



APPROVED

FEDERAL PURCHASE PROGRAM SPECIFICATION (FPPS) FOR BULK PACK BONELESS, SKINLESS TURKEY THIGH

Agricultural Marketing service (AMS)
Livestock and Poultry (LP) Program
Food Safety and Commodity Specification (FSCS)
Division
Room 2624-S, Phone: 202-692-0342

Supersedes: Bulk Boneless Skinless Turkey Thigh April 2013 –
changes from previous requirements in [blue](#)

Effective: September 2018

100 ITEM DESCRIPTION

110 Bulk [Pack](#) Boneless Skinless Turkey Thigh (100883) - Bulk packed for further processing, [chilled](#) boneless skinless turkey thighs from ready-to-cook young turkeys. Frozen may be specified in the Solicitation. The commodity [shall](#) be packed in commercial containers. A purchase unit [shall](#) total 36,000 pounds (16,329 kg).

200 APPLICABLE DOCUMENTS

210 The following documents are incorporated as part of this USDA, AMS, [FSCS](#) Division FPPS-Bulk Pack Boneless, Skinless Turkey Thigh – September 2018:

210.1 [AMS/LP/Quality Assessment Division \(QAD\) Policies and Procedures.](#)

210.2 [Poultry Products Inspection Regulations \(9 CFR § 381\).](#)

210.3 [Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products \(7 CFR § 70\) and the U.S. Classes, Standards, and Grades for Poultry \(AMS 70.200 *et seq.*, 9 CFR § 381.170 to 172\).](#)

210.4 [AMS Master Solicitation for Commodity Procurements and Solicitation.](#)

300 CHECKLIST OF REQUIREMENTS

310 [Domestic Products – Refer to the current AMS Master Solicitation for Commodity Procurements.](#)

320 [Food Defense – Refer to the current AMS Master Solicitation for Commodity](#)

Procurements.

400 HARVESTING

- 410 All harvesting activities shall comply with all applicable Food Safety and Inspection Service (FSIS) regulations and requirements, including 9 CFR § 381, and shall be done under FSIS inspection.
- 420 Humane Handling – All poultry shall be humanely handled in accordance with FSIS Directive 6100.3.

500 PROCESSING

- 510 All processing activities shall comply with all applicable FSIS regulations and requirements, including 9 CFR § 381, and shall be done under FSIS inspection.
- 520 Performance Standards – Product shall be produced under FSIS pathogen reduction standards, as specified in 9 CFR § 381.
- 530 The commodity shall not be processed prior to date of contract.
- 540 Inspection for contract and FPPS compliance shall 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.*). The AMS Grader shall be responsible for certification of compliance with the requirements of this FPPS for ready-to-cook turkey thigh meat; freezing; packaging and packing; labeling and marking; net weight; sampling; and checkloading.
- 541 AMS Certification – For information about AMS Certification, contact USDA/AMS, LP Program's QAD field office or the Director of QAD, LP Program, AMS, USDA, Room 3953-S, STOP 0258, 1400 Independence Avenue, SW, Washington, DC 20250-0258, or by telephone (202) 720-5705.
- 542 All steps in the manufacturing process shall be under the direct supervision of an AMS Grader and as outlined in QAD Policies and Procedures. Quality and compliance with product requirements shall be determined in accordance with QAD Policies and Procedures. The AMS Grader may select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination.
- 543 Lot Definition – A lot is the amount of packaged commodity produced during a processing shift.
- 543.1 Sub-Lot – Contractor shall clearly identify sub-lot size and maintain the identity and traceability of each sub-lot.

- 550 Turkey from Other Plants – Turkey carcasses, thighs, and boneless skinless thighs may be transferred or obtained from other processing plants provided they:
- 550.1 have been processed, handled, and identified in accordance with this FPPS, and
- 550.2 comply with the organoleptic, non-basted, and other applicable requirements of the FPPS as evidenced by USDA certification. USDA certification may occur either at the plant of origin or at the receiving plant.
- 551 Limited substitution of donated commodity is allowed in the state reprocessing program provided certified commercial product of the same quality is used. Substituted commodity shall meet the General Requirements section in QAD Instruction 630a Poultry Substitution Guidelines.
- 552 Type, class, and specific name of the product, part, boneless part or meat; date harvested as applicable; and the USDA-assigned plant number shall be shown on each shipping container.
- 553 The chilled turkey and parts shall be at an internal product temperature between 26 °F (-3.3 °C) and 40 °F (4.4 °C) during transit, from plant origin to destination.
- 553.1 Boneless skinless turkey thigh meat may be obtained by warm deboning and shall be chilled immediately between 26 °F (-3.3 °C) and 40 °F (4.4 °C).
- 553.2 Cooling Requirements – Boneless skinless thighs that are not used in the commodity on a continuous basis after deboning shall be cooled by cooling methods and media to ensure the internal product temperature is lowered between 26 °F (-3.3 °C) and 40 °F (4.4 °C).
- 553.2.1 Cooling Medium – Cooling methods and media (e.g., use of liquid carbon dioxide (CO₂), dry ice, or liquid nitrogen (N₂)) may be used to maintain the temperature of the meat.
- 553.2.2 Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of the boneless skinless thighs shall not be incorporated into the commodity. Liquid associated with normal product purge is acceptable.
- 554 Frozen Turkey – Frozen turkey, parts and skinless boneless thighs may be used if they have been:
- 554.1 packaged to protect the product from freezer burn, dehydration, and quality deterioration during storage,
- 554.2 labeled as to kind and class of poultry and identified so the time in storage can be determined, and
- 554.3 held in frozen (0 °F/-17.8 °C) storage for no more than 180 days.

- 555 Meat Time Requirements – The commodity shall be chilled to an internal product temperature of 40 °F (4.4 °C) or lower immediately after processing.
- 556 Chilled commodity shall be delivered to destination within 5 calendar days after the date of harvest.
- 557 Frozen commodity shall be processed, packaged and packed, and placed in a freezer within 7 calendar days after the date of harvest.
- 557.1 The chilled commodity shall be placed in a freezer immediately after packaging or packing and be frozen to an internal product temperature of 10 °F (-12.2 °C) or lower within 72 hours from the time of entering the freezer.
- 560 Organoleptic Requirements – Boneless skinless thighs shall be examined on a continuous basis for organoleptic requirements shown in Table 1. Any product that does not comply with the organoleptic requirements shall be rejected for use under this FPPS.
- 561 Meat Defects – A sample of 30 pieces of boneless skinless thighs shall be drawn and examined for the defects, shown in Table 1. The frequency of sampling and the number of defects allowed shall be those outlined in QAD's Sample Plan Level 1 (SPL-1). Separate examinations shall be made for bone and other defects.
- 561.1 A sample with bone or bone-like material less than 0.40 inch (1.02 cm) shall count as a defect. Regardless of the kind and number of defects found, any sample with bone or bone-like material greater than 0.40 inch (1.02 cm) shall be cause for the rejection of the product the sample represents.
- 561.2 If the number of bone defects exceed the maximum defects allowed, or results in a rejection, the frequency of sampling for bone defects shall be increased to 30 pieces of boneless skinless thighs drawn twice each sampling interval until the cumulative number of bone defects reverts to levels allowed.
- 561.3 If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents shall be rejected.
- 600 PACKAGING AND PACKING**
- 610 The contractor shall assure that all packaging, packing, labeling, closure, marking, and palletization comply with the National Motor Freight Regulations and FSIS regulations and the requirements listed below.
- 620 Packaging – All packaging and packing materials shall be clean and in new condition, shall not impart objectionable odors or flavors to the commodity, and shall be safe for use in contact with food products (cannot adulterate product or be injurious to health). All packaging material shall comply with FSIS regulations

(9 CFR § 381.144(c)).

- 621 Plastic-film Bags – The commodity shall be placed in a polyethylene-film bag with a wall thickness of not less than 2 mil (0.002 inch); and the bag shall protect the commodity from dehydration, freezer burn, or quality deterioration during the conditions of use. Closure methods shall be approved by a representative of QAD. Metal wire ties, paper-coated wire ties, or staples shall not be used for sealing plastic-film bags.
- 630 Packing
- 631 Chilled Commodity – Shall be delivered to the destination as specified in the shipping instructions in commercial containers with a commercial cooling medium; for example,
- 631.1 in wax-coated fiberboard containers,
- 631.2 in covered combo bins or tanks, or
- 631.3 in plastic-film bags and packed in fiberboard shipping containers. The bags need not be vacuum packed.
- 632 Frozen Commodity – Shall be delivered to the destination:
- 632.1 in plastic-film bags and packed in fiberboard shipping containers or commercial bulk containers; or
- 632.2 in wax-coated fiberboard containers.
- 632.3 The bags need not be vacuum packed.
- 640 Shipping Containers – Shipping containers shall:
- 640.1 be good commercial fiberboard containers that are acceptable by common or other carrier(s) for safe transport to point of destination,
- 640.2 be of such size to pack the commodity without slack filling or bulging,
- 640.3 withstand the stresses of handling, shipping, stacking, and storage, and
- 640.4 be closed by commercially accepted methods and materials. Steel or wire straps shall not be used for final closure.
- 641 Staples shall not be used for final closure of shipping 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 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.

700 LABELING

710 Shipping Containers – USDA-assigned plant number, type and name of commodity, date of production (in easily readable character size in day/month/year format), and net weight of commodity shall be shown on each container, tank, or bin.

711 In-Plant Deliveries – When in-plant delivery is made, the contractor shall label and mark the end product(s) according to requirements of the State distributing agency.

720 Free Along Side (FAS) Vessel Deliveries

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

800 FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY

810 Net Weight Compliance

820 Net Weight – Each delivery unit shall be determined by the test-weighing procedures of LP Program. Containers used to ship commodity shall be uniform in both type and size in each delivery unit. The commodity shall be delivered chilled subject to an agreement in writing with the processor receiving the commodity, or as specified in the applicable Solicitation, it may be delivered frozen.

821 Test Weighing Procedures

821.1 The tare weight of all packing materials shall be determined by weighing a representative sample of all packaging components such as plastic-film bags, clips, and fiberboard containers according to applicable LP Program's instructions (LP, QAD 600 Series Instructions).

821.2 A purchase unit or delivery unit of bulk pack boneless skinless turkey thighs shall total 36,000 pounds (16,329 kg) net, or multiples thereof. Any delivery unit weighing less than 36,000 pounds (16,329 kg) net shall be rejected.

821.3 Net Weight Determination – Frozen commodity shall be determined at origin and, for chilled commodity, at destination. Net weight at destination shall be determined by removing the product from the packaging and packing materials and weighing on a direct net weight basis. The net weight of each delivery unit shall be determined by an AMS Grader at the contractor's expense.

830 Loading and Shipping Frozen Commodity

- 831 Visual Inspection – The frozen boneless skinless turkey thigh meat commodity **shall** have uniform light and bright color. Frozen commodity showing any evidence of defrosting, refreezing, or freezer deterioration **shall** be rejected for use under this **FPPS**.
- 832 Internal Product Temperature
- 832.1 Internal product temperature of frozen commodity **shall** 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) **shall** 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 **shall** be rejected for use under this **FPPS**.
- 832.2 Optional Temperature Verification – The contractor may request an alternate method utilizing commodity temperature sensing devices. If this option is selected, a Federal-State supervisor, Grading Division, LP Program **shall** 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 LP Program's instructions for this **FPPS**.
- 840 Inspection and Checkloading
- 841 Requirements – Inspection for contract compliance **shall** be made by a representative of the USDA, in accordance with 7 CFR § 70, FSIS regulations, and this **FPPS**, at the site of processing, both during and after processing and packaging. A representative of USDA may select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination. Inspection records **shall** be complete and made available to USDA, as requested, to assure contract compliance.
- 842 Procedures – The inspection and checkloading **shall** be performed by an **AMS** Grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest **QAD** field office or the Director of **QAD**, LP Program, AMS, USDA, Room 3953-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 **shall** be evidenced by certificates issued by the **AMS** Grader. **The contractor shall** not ship the commodity unless informed by the **AMS** Grader that the designated commodity to be shipped meets **the requirements of the AMS Master Solicitation for Commodity Procurements, Solicitation, and this FPPS**.
- 900 PALLETIZED UNIT LOADS**
- 910 All products shall be stacked on new or well-maintained pallets and palletized with shrink wrap plastic, unless otherwise specified in the Solicitation. Pallet loads shall

be stacked in a manner that minimizes the overhang of the shipping containers over the edges of the pallets and exposes each shipping container's principal display panel to facilitate certification examinations.

920 Size and Style of Container – Only one size and style of shipping container shall be used in any one delivery unit.

1000 SHIPMENT AND DELIVERY

1010 Shipment and Delivery – Refer to the current AMS Master Solicitation for Commodity Procurements.

1011 In addition, the contractor shall adhere to the following provisions:

1011.1 Each shipping container shall be identified with a USDA Contract Compliance stamp with the applicable certificate number. An AMS Grader, or other authorized personnel under the supervision of the AMS Grader, shall 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.

1011.2 As an alternative to stamping, the contractor may preprint the stamp on the shipping container or label. Prior approval by QAD is required before using this alternative method.

1012 A copy of the original USDA Poultry Grading Certificate issued at time of checkloading shall accompany each shipment.

1012.1 Railcar or Piggyback – The certificate shall be placed in the railcar or trailer for easy access to the AMS Grader, warehouseman, or consignee, as applicable.

1012.2 Trucks – The driver shall, upon delivery, give the certificate to the AMS Grader, warehouseman, or consignee, as applicable.

1020 Loading and Sealing of Vehicles

1021 Refer to the current AMS Master Solicitation for Commodity Procurements.

1030 Delivery Notification

1031 Refer to the current AMS Master Solicitation for Commodity Procurements.

1040 Split Deliveries

1041 Refer to the current AMS Master Solicitation for Commodity Procurements.

1100 DESTINATION EXAMINATION

1110 The cost of a destination examination, before or after delivery, by an AMS Grader on accepted product shall be for the account of USDA. Costs for destination examinations of rejected delivery units shall be for the account of the contractor. The origin AMS Grader shall make arrangements for destination examination prior to delivery.

1111 Commodity Requirements – Before acceptance by consignee, the commodity may be examined by an AMS 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.

1112 Temperature

1112.1 Chilled commodity shall arrive at destination at an internal product temperature between 26 °F (-3.3 °C) and 40 °F (4.4 °C).

1112.2 Frozen commodity shall 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).

1112.3 Commodity not meeting these requirements shall be rejected for use under this FPPS.

1200 PRODUCT ASSURANCE AND COMPLAINT RESOLUTION

1210 Product Assurance – The Contractor shall guarantee that the product complies with all FPPS requirements and provisions set forth in the AMS Master Solicitation of Commodity Procurements and Solicitation.

1211 Waiver Requests – Contractor shall submit all waiver requests directly to the Commodity Procurements Staff (CPS) Contracting Officer for review and determination. A full list of CPS contacts can be found at:

<https://www.ams.usda.gov/sites/default/files/media/AMS%20Commodity%20Procurement%20Staff%20Contact%20List.pdf>

1220 Complaint Resolution – Customer complaint resolution procedures shall be the responsibility of the Contractor. These procedures shall include: a point of contact, investigation steps, intent to cooperate with AMS, and product replacement or monetary compensation. The procedures shall be used to resolve product complaints from recipient agencies or AMS.

TABLE 1
Organoleptic Requirements and Defects for Meat

Organoleptic Requirements:	Meat shall: (a) not be rancid; have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign or off-odors; not contain foreign materials (e.g., glass, paper, rubber, metal, plastic, wood); or show evidence of mishandling or deterioration; and (b) have a bright color.
Boneless Meat	Defects
Bone:	Bone or bone-like material greater than 0.40 inch (1.02 cm). Bone or bone-like material less than or equal to 0.40 inch (1.02 cm).
Discoloration:	Any moderate discolorations. Lightly shaded discolorations exceeding an area equivalent to the area of a circle with a diameter of 0.50 inch (1.27 cm). Slight discolorations are permitted, provided the discoloration does not detract from the overall appearance of the meat.
Other:	Cartilage (gristle), hard tendons or tendonous material or blood clots.
Boneless Thighs:	Thigh with more than one-half of the meat missing.