USDA-assigned plant number must be shown on each shipping container.

b. The chilled and/or frozen turkey carcasses and parts 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.

3. Requirements for Meat and Skin.

a. Meat.

(1) Meat must be derived from the breast and thigh. Meat must be in recognizable portions; that is, whole, half, or quartered breasts, tenderloins, complete thighs, or thighs with no more than one-half of the meat missing. Scapula meat may be used, provided it is attached to the breast meat portion.

(2) Fatty blubber and spongy fat must be removed from the breast meat in the crop cavity.

(3) Mechanically separated turkey (comminuted, ground, chopped, or desinewed) cannot be used.

b. Skin.

(1) Skin must be used only to cover the outer surface of the roasts.

(2) Skin for covering a roast may include the skin covering the crop area and the neck skin up to the whisker if the fatty blubber, spongy fat, and membranes have been removed from these areas.

c. Containers of breasts, boneless thighs, meat, or skin must not contain added water (for example, water from ice or slush ice and water).

4. Examination for Defects. Boneless breasts and thighs, meat, and skin will be sampled and examined for the defects shown in Table 1.

a. A sample of 30 pieces of each meat component and 30 pieces of skin will be sampled and examined for the defects shown in Table 1, prior to being used in the formula. The frequency of sampling and the number of defects allowed will be those outlined in LPS Program's SPL-1. Separate examinations will be made for: (1) bone and (2) other defects.

b. Regardless of the kind and number of defects (within Table 1) found, any sample with bone or bone-like material greater than 0.40 inch (1.02 cm) will be cause for the rejection of the product the sample represents.

c. If the number of bone defects exceeds the maximum for the "target" level or results in a rejection, the frequency of sampling for bone defects will be increased to 30 pieces of the applicable meat component or skin drawn twice each sampling interval until the cumulative number of bone defects reverts back to the "target" level.

d. If the samples of meat and skin have more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

**Table 1. Defects for Meat and Skin**

	<b>Defects</b>
<b>Bone:</b>	<b>Bone or bone-like material</b> greater than 0.40 inch (1.02 cm) (see II.E.4.b).  <b>Bone or bone-like material</b> less than or equal to 0.40 inch (1.02 cm).
<b>Other:</b>	<b>Cartilage, bruise, blood clot, fatty blubber and spongy fat</b> from the crop cavity on breast meat, or areas of discoloration as described below.
<b>Discoloration:</b>	<b>Any moderate discolorations.</b>  <b>Lightly shaded discolorations</b> exceeding an area equivalent to the area of a circle having a diameter of 0.50 inches (1.27 cm). Slight discolorations are permitted, regardless of the area, provided the discoloration does not detract from the overall appearance of the meat.
<b>Other:</b>	<b>Feathers, blemishes, fatty blubber, spongy fat, membranes, or areas of discoloration</b> as described below.
<b>Discoloration:</b>	<b>Any moderate discolorations.</b>  <b>Lightly shaded discolorations</b> exceeding an area equivalent to the area of a circle having the diameter of 1.50 inches (3.81 cm). Slight discolorations are permitted on the skin, regardless of area, provided the discoloration does not detract from the appearance of the roast.

5. Formula for Roasts.

- a. Formula. Proportions of ingredients required in preparing turkey roasts:

	<u>Percent of Total</u>
Breast meat (minimum)	47.00
Thigh meat (maximum)	34.00
Skin (maximum)	12.50
Water (maximum)	5.00
Salt (maximum)	1.00
Sodium phosphates (maximum)	<u>0.50</u>
	100.00

(1) Except as otherwise specified in II.E.5.a.(2), only the ingredients and the percentages of ingredients listed in the formulation above may be used. The sodium content of the turkey roast must be lower than or equal to 500 mg per 100 g.

(2) Additional breast meat may replace thigh meat. Additional breast meat or thigh meat may replace skin. The maximum percentage of thigh meat in the formulation may be exceeded if thigh meat replaces skin and minimum percentage of breast meat is maintained.

- b. Formulated batches of ingredients that do not comply with III.E.5.a. will be rejected for use in the roasts.

c. USDA may select additional samples of packaged roasts to examine for compliance with formulation requirements prior to shipment or at destination.

6. Mixing.

a. Sodium phosphates and salt must be mixed with the water and added as a solution to the meat and skin during tumbling, massaging, or injecting. Sodium phosphates must be thoroughly mixed with the water prior to the addition of the salt to the solution.

b. Salt, sodium phosphates, and water must be incorporated into the meat and skin by tumbling, massaging, or injecting. Tumbling, massaging, or injecting must be accomplished without deforming, shredding, mutilating, or breaking up the pieces of meat.

7. Meat and Skin Percentages. The following final percentages are required for meat and skin in each packaged roast, and include the amount of salt and sodium phosphates and the moisture pickup permitted during formulation, as applicable:

a. Tumbled, massaged, or injected.

(1) For roasts, when both the meat and skin have been tumbled, massaged, or injected, 50.27 percent breast meat (minimum), 36.36 percent thigh meat (maximum), and 13.37 percent skin (maximum).

(2) For roasts, when only the meat has been tumbled, massaged, or injected and the skin has not, 50.77 percent breast meat (minimum), 36.73 percent thigh meat (maximum), and 12.50 percent skin (maximum).

(3) The maximum tolerance of moisture, salt, and sodium phosphates applies to each individual component (breast meat, thigh meat, and skin) and to each packaged roast.

b. Substitution of thigh meat for skin. For roasts, where thigh meat has been substituted for skin, the maximum percentage of thigh meat permitted will be increased proportionately to the decrease in percentage of skin.

8. Hand and Mechanical Forming or Stuffing.

a. Roasts may be fabricated by hand or by mechanically forming or stuffing. The mechanical process must: (1) result in finished roasts with recognizable pieces of breast and thigh meat; (2) not intermingle the breast meat and thigh meat; (3) result in a lengthwise layering effect of the breast meat and thigh meat throughout the length of the finished roast; (4) not interfere with the uniform distribution and the appearance of the skin covering; and (5) be approved by Livestock, Poultry and Seed Program. (Approval will be granted on an individual plant basis after a review of the process and when the resulting fabrication is found acceptable by supervisory personnel of the Grading Division, LPS Program, USDA/AMS.)

b. For hand-formed or hand-stuffed roasts, pieces of breast and thigh may be cut from the recognizable portions of meat and removed during fabrication of the roast to facilitate meeting the percentages of breast meat or thigh meat (see II.E.7.). One piece of breast and one piece of thigh may be cut from the recognizable portions of meat and added to the roast during fabrication to meet the percentages of breast meat or thigh meat (see II.E.7.).

9. Skin Coverage.

a. At least 50 percent of the outer surface of the roasts must be covered with skin. Skin must be uniformly distributed over the outer surface of the roast.

(1) Skin covering may overlap without limit in all areas provided, (a) the fatty tissue has been removed from the sternal and pectoral feather tracts, (b) the percentage of the skin does not exceed the maximum amount listed in the formula, and (c) the areas are smooth in appearance.

(2) When fat is not removed from the sternal and pectoral feather tracts, no overlapping is permitted in these particular areas.

b. Skin cannot be used in the interior of the roasts.

10. Netting.

a. After assembling, the formed roast must be enclosed in an elasticized netting.

b. Roasts must be fabricated, netted, packaged, and packed so they will retain their unfrozen and netted shape after cooking, and each slice can be served with minimal separation.

11. Packaging and Packing. All packaging and packing materials must comply with the requirements in section III.

a. Packaging.

(1) Requirements. After netting, a mechanically formed roast must be packaged in a casing and a hand-stuffed roast must be packaged in a plastic-film bag, casing, or heat-shrinkable plastic-film bag. The casings and bags must have a wall thickness of not less than 2 mil (0.002 inch) or be a heat-shrinkable, plastic-film bag with characteristics equivalent to the 2 mil low-density polyethylene bag. Casings and bags must protect the commodity from dehydration, freezer burn, quality deterioration, or contamination during the conditions of use.

(2) Casings and bags must fit snugly around the roasts and be sealed by metal clip, plastic clip, or other device in a manner that will protect the product from dehydration, freezer burn, and quality deterioration. Metal wire ties, paper-coated wire ties, or staples must not be used for sealing plastic-film casings or bags. Metal clips may be used to seal/close casings or bags.

b. Packing. Four packaged roasts must be packed in each shipping container.

12. Weight, Length, and Diameter Requirements. Unfrozen packaged roasts must comply with the following size requirements:

a. Weight. Each roast must weigh not less than 8 pounds (3.63 kg), and not more than 12 pounds (5.44 kg);

b. Length. Each roast must measure between 9 and 17 inches (22.9 to 43.2 cm) in length; and

c. Diameter. Each roast must measure between 4 and 7 inches (10.2 to 17.8 cm) in diameter.

13. Examination for Fabrication Requirements and Defects.

a. Examination for fabrication. Three packaged roasts will be sampled and examined for compliance with the fabrication defects (requirements for meat and skin percentages, II.E.7.) as shown in Table 2. The frequency of sampling and number of defects allowed in a sample will be those outlined in LPS Program's SPL-2.

(1) Sample roasts with more fabrication defects than the maximum tolerance for the sample plan will result in the rejection of the product the samples represent.

(2) USDA may select additional samples of packaged roasts to examine for compliance with fabrication requirements prior to shipment or at destination.

b. Examination for defects. Packaged roasts will be sampled and examined for compliance with size requirements (weight, length, and diameter) and grade factors, such as skin coverage and overlap, and exterior defects.

(1) Three roasts will be examined for the defects shown in Table 2. The number of defects allowed will be as outlined in the LPS Program's SPL-2.

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

**Table 2. Defects for Finished Roasts**

	<b>Defect</b>
<b>Fabrication:</b>	<p><b>A fabrication defect for a finished roast is when:</b></p> <p>Both meat and skin are tumbled or massaged, and the percentage of breast meat is less than 50.27, the percentage of thigh meat is more than 36.36, or the percentage of skin is more than 13.37;</p> <p>Only the meat is tumbled or massaged, and the percentage of breast meat is less than 50.77, the percentage of thigh meat is more than 36.73, or the percentage of skin is more than 12.50; or</p> <p>The substitution of thigh meat for skin does not comply with II.E.7.</p>
<b>Size:</b>	<p><b>A size defect for a finished roast is when the roast:</b></p> <p>Weighs less than 8 pounds (3.63 kg), or more than 12 pounds (5.44 kg);</p> <p>Measures less than 9 inches (22.9 cm), or more than 17 inches (43.2 cm) in length; or</p> <p>Measures less than 4 inches (10.2 cm), or more than 7 inches (17.8 cm) in diameter.</p>
<b>Skin Coverage:</b>	<p><b>Less than 50 percent</b> of the outer surface of the roast is covered with skin, or when the skin or skin coverage does not comply with II.E.9.</p>
<b>Exterior:</b>	<p><b>Three or more feathers</b> greater than 0.75 inches (1.91 cm) in length.</p> <p><b>Any moderate discolorations.</b></p> <p><b>Lightly shaded discoloration</b> on the skin or meat exceeding an area equivalent to the area of a circle having a diameter of 1.50 inches (3.81 cm).</p>

14. Metal Detection. Each fabricated roast must be examined by a metal detection device capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips, metal fragments from cutting equipment, and pieces of wire. Netted roasts must be examined prior to or after placing in the casing or plastic-film bag in accordance with the procedures in AMS 910, Poultry Grader’s Handbook. As an alternate method, the meat used in the roast may be examined by an in-line metal detection device installed in the mechanical stuffing or forming system. Product found to be contaminated with metal will be handled in accordance with FSIS procedures. Other procedures for examination of roasts or meat and skin must be approved by the Deputy Administrator of LPS Program, in writing.



15. Ready-to-Cook Roasts for Further Processing. Roasts may be delivered within the plant (see section VII.D.) when there is an approved contract for further processing between the processing plant and the final recipient of the product. Roasts delivered in this manner must be netted and delivered on a lot or sub-lot basis in the chilled state (at an internal product temperature not lower than 26 °F (-3.3 °C) and not higher than 40 °F (4.4 °C)), without being packaged in casings or plastic-film bags, for further processing under contract between the plant and the final recipient. Delivery (point of delivery and acceptance) within the plant must be under procedures approved by LPS Program.

### **III. PACKAGING AND PACKING MATERIALS**

All packaging and packing materials must be clean and in new condition, must be of commercial quality, must not impart objectionable odors or flavors to the commodity, must be safe (not adulterate or injurious to health) for use in contact with food products, and must be tamper-evident. Tamper-evident is defined as packaging and packing with one or more indicators or barriers to entry, which, if breached or missing, can reasonably be expected to provide visible evidence that tampering has occurred.

#### **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, and staples must not be used for final closure of consumer pack turkeys and turkey roasts containers. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. Staples may be used to manufacture and to assemble 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. Containers for Bulk Pack**

Commercial fiberboard shipping containers used for bulk pack turkeys must be closed by commercial methods and materials.

### **IV. LABELING**

Commercial labeling (IV.A., and IV.G.-H.) or USDA labeling (IV.B.-H.) must be used. When commercial or USDA labeling is selected, both the packages and shipping containers within a purchase unit must be labeled in that format. Unless otherwise specified, the contractor must use the same label format (commercial or USDA) within a purchase unit.

#### A. Commercial Labeling Requirements for Consumer Pack and Roasts

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. Commercial Labels. Commercial labels must be the processor's own commercial label (brand name). Distributors' labels are not 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).

3. USDA Grade for Consumer Pack. In addition to the FSIS commercial labeling requirements, the USDA grade mark must be shown on each shipping container of consumer pack graded commodity. For shipping containers containing both U.S. Grades A and B consumer pack turkeys, no grade will be placed on the shipping container. If individual packages are commercially labeled, the USDA grademark must be printed on each package.

4. Nutrition Facts, Ingredients and Allergen statements on shipping containers. Nutrition Facts must be provided. The ingredient statement, even for single ingredient foods, must be included as a statement separate from the name of the product, e.g. Ingredients: \_\_\_\_\_. The allergen statement must be provided in the format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains \_\_\_\_\_.

#### B. USDA Labeling Requirements for Consumer Pack and Roasts

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

##### 1. USDA Labeled Packaged Consumer Pack and Roasts.

a. Consumer Pack. When both U.S. Grades A and B turkeys are included in a delivery unit, the USDA grade must be shown on each package of turkey.

b. Roasts.

(1) Plant number, production date, and net weight. The following information must be legibly preprinted, stamped, or stenciled on each casing or bag of roast; or preprinted, stamped, or stenciled on a waterproof tag in water-fast, non-smearing ink and securely attached to the sealing device of each casing or bag of roast:

- The USDA-assigned plant number.
- Date of production (month, day, and year).
- The net weight must be shown, except for in-plant delivery where the roasts are delivered without packaging in casings or bags.

(2) Additional labeling requirements. There must be no other labeling of the packaging materials.

2. USDA Labeled Shipping Containers for Consumer Pack and Roasts.

a. Labeling and Marking Information.

(1) Requirements. Labeling and marking information must be preprinted, stamped, or stenciled on each shipping container; or printed on a self-adhesive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 1 - 4.

(2) Qualifying statement (as applicable). For consumer pack basted commodity, the asterisks (\*) must appear on each shipping container (as shown in Exhibit 3) beside the commodity name and qualifying statement.

(3) USDA grade for Consumer Pack. The USDA grademark must be shown on the “one end” designated panel of each shipping container of commodity. For shipping containers containing both U.S. Grades A and B consumer pack turkeys, no grade will be placed on the shipping container.

(4) Nutrition Facts, Ingredients and Allergen statements on shipping containers. Nutrition Facts must be provided. The ingredient statement, even for single ingredient foods, must be included as a statement separate from the name of the product, e.g. Ingredients: \_\_\_\_\_. The allergen statement must be provided in the format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains \_\_\_\_\_.

(5) Recycle Symbol and Statement. The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 5. The statement “PLEASE RECYCLE” is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.

(6) Inventory Control Information. The processor may include any additional information (including bar codes) for processor inventory control purposes. This information may be applied somewhere on the shipping container but must not cover or conflict with the labeling requirements of this Specification.

b. Universal Product Code (UPC).

(1) 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 GS1 US., 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 processor's identification number for the commodity purchase programs and will use a unique item code number for consumer pack and roasts purchased under this Specification. The contractors need not join GS1.

- Consumer pack: The 14-digit UPC code for shipping containers of consumer pack is: 1 07 15001 00123 5

- Roasts: The 14-digit UPC code for shipping containers of roasts is:  
1 07 15001 00125 9

(3) The UPC code must be placed in the lower right-hand corner of the "one end" designated panel of each shipping container.

c. Labeling of Shipping Containers for Bulk Pack

(1) Requirements. USDA-assigned plant number, type and name of the product, date of production, and net weight of the product must be shown on each container or bin. In addition, each shipping container must be identified with the USDA Contract Compliance stamp with certificate number.

(2) In-Plant Deliveries. When in-plant delivery is made (see VII.D.), the contractor must label and mark the end product(s) according to the requirements of the State distributing agency.

d. Use of Previously Printed USDA Labeling Materials.

Carryover inventories of existing supplies of printed packing materials (USDA Labeling) from the Commodity Specification for Turkey and Turkey Products dated May 2012 may be used. If

the ingredients and allergen statement changes from that printed on existing supplies, the contractor/processor must request approval for use of carryover inventories from FSIS.

Shipping containers or labels with incorrect: (1) contract number, (2) plant number, (3) date packed, (4) USDA Grade, (5) name of product, (6) ingredients statement, (7) net weight, (8) allergen statement, or (9) nutrition facts information or label must be corrected before they can be used. The incorrect information must be blocked out and the correct information legibly printed, stenciled, or stamped in permanent ink. Additionally, the name, address, and phone number of the processor must appear on each shipping container.

e. Additional Labeling Issues.

The following are not acceptable for use under this Specification:

- Commercial labels that do not have a processor traceability system and code.
- Commercial labeling traceability coding and systems that have not been reviewed by a representative of LPS Program, Grading Division.
- Distributor commercial labels.
- Two or more different commercial labels in the same purchase unit.
- Commercially labeled packages and shipping containers of turkey roasts and USDA labeled packages and shipping containers of turkey roasts in the same purchase unit.

C. Free Along Side (FAS) Vessel Deliveries

FAS vessel deliveries that are not source loaded in a seavan are required to show the final overseas destination's address as provided in the Sales Order/Item Number. The address must be clearly printed on at least two sides of each pallet.

**V. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY**

A. Material and Net Weight Compliance

1. Verification of Materials and Defects.

a. 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:

“(I)(We) certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under this Commodity Specification for Turkey and Turkey Products dated March 2013, comply or will comply with the terms of this Commodity Specification.

Name \_\_\_\_\_  
Title \_\_\_\_\_”

One certification is adequate for all production under this Specification.

b. Packaging defects. Packages in a delivery unit will be examined for defects that affect protection, expose product, or permit dehydration or freezer burn or quality deterioration during storage, such as tears, holes, or improperly sealed or closed packaging.

c. Packing defects. Shipping containers in a delivery unit will be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers.

d. Tolerance for defects. If samples of packaged commodity or 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.

2. Net Weight. Net weight of each delivery unit will be determined by the test-weighing procedures of Poultry Programs.

a. Test weighing procedures.

(1) The tare weight of all packing materials will be determined by weighing a representative sample of all packaging components such as plastic-film bags, clips, and fiberboard containers.

(2) A representative sample will be selected in accordance with the following sample plan:

Number of Shipping Containers in Lot	Number of Shipping Containers in a Sample
1 - 4	All
5 - 50	4
51 - 100	5
101 - 200	6
201 - 400	7
401 - 600	8

For each additional 100 cases, or fraction thereof, in excess of 600 cases, one additional case shall be included in the sample.

(3) For large bulk containers (combo bins, tanks, etc.), the representative sample size shall be reduced by one-half the amount listed (V.A.2.a.(2)).

b. Consumer pack and roasts. A purchase or delivery unit of consumer pack and roasts must total 38,000 and 40,000 pounds (17,237 and 18,144 kg) net, respectively. A weight variation of minus 1 percent is permitted on each delivery unit. USDA will pay the contractor for the amount of commodity delivered within the required weight range.

c. Consumer pack. A maximum of 11,400 pounds (5,171 kg) net weight U.S. Grade B young turkeys may be included in a delivery unit at \$0.03 per pound less than the contracted price for U.S. Grade A. The discount must be stated on the grading certificate.

(1) Each delivery unit of consumer pack must contain all basted or all non-basted birds. Non-basted product must not have solutions or ingredients added.

(2) The net weight per carcass within individual shipping containers must not vary more than an increment of 2 pounds (0.91 kg). The 2-pound (0.91 kg) increments must be: 12-14, 14-16, 16-18, 18-20, or 20-22 pounds. (Metric equivalency of increments: 5.44-6.35, 6.35-7.26, 7.26-8.16, 8.16-9.07, and 9.07-9.98 kg.)

(3) With the exception of turkeys in the 12-14 pound weight range, a delivery unit may consist of shipping containers which cover two consecutive weight ranges only. For example, if a delivery unit consists of turkeys from the 14-16 and 16-18 pound (6.35-7.26 and 7.26-8.16 kg) weight ranges, it may not contain turkeys smaller than 14 pounds (6.35 kg) or larger than 18 pounds (8.16 kg).

d. Bulk pack. A purchase or delivery unit of bulk pack turkeys must total 36,000 pounds (16,330 kg) net, or multiples thereof. Less than 36,000 pounds (16,330 kg) will be rejected. Containers used to ship bulk pack will be uniform in both type and size in each delivery unit. Bulk pack must be delivered chilled. Subject to an agreement in writing with the processor receiving the commodity, or as specified in the applicable Solicitation/Invitation, it may be delivered frozen.

e. Net weight determination. Net weight for consumer pack, roasts, and frozen bulk pack will be determined at origin, and for chilled bulk pack, at the destination specified in the contract. The net weight of each delivery unit will be determined by a Grader at the contractor's expense.

f. Alternate net weight verification. As an alternative to test weighing at time of checkloading, the contractor may request on-line verification of net weights for consumer pack turkeys and turkey roasts. Upon receiving the request, a Federal-State supervisor, Grading Division, LPS Program (or their designee), will determine that the facilities and procedures are in accordance with applicable LPS Program's instructions for this Specification.

## B. Prerequisites for Loading and Shipping Frozen Commodities

1. Visual Inspection. Frozen consumer pack, bulk pack, and roasts must be a uniform light and bright color. Moisture (ice) present in a packaged roast or consumer packaged turkey must not exceed occasional small areas showing a thin layer of clear or pinkish-colored ice. Frozen commodity showing evidence of purge beyond the tolerance; or defrosting, refreezing, or freezer deterioration will be rejected for use under this Specification.

### 2. Internal Product Temperature.

a. Requirements. Internal product temperature of frozen consumer pack, bulk pack, and roasts must be 2 °F (-16.7 °C) or lower at time of loading. Delivery units with internal product temperatures exceeding 2 °F (-16.7 °C) and up to 5 °F (-15 °C) will be tentatively rejected. Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2 °F (-16.7 °C) or lower and reoffered one time only. Delivery units exceeding 5 °F (-15 °C) or delivery units that have been tentatively rejected and exceed 2 °F (-16.7 °C) when reoffered, will be rejected for use under this Specification.

b. Optional temperature verification. As an option to verifying internal product temperature of frozen commodities at time of loading, the contractor may request an alternate method utilizing product temperature sensing devices. If this option is selected, a Federal-State supervisor will determine that the facilities, equipment, procedures, and the contractors' current level of freezing compliance are in accordance with the established guidelines outlined in the applicable LPS Program's instructions for this Specification.

## C. 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 the 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 must be performed by a Grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest Grading Division field office or the Chief of the Grading Division, LPS Program, AMS, USDA, Room 3932-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 certificates issued by the Grader. The contractor must not ship the commodity unless informed by the Grader that the designated commodity to be shipped meets contract specifications.



## **VI. UNITIZATION**

Each delivery unit of consumer pack and roasts must be unitized (palletized and stretch-wrapped) and must comply with the following:

### **A. Pallets**

Pallets must be good quality, 48 inches x 40 inches, nonreversible, flush stringer, and partial four-way entry. Each pallet of shipping containers must be stretch-wrapped with plastic film in a manner that will secure each container and layer of containers on the pallet. Palletized product must be loaded in a way that will prevent shifting and damage to the 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 shipping container display panels to facilitate certification examinations.

### **B. Pallet Exchange**

Contractors may arrange for pallet exchange with consignees; however, USDA is not responsible for such arrangements.

## **VII. SHIPMENT AND DELIVERY**

Shipment and delivery must be made in accordance with the AMS Master Solicitation, the applicable Solicitation, and this Specification.

### **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 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.

### 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. Thereafter, all delivery units--truck lot and less-than-truck lot (LTL) quantities—must be secured at all times prior to unloading with tamper resistant, serially numbered, high security seals. Suppliers of commodities, products and/or services shall be responsible for placing a seal(s) on all doors of each transportation conveyance upon completion of loading or servicing. Seals shall be serially numbered, barrier-type and meet the American Society for Testing and materials (ASTM) standards. Seals shall be 1/8<sup>th</sup> inch in diameter, high security bolt, or equivalent. The contractor must maintain a record of each seal number used for truck lot and LTL delivery units. Additionally, the contractor must ensure that the applicable seal identification number is on each bill of lading, shipment manifest, certificate, or other delivery documents for each delivery destination.

When LTL delivery units are transported on the same trailer and destined for multiple recipients, the trailer must be sealed after each delivery. The seal number must be recorded on the appropriate delivery documents and correspond with the applied seal at the time of arrival at the next destination. It will be the responsibility of the contractor to provide a sufficient number of seals to the carrier service and to ensure that the trailer is sealed after each delivery destination. Failure to seal the trailer after each stop may result in rejection of the shipment by the recipient agency at the next scheduled stop and rejection of any subsequent deliveries on the trailer.

1. Railcar. Each railcar must be sealed. The contractors are responsible for arranging for 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 require sealing after each drop in accordance with Section VII.C of this Specification.

### D. Delivery Notification

The contractor must comply with the Master Solicitation regarding Advance Shipping Notices (ASNs) and unloading appointments.

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

a. Definition of a subplot. A lot (see definition, Section II.A.7.) may be separated into sublots. If this option is used, the commodity must be sublotted on the basis of consecutively produced shipping containers or pallets. The sublots must be consecutively identified at the time of packing.

b. Bulk pack. In-plant delivery of up to three sublots per purchase unit of bulk pack is permitted when the contractor slaughters and further processes (in accordance with a contract between contractor and final recipient of the final product(s)) the turkey in the same processing plant. Test weighing of sublots will be done in accordance with procedures established by LPS Program.

c. Roasts. Roasts may be delivered in the same plant where the roasts were produced in unfrozen form without casings or bags or without being packaged in containers (see Section II.E.15.). Such deliveries will be discounted, against the contractor's account, by 3.5 cents per pound.

2. Delivery In Storage. Delivery may be made in store provided the destination in the Sales Order/Item number 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 the Sales Order/Item number to each destination. Contractors must provide to the Grader, at time of shipment, the number of boxes and pounds for each destination.

1. Consumer Pack and Roasts. At the option of the contractor, a purchase unit for multiple destinations (split deliveries) may be delivered on separate trucks provided each truck ships the total quantity stated on the Sales Order/Item number. Any additional costs will accrue to the contractor's account.

2. Bulk Pack. The contractor may deliver product in two or more trucks upon the approval of the recipient and upon the Grader being available to perform the necessary checkloading and final acceptance duties.

### **VIII. DESTINATION EXAMINATION**

#### A. Commodity Requirements

Before acceptance by consignee, frozen commodity may be examined by a Grader on a spot-check basis for temperature, condition, identity, and, when applicable, count. The commodity may be examined for conformance to contract provisions at any time required by the Contracting Officer.

B. Temperature

Chilled bulk pack must arrive at destination at an internal product temperature not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C). Frozen commodity must arrive at destination at an average internal product temperature not to exceed 10 °F (-12.2 °C), with no individual temperature exceeding 15 °F (-9.4 °C). Commodity not meeting these requirements will be rejected for use under this Specification.

C. Cost for Frozen Commodity Destination Examination

The cost of a destination examination for frozen commodity, before or after delivery by a Grader on acceptable product, will be for the account of USDA. Costs for destination examinations of rejected delivery units will be for the account of the contractor. The origin Grader will make arrangements for destination examinations prior to delivery.

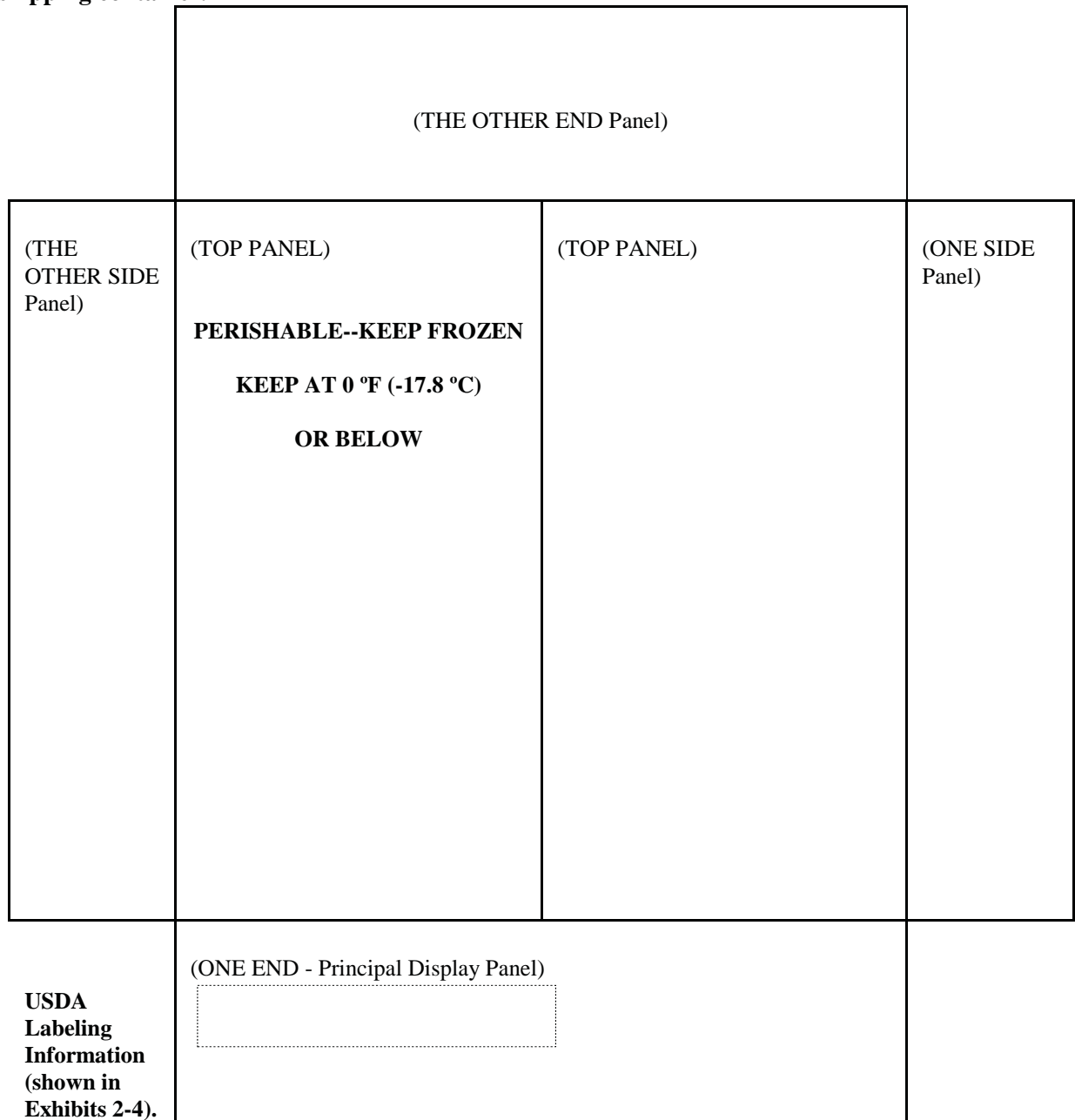


Director, Food Safety and Commodity Specification Division  
Livestock, Poultry and Seed Program

Attachments

**EXHIBIT 1**  
**USDA Labeled Shipping Containers**

**Marking Information:** Shipping containers may be marked substantially as shown below. Detailed USDA labeling information is provided in Exhibits 2 - 4. Markings must be legibly preprinted, stamped, stenciled, or printed on a separate self-adhesive label and applied to containers. The USDA symbol, copy back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the top panel or the principal display panel. The processor's name, address, and phone number may be printed on the top panel or the principal display panel. The processor's name and address may indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints. FSIS Safe Handling Instructions must be preprinted or applied as a separate self-adhesive label on each package or shipping container.



**EXHIBIT 2**  
**USDA Label Information for Turkey Roasts**

**Marking Information:** USDA labeling information must be printed on the principal display panel of each shipping container as provided in Exhibit 1. Markings must be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. The UPC 14-digit I 2/5 code, and symbol, must be shown in the lower right-hand corner of the principal display panel. The USDA symbol, copy back of Specification, must be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the top panel or the principal display panel. The processor's name, address, and phone number may be printed on the top panel or the principal display panel. The processor's name and address may indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints. FSIS Safe Handling Instructions must be preprinted or applied as a separate self-adhesive label on each package or shipping container.



**FROZEN READY-TO-COOK TURKEY ROASTS**

Ingredients:  
(Food Allergen Statement  
Must be placed here)  
Processor's  
Name, Address, and Phone

Required  
Nutrition Facts Label  
Must Be Placed Here

Safe Handling Instructions  
Must Be Placed Here.

**KEEP FROZEN**

\_\_ Bags Net  
Weight \_\_ LBS. ( \_\_ KG)

DATE PACKED (Month, Day, and Year)

UPC Symbol and Code

**EXHIBIT 3**  
**USDA Label Information for Basted Young Turkeys**

**Marking Information:** USDA labeling information must be printed on the principal display panel of each shipping container as provided in Exhibit 1. Markings must be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. The UPC 14-digit I 2/5 code, and symbol, must be shown in the lower right-hand corner of the principal display panel. The USDA symbol, copy back of Specification, must be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the top panel or the principal display panel. The processor's name, address, and phone number may be printed on the top panel or the principal display panel. The processor's name and address may indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints. FSIS Safe Handling Instructions must be preprinted or applied as a separate self-adhesive label on each package or shipping container.



**FROZEN READY-TO-COOK  
YOUNG TURKEYS\***

\*Injected with approximately 3 percent of a solution of \_\_\_\_\_.

Ingredients:  
(Food Allergen Statement  
Must be placed here)

Processor's  
Name, Address, and Phone

Safe Handling Instructions  
Must Be Placed Here

Required  
Nutrition Facts Label  
Must Be Placed Here

**KEEP FROZEN**

Net Weight \_\_\_ LBS. (\_\_\_ KG)

DATE PACKED (Month, Day, and Year)

UPC Symbol and Code

**EXHIBIT 4**  
**USDA Label Information for Non-basted Young Turkeys**

**Marking Information:** USDA labeling information must be printed on the principal display panel of each shipping container as provided in Exhibit 1. Markings must be legibly preprinted, stamped, stenciled on containers, or preprinted on a separate self-adhesive label and applied to containers. The UPC 14-digit I 2/5 code, and symbol, must be shown in the lower right-hand corner of the principal display panel. The USDA symbol, copy back of Specification, must be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the top panel or the principal display panel. The processor's name, address, and phone number may be printed on the top panel or the principal display panel. The processor's name and address may indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints. FSIS Safe Handling Instructions must be preprinted or applied as a separate self-adhesive label on each package or shipping container.



**FROZEN READY-TO-COOK  
YOUNG TURKEYS**

Ingredients:  
(Food Allergen Statement  
Must be placed here)

Processor's  
Name, Address, and Phone

Safe Handling Instructions  
Must Be Placed Here.

Required  
Nutrition Facts Label  
Must Be Placed Here

**KEEP FROZEN**

Net Weight \_\_\_ LBS. ( \_\_\_ KG)

DATE PACKED (Month, Day, and Year)

UPC Symbol and Code



EXHIBIT 5  
“Please Recycle” Symbol and Statement



**PLEASE  
RECYCLE**

USDA SYMBOL

