



# APPROVED

**FEDERAL PURCHASE PROGRAM  
SPECIFICATION (FPPS) FOR  
SMOKED TURKEY HAM  
PRODUCTS**

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

Supersedes: FPPS for March 2015 – changes from previous requirements in blue

**Effective: April 2018**

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**100 ITEM DESCRIPTION**

- 110 Smoked Turkey Ham – Frozen, fully cooked smoked turkey hams, produced from non-basted, young ready-to-cook **chunked and formed** turkey thigh meat. Each smoked turkey ham **shall** be vacuum packaged in a shrinkable oxygen and moisture proof bag or casing, and be packed **as:**
- 110.1 100126 - Four 10-pound **smoked turkey** hams **per** fiberboard **shipping** container. The packaged commodity shall be 4 to 5 inches in diameter and round. A purchase unit **shall** total 40,000 pounds.
- 110.2 100886 - Twenty 2-pound **smoked turkey** hams **per** fiberboard **shipping** container. The packaged commodity shall be 4 to 5 inches in diameter and round. A purchase unit **shall** total 40,000 pounds.
- 110.3 110911 (Sliced) – Thinly sliced (not shaved) **smoked turkey ham, chunked and formed, smoked, and having no spongy (porous texture) appearance (after thawing of frozen turkey ham).** Product shall be shingle layered and packed eight (8) 5-pound packages per shipping container to a net weight of 40 pounds. A purchase unit shall total 40,000 pounds.
- 110.4 XXXXXX (Sliced) – Thinly sliced (not shaved) **smoked turkey ham, chunked and formed, smoked, and having no spongy (porous texture) appearance (after thawing of frozen turkey ham).** Product shall be shingle layered or stacked, and packed twenty (20) 2-pound packages per shipping container to a net weight of 40 pounds. A purchase unit shall total 40,000 pounds.

**200 APPLICABLE DOCUMENTS**

- 210 The following documents are incorporated as part of this USDA, AMS, FSCS Division FPPS – Smoked Turkey Ham Products – April 2018:

- 210.1 AMS/LPS/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 more than 90 calendar days prior to the first date of the delivery period for each sales order.
- 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 § 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 carcasses and parts; preparation, formulation, and fabrication of turkey hams; smoking, cooking and cooling turkey hams; slicing; packaging and packing; freezing; labeling and marking; sampling; net weight; and checkloading.
- 541 AMS Certification – USDA/AMS, LPS Program’s QAD field office or the Director of QAD, LPS Program, AMS, USDA, Room 3953-S, STOP 0258, 1400 Independence

Avenue, SW, Washington, DC 20250-0258, telephone (202) 720-3271.

- 542 All steps in the manufacturing process shall be under the direct supervision of 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 also 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 and parts may be transferred or obtained from other processing plants provided it:
- 550.1 has been processed, handled, and identified in accordance with this FPPS, and
- 550.2 complies with the non-basted, organoleptic, and other applicable requirements of this FPPS as evidenced by USDA certification. USDA certification may occur either at the plant of origin or at the receiving plant.
- 551 Type, class, and specific name of the product, part, boneless, skinless part or meat; date harvested or date placed in frozen storage, as applicable; and the USDA-assigned plant number shall be shown on each shipping container.
- 552 The chilled turkey and parts shall maintain an internal product temperature between 26 °F (-3.3 °C) and 40 °F (4.4 °C) during transit, from plant origin to destination.
- 560 Meat Time Requirements
- 560.1 Smoked Turkey Ham (100126 and 100886) – The chilled commodity shall be processed, packaged, packed, and placed in a freezer within 7 calendar days after the date of harvest.
- 560.2 Smoked Turkey Ham, Sliced (110911 and XXXXXX) – The chilled commodity shall be processed, packed in casing, sliced, packaged, packed and placed in a freezer within 14 calendar days after the date of harvest.
- 561 Frozen meat may be used when:
- 561.1 produced from freshly harvested turkeys;
- 561.2 packaged to protect against quality deterioration during frozen storage and identified so the time in storage and the class, kind, and specific deboned turkey product can be determined;

- 561.3 held not more than 180 days in frozen storage; and
- 561.4 product shows no evidence of thawing and refreezing or freezer deterioration.
- 562 Other than the final freezing process for finished, packaged commodity, the commodity shall not be derived from turkey meat that has been frozen more than one time.
- 563 Maximum Temperature – The temperature of the meat shall not exceed 55 °F (12.8 °C) at any time during preparation or processing into the commodity.
- 564 Skin – Shall not be used in the commodity. All skin shall be removed from each part or meat portion.
- 565 Boneless turkey thighs shall be in recognizable portions; that is, complete thighs, or thighs with no more than one-half of the meat missing.
- 565.1 Turkey thigh meat trimmings that are removed from the turkey thighs during the boning and trimming process may be used if they represent no more than 15 percent of the total weight of the turkey thigh meat as specified in the formulation section.
- 566 Cooling Requirements – The thigh meat which is not used in the commodity on a continuous basis, after deboning shall be cooled by methods or media to continuously lower and ensure that the internal product temperature is between 26 °F (-3.3 °C) and 40 °F (4.4 °C).
- 566.1 Cooling Medium – Cooling methods and media (e.g., liquid carbon dioxide (CO<sub>2</sub>), dry ice or liquid nitrogen (N<sub>2</sub>)) may be used to maintain the temperature of meat.
- 566.2 Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat or parts shall not be incorporated into the commodity. Liquid associated with normal product purge is acceptable.
- 570 Organoleptic Requirements – Boneless skinless thighs and thigh trim 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.
- 571 Meat Defects – A sample of 30 pieces of boneless skinless thighs and 2 pounds of thigh trim (as applicable) shall be drawn and examined for the defects, shown in Table 1, before it is used in the formula. The frequency of sampling and the number of defects allowed shall be those outlined in QAD's Sample Plan Level 1 (SPL-1) for boneless thighs; and Sample Plan Level 2 (SPL-2) for thigh trim. If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents shall be rejected.
- 572 Unacceptable Meat – Mechanically separated turkey (comminuted), finely ground, flaked, or finely chopped turkey meat.

- 573 **Processing and Size Reduction** – Thigh meat **shall** be reduced in size through a plate with openings that are not less than 0.50 inch and not greater than 1.00 inch.
- 573.1 Thigh trimmings **shall** be ground through a plate with holes no less than 0.125 inch (1/8 inch) in diameter; or reduced through a desinewer plate or screen with holes 0.0591 inch to 0.0787 inch in diameter. For trim meat reduced through a desinewer plate or screen, the patella (knee cap) and portions of the condyle of the femur may be present when attached to the thigh trim.
- 573.1.1 Additionally, the plate, screen, or equipment **shall** be designed to extract and discharge bone, bone-like material, cartilage, etc., simultaneously with size-reduction. The system **shall** provide a continuous flow of discharge material during size-reduction. The discharge material **shall** not be used in the commodity produced under this FPPS.
- 574 **Defects** – Thigh trim that is size-reduced using equipment **designed to extract and discharge the material listed above** shall be examined for bone, bone-like material, cartilage (gristle), cartilage-like material, or hard tendons or tendonous material after size reduction only. Regardless of the size-reduction system used, thigh trim **shall** be examined for skin, blood clots, and discolorations prior to size reduction.
- 575 **Organoleptic Requirements and Defects** for Size-Reduced Meat
- 575.1 The size-reduced meat and size-reduced trim meat **shall** be examined in the fresh state on a continuous basis for the organoleptic requirements listed in Table 2 prior to formulation. If the product does not comply with the organoleptic requirements, it **shall** be rejected for use under this FPPS.
- 575.2 A 5-pound sample of size-reduced meat and a 2-pound sample of size-reduced trim meat **shall** be drawn and examined in the fresh state for the defects listed in Table 2 prior to formulation.
- 575.2.1 If the sample of size-reduced meat or trim meat contains bone or bone-like material, or has more meat defects (listed in Table 2) than the maximum tolerance for SPL-2, the product the sample represents **shall** be rejected for use under this FPPS.
- 576 **Temperature Requirements** – Size-reduced meat or trim which is not used in the turkey ham on a continuous basis, **shall** be cooled by using cooling methods or media (e.g., use of liquid CO<sub>2</sub>, dry ice or liquid N<sub>2</sub>) that ensure the internal product temperature is **between** 26 °F (-3.3 °C) **and** 40 °F (4.4 °C).
- 576.1 Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat or trim **shall** not be incorporated into the size-reduced product. Liquid associated with normal product purge is acceptable. No frozen or previously frozen size-reduced meat or trim may be used in the turkey hams.
- 577 **Processing Sequence** – Unless otherwise specified, the size reduction; formulation; mixing; stuffing into casings, smoking/cooking, cooling; **slicing**, packing; and

freezing of the commodity shall be a continuous process that complies with the time and temperature requirements of this FPPS.

580 Formulation – Smoked Turkey Ham Products

	<u>Percent of Total by Weight</u>
Size-Reduced Meat Block (minimum)	80.0
Other Ingredients:	total shall not exceed 20 percent
Water (up to)	14.4
Added Processing Aids including Curing Agents (up to)	7.6
Total	100.0

581 Sodium Requirement – The sodium content of the cooked commodity shall be no more than 600 mg per 100 gram basis as evidenced by laboratory analysis.

582 Water and/or ice shall be added to assist in the processing of turkey hams. The amount of water/ice and other ingredients shall comply with the “12-percent water added” statement for the finished commodity. See EXHIBIT 1 for an example of this calculation.

583 Dry ingredients may be mixed with water to form a brine solution prior to the addition of the meat. As an option to forming a brine solution, dry ingredients may be added directly to the meat portion and thoroughly mixed.

583.1 Soy and gluten are not allowed.

584 If liquid smoke flavoring is added to the formulation, the percentages for salt, sugar, and phosphate may be adjusted (reduced) to include this ingredient.

585 Verification of compliance with actual percentages of sodium erythorbate or sodium ascorbate and sodium nitrite used shall be monitored by FSIS.

586 The AMS Grader shall monitor the “other ingredients” (salt, sodium phosphate, binder, cure, and cure accelerator) formulation requirements. FSIS shall monitor compliance with the labeled “12-percent added water” statement.

587 Batches of turkey thigh meat, trimmings, and other ingredients shall be formulated to comply with the required 95 percent fat free labeling. Verification shall be monitored by FSIS personnel.

588 Processing aids (e.g., anti-caking agents, anti-dusting agents, or other manufacturing aids (as present in salt, sugar, etc.)) are allowed. If processing agents are used, the ingredients and amount of ingredients listed in the formulation shall remain the same.

590 Mixing – The brine solution shall be incorporated into the size-reduced thigh meat

by mixing/blending, or tumbling or massaging with or without vacuum. If the option of adding dry ingredients directly with the meat portion is used, batches of meat, dry ingredients, and water/ice shall be thoroughly mixed (by mixing/blending, or tumbling or massaging with or without vacuum) to ensure even distribution of ingredients throughout the batch.

5000 Stuffing into Casings

5010 After blending, the formulated batches of ingredients shall be stuffed into a cook-in-film bag, pouch, plastic casing, moisture proof casing, standard fibrous casing, or smoke impregnated casing.

5010.1 Formulated batches of ingredients shall be stuffed into casings (pre-smoked casing is allowed) that conform to the finished smoked ham commodity requirements of 4 to 5 inches in diameter, round, and approximately 10 pounds or 2 pounds net weight.

5011 In no case shall the stuffing of the formulated batches of ingredients into casings be delayed longer than 48 hours or will the formulated batches shall be held at an ambient temperature between 26 °F (-3.3 °C) and 40 °F (4.4 °C).

5020 Smoking – Stuffed casings of formulated product shall be smoked. Liquid smoke flavoring and smoke impregnated fibrous casings may be used. The processor shall inform the AMS Grader of the smoking method being used, and appropriately label that method on each commodity label.

5021 Product Color Characteristic – Product shall have a mahogany color that is commonly associated with smoked meats and not be lighter or darker than the color tolerance.

5021.1 To obtain a copy of the Official USDA Color Control Standard on Turkey Ham, please contact QAD at (202) 720-3271.

5030 Cooking – All products shall be fully cooked in accordance with FSIS regulations.

5031 Cooling – After cooking, the commodity shall be cooled to an internal product temperature of 40 °F (4.4 °C) or lower. Cooling methods and procedures shall be in compliance with FSIS directives and guidelines for cooked products.

5040 Reworked Commodity – Smoked turkey hams which are fractured (separated into two or more pieces); are misshaped; have cuts; have more internal or external defects than the maximum tolerances allowed; or do not meet the size and weight requirements may be reworked (defects removed) and incorporated into formulated batches of turkey ham provided:

5040.1 temperature of the hams has not exceeded an internal product temperature of 40° F (4.4° C) and they have been maintained at that temperature or lower;

5040.2 hams are reworked within 72 hours from the end of the shift it was packaged;

- 5040.3 hams are ground through a plate with holes 0.125 inch (1/8 inch) in diameter;
- 5040.4 hams are incorporated at a maximum of 2 percent of the formulated batch (2 percent of the total 15 percent trimmings allowed); and
- 5040.5 hams are added to formulated product that shall undergo the same smoking method(s).
- 5050 Freezing – Packaged commodity shall be placed in a freezer within 48 hours of packing. The commodity shall be frozen by lowering the internal product temperature to 10 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If the commodity is not placed in a freezer immediately after packing, the product shall be held at a temperature between 26 °F (-3.3 °C) and 36 °F (2.2 °C). When packaged product is held at a temperature below 26° F (-3.3 °C), the commodity shall be considered to be in a freezer and subject to the 72-hour freezing requirement which begins at the end of the shift the commodity enters the 26 °F (-3.3 °C) or lower facility.
- 5060 Metal Detection – The commodity shall 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 metal according to QAD policies and procedures.
- 5061 As an alternate method, the formulated product may be examined by an in-line metal detection device installed in the mechanical stuffing or forming system before cooking and/or smoking. If the alternate metal detection method (in-line) is used and casings are later cut to meet the physical requirements, the product shall also be examined by a metal detection device after it is placed in the bag or casing.
- 5062 Commodity found to be contaminated with metal shall be handled in accordance with FSIS procedures. Other procedures for examination of the commodity shall be approved by the Director of the FSCS Division in writing.
- 5070 Equipment – All equipment used to produce the commodity for USDA shall be maintained and routinely checked for optimal performance.
- 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, shall be safe for use in contact with food products (cannot adulterate product or be injurious to health), and shall be tamper-evident. Tamper-evident is defined as packaging and packing materials with one or more indicators of barriers to entry, which, if breached or missing, can reasonably be expected to provide visible evidence that tampering has occurred. All packaging material shall comply with FSIS regulations



(9 CFR § 381.144(c)).

- 630 Films, Bags, and Casings – **Shall** be made of water-proof film with oxygen barrier properties; be heat-shrinkable; and **shall** protect the product from dehydration, freezer burn, quality deterioration or contamination during the conditions of use.
- 631 When fibrous casings are used, the casing **shall** be removed from **the commodity** after the smoking, cooking, and cooling processes just prior to packaging.
- 632 **The commodity shall** be packaged in a heat shrinkable oxygen- and water-proof **film**, bag, or casing, **as appropriate**. The excess air **shall** be removed (by vacuum) from each **film**, bag, or casing. The bag or casing **shall** be shrunk to fit tightly against the surface of the **commodity**.
- 633 After the air is removed, the **film**, bags or casings **shall** be hermetically heat sealed to ensure a vacuum closure and to prevent product dehydration and quality deterioration. Metal wire ties, paper-coated wire ties, or staples **shall** not be used for sealing bags or casings.
- 640 **Shipping Containers shall:**
- 640.1 **be** good commercial fiberboard containers that are acceptable by common or other carrier for safe transport to point of destination,
- 640.2 **be** of such size to pack the commodity without slack filling or bulging,
- 640.3 **w 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 CN Labeling information or a Product Formulation Statement demonstrating product contribution to the National School Lunch Program meal pattern requirements is required. For more information on the CN Labeling Program, see the section for Food Manufacturers/Industry on the FNS website:  
<http://www.fns.usda.gov/cnlabeling/child-nutrition-cn-labeling-program> .
- 720 Water Added Statement – The **commodity shall** be formulated with water and other ingredients in a manner that complies with the required labeling of “12-percent water

added”.

- 721 Percent Fat Free Statement – The commodity shall be formulated to comply with the requirements of this FPPS, and comply with the “95 Percent Fat Free” statement to be placed on each shipping container. The contractor/processor is responsible for providing any analysis data required by FSIS to label this commodity.
- 730 Smoked Turkey Ham (100126) and (110911 – Sliced) shall use either commercial labeling or USDA labeling. When commercial or USDA labeling is selected, both the packages and shipping containers within a purchase unit shall be labeled in that format. The contractor must use the same label format (either commercial or USDA) within a purchase unit.
- 730.1 For Smoked Turkey Hams (100886) and (XXXXXX – Sliced), only commercial labeling shall be used. Each individual package and shipping container shall be commercially labeled.
- 740 Commercial Labeling Requirements
- 741 Commercially labeled packages and shipping containers shall be labeled in accordance with FSIS requirements. Labeling shall be approved by FSIS prior to acceptance for use under this FPPS.
- 742 Commercial Labels shall be the processor’s own commercial label.
- 743 Traceable Product – The processor shall 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 FPPS and commercial product, the identification system shall 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, shall be reviewed by USDA/AMS before production begins for the contract(s).
- 744 Nutrition Facts, Ingredients, and Allergen Statements on Shipping Containers – Nutrition Facts shall be provided. The ingredient statement, even for single ingredient foods, shall be included as a statement separate from the name of the product, e.g. Ingredients: \_\_\_\_\_. The allergen statement shall 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 \_\_\_\_\_. For additional guidance refer to the Compliance Guidance at:  
<http://www.fsis.usda.gov/wps/wcm/connect/f9cbb0e9-6b4d-4132-ae27-53e0b52e840e/Allergens-Ingredient.pdf?MOD=AJPERES>
- 750 USDA Labeling Requirements

751 When USDA labeling is used, any deviations from the USDA labeling requirements in this FPPS shall be approved by the Contracting Officer, in writing, prior to start of production. Labeling and marking of the commodity shall be in accordance with this FPPS.

752 Labeling and marking information shall be water-fast, non-smearing, of a contrasting color, clear, and readable.

### 753 USDA-Labeled Shipping Container Requirements

753.1 Labeling and marking information shall be preprinted, stamped, or stenciled on each shipping containers, or printed on a self-adhesive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 2 - 4.

753.2 Nutrition Facts, Ingredients and Allergen statements on Shipping Containers – I Nutrition Facts shall be provided. The ingredient statement, even for single ingredient foods, shall be included as a statement separate from the name of the product, e.g. Ingredients: \_\_\_\_\_. The allergen statement shall 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 \_\_\_\_\_. For additional guidance refer to the Compliance Guidance at:

<http://www.fsis.usda.gov/wps/wcm/connect/f9cbb0e9-6b4d-4132-ae27-53e0b52e840e/Allergens-Ingredient.pdf?MOD=AJPERES>

### 753.3 Universal Product Code (UPC) Code

753.3.1 The UPC symbol and code, called Interleaved 2 of 5 (I 2/5), shall appear on the principal display panel of each shipping container. The complete code, including the check digit, shall be printed in machine-readable and human-readable form. The start and stop indicators shall be included in the bar codes. Printing, readability, and scanability of the bar code shall be in accordance with UPC guidelines published by GS-1 US, Princeton Pike Corporate Center, 1009 Lenox Drive, Suite 202, Lawrenceville, NJ 08648.

753.3.2 The contractor shall use the code furnished by USDA. USDA has acquired a unique processor's identification number for the commodity purchase programs and shall use a unique item code number for the commodity purchased under this FPPS. The contractors need not join GS-1 US.

753.3.3 14-digit UPC code for smoked turkey ham products:

753.3.3.1 Material Code 100126 – 1 07 15001 00126 6.

753.3.3.2 Material Code 100886 – 1 07 15001 00886 9.

753.3.3.3 Material Code 110911 – 1 07 15001 10911 5.

753.3.3.4 Material Code (2 pound Sliced) – X XX XXXXX XXXXX X.

- 753.4 The UPC code shall be placed in the lower right-hand corner of the principal display panel of each shipping container.
- 754 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 shall be legibly printed in permanent ink.
- 755 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 surface of the shipping container but shall not cover or conflict with the labeling requirements of this FPPS.
- 756 Shipping containers or labels with incorrect: contract number, plant number, net weight, date packed, shall be corrected before they are used. The incorrect information shall be blocked out and the correct information legibly printed, stamped, or stenciled in permanent ink. Additionally, the name, address, and phone number of the processor shall appear on each shipping container.
- 760 Unacceptable Labeling
- 761 Commercial labels that do not have a processor traceability system and code.
- 762 Commercial labeling traceability coding and systems that have not been reviewed by a representative of USDA/AMS/LPS/QAD.
- 763 Distributor Commercial Labels
- 764 Two or more different commercial labels in the same purchase unit.
- 765 Commercial labels and USDA labels in the same purchase unit.
- 770 Free Along Side (FAS) Vessel Deliveries
- 771 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 Packaging Defects – Packages in a delivery unit shall 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 packages.
- 820 Packing Defects – Shipping containers in a delivery unit shall be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers.
- 830 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 QAD sample plan, the delivery unit shall be rejected.

840 Net Weight – Net weight for smoked turkey ham products shall be determined at origin.

841 A purchase or delivery unit shall total 40,000 pounds net, or multiples thereof.

842 Test Weighing Procedures

842.1 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.

842.2 A representative sample shall be selected in accordance with the following sample plan:

<u>Number of Shipping Containers in Lot</u>	<u>Number of Shipping Containers in a Sample</u>
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.

842.3 **Weight Variation** – A weight variation of minus 1 percent (39,600 pounds) is permitted on each delivery unit. USDA shall pay the contractor only for the amount of commodity delivered within the required weight range. Any delivery unit not within the required weight range shall be rejected.

843 As an alternative to test weighing at time of checkloading, the contractor may request on-line verification of net weights. Upon receiving the request, a Federal-State supervisor, QAD, LPS Program (or their designee), shall determine that the facilities and procedures are in accordance with the applicable LPS Program's instructions for this FPPS.

850 Loading and Shipping Frozen Commodity

851 Visual Inspection – Frozen commodity showing any evidence of thawing, refreezing, or freezer deterioration shall be rejected for use under this FPPS.

852 Internal Product Temperature

852.1 **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.

- 852.2 Optional Temperature Verification – The contractor may request an alternate method utilizing product temperature-sensing devices. If this option is selected, a Federal-State supervisor 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 LPS Program's instructions for this FPPS.
- 860 Inspection and Checkloading
- 861 Requirements – Inspection for contract compliance shall be made by a USDA representative, in accordance with 7 CFR § 70, FSIS regulations, and this FPPS, at site of processing, both during and after processing and packaging. Inspection records shall be complete and made available to USDA, as requested, to assure contract compliance.
- 862 Procedures – The inspection and checkloading shall be performed by the 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, LPS Program, AMS, USDA, 1400 Independence Avenue, Room 3953-S, STOP 0258, Washington, DC 20250-0258, telephone (202) 690-3147. The quality, quantity, weight, packaging, packing, and checkloading of the commodity shall be evidenced by certificates issued by the AMS Grader. 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 Products Grading Certificate issued at time of checkloading shall accompany each shipment.
- 1012.1 Railcar or Piggyback – If shipment is by rail 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 – If shipment is by truck, 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 USDA origin AMS Grader shall make arrangements for destination examination prior to delivery.
- 1120 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.
- 1130 Temperature – The 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).

**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 for Commodity Procurements and Solicitation.

1220 Waiver Requests – Contractor shall submit all waiver requests directly to the Commodity Procurements Staff (CPS) Contracting Officer for review and determination. 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>

1230 Complaint Resolution – Customer complaint resolution procedures shall be the responsibility of the Contractor. These procedures shall include: a point of contact, investigation steps, and 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**

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

**Table 2. Organoleptic Requirements and Defects for Size-Reduced Meat and Trim Meat**

<b>Organoleptic Requirements:</b>	<b>Meat shall:</b> (a) not be rancid; not have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign and off-odors; not contain foreign materials (e.g., glass, paper, rubber, metal, plastic, <b>wood</b> ); or show evidence of mishandling or deterioration; and (b) have a bright color.
<b>Defects – Meat and Trim</b>	Bone or bone-like material.
	Cartilage (gristle) or cartilage-like material, or hard tendons or tendonous material.

**Table 3. Organoleptic Requirements and Defects for Finished Turkey Hams**

<p><b>Organoleptic Requirements:</b></p>	<p><b>Meat shall:</b> (a) not be rancid; have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other 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.</p>
<p><b>Exterior:</b> (10 products examined)</p>	<p style="text-align: center;"><b>Defects</b></p> <p><b>Individual major surface voids</b> (including air voids, fat pockets, and purge pockets) exceeding an aggregate area equivalent to the area of a circle with the diameter of 0.75 inch (1.91 cm). The depth of a void or pocket shall be no greater than 0.50 inch (1.27 cm).</p> <p>Unobtrusive purge is allowed; however, pockets and voids holding purge, fat, or air shall not exceed the aggregate diameter of 0.75 inch (1.91 cm).</p> <p><b>Product shows evidence of</b> excessive heating (burnt or scorched).</p> <p><b>Individual hams that are not</b> 4 to 5 inches (10.16 to 12.70 cm) and round in diameter.</p> <p><b>Product</b> that does not have a mahogany color associated with smoked meats, or one with a mahogany color lighter than or darker than the tolerance.</p>
<p><b>Interior:</b> (2 products examined) Product shall be cut (widthwise) in three approximately equal pieces.</p>	<p><b>Voids, gelatin, or fat pockets</b> on the sliced surfaces that exceed an aggregate area per surface equivalent to the area of a circle with the diameter 0.75 inch (1.91 cm).</p>

# Color Control on Turkey Ham



**Light tolerance**



**Dark tolerance**

United States  
Department of  
Agriculture

Agricultural  
Marketing  
Service

Poultry Division  
Washington, D.C. 20250  
July 1994

"NOT TO BE USED AS THE OFFICIAL STANDARD"

**EXHIBIT 1**  
**Example Formulation for Smoked Turkey Ham Products**

In the formulation of turkey ham products, the meat portion and the added water (all other non-meat ingredient) portion are considered two separate components. Water/ice and other ingredients shall be added to the meat portion to assist in the processing of turkey hams products. Water/ice\* may be added in an amount to be determined by the contractor/processor taking into consideration the smoking/cooking method and yield\*\*. The end product shall comply with the 12 percent water added requirement (percentage includes water and all other non-meat ingredients) and this FPPS. The added water statement shall be calculated on the formulation using the raw meat (green) weight and the finished cooked weight of the product as shown below.

$$\frac{\text{Finished weight} - \text{Green weight}}{\text{Finished weight}} \times 100 = \% \text{ Added Water/Ingredients Declaration}$$

**The following formulation is only an example and should not be mistaken for actual poundage to be used:**

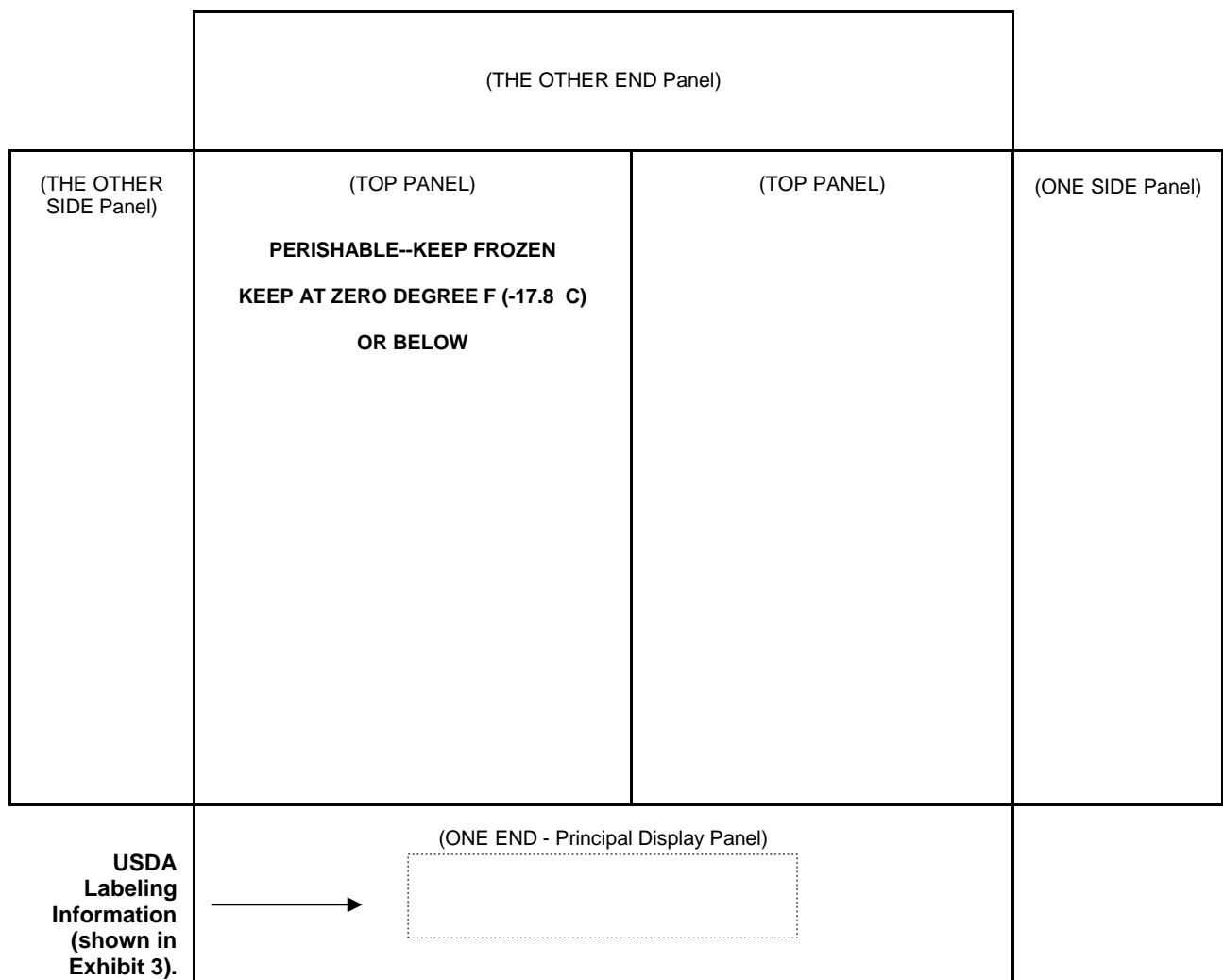
	<u>Number of Pounds</u>
<b>Meat Portion (Green Weight)</b>	
Size-Reduced Turkey Thigh Meat (may contain up to 15% thigh trimmings)	<u>100.00</u>
Raw Meat Weight w/o Water/Ingredients	<b>100.00 lbs.</b>
 <u>Water / Other Ingredient Portion</u>	
*Water/Ice	18.15
Salt	1.50
Lite Salt	0.50
Brown Sugar	2.00
Sodium Phosphate	0.50
Approved Binder(s) (maximum)	0.50
Sodium Erythorbate	0.61
Sodium Nitrite	0.02
Sodium or Potassium Lactate/Diacetate (maximum)	<u>2.50</u>
Raw Batch Weight	126.28 lbs.
**Yield (%) after cooking/smoking	<u>x 0.90</u>
Finished Cooked/Smoked Weight	<b>113.65 lbs.</b>

***Percent added water calculation:***

$$\frac{113.65 \text{ lbs} - 100 \text{ lbs}}{113.65 \text{ lbs}} \times 100 = 12\% \text{ Added Water}$$



## EXHIBIT 2 USDA Labeled Shipping Containers

**Marking Information:** Shipping containers may be marked substantially as shown below. Detailed USDA labeling information is provided in Exhibit 3 and Exhibit 4. Markings shall be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. The USDA symbol, Exhibit 6, 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 shall be printed on the "TOP PANEL" or principal display panel. The processor's name and address shall indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints. ***The Handling Information and Nutrition Facts Label (on the principal display panel) is required on shipping containers of commodity weighing 10 and 5 pounds.***



**EXHIBIT 3**  
**USDA Label Information for Smoked Turkey Hams**



Marking Information: USDA labeling information shall be printed on the principal display panel of each shipping container as provided in Exhibit 2. Markings shall be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. <sup>1</sup>The identification of *smoking method(s)* used below is provided only as an example. The processor shall designate the applicable smoking method used on each label and the labeling shall be approved by FSIS. The UPC 14-digit I 2/5 bar and code, shall be shown in the lower right-hand corner of the principal display panel. The USDA symbol, EXHIBIT 6, shall be a minimum of 2.25 inches (5.72 cm) in height and shall be printed on the "TOP PANEL" or principal display panel. The processor's name, address, and phone number shall be printed on the top panel or the principal display panel. The processor's name and address shall indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.

	
<p><b>FROZEN FULLY COOKED SMOKED TURKEY HAM*</b> <b>with 12% Water</b></p> <p><b>*Cured Turkey Thigh Meat, Chunked and Formed, Smoke Flavor Added (as applicable)<sup>1</sup> 95% FAT FREE</b></p> <p>Ingredients:</p> <p><b>(Food Allergen Statement, Shall be Placed Here)</b></p>	
<p><b>Processor's Name, Address, and Phone</b></p>	<p><b>Required Nutrition Facts Label Shall Be Placed Here</b></p>
<p><b>KEEP FROZEN</b></p>	
<p>__ Bags Net Weight __ LBS. ( __ KG)</p>	<p><b>DATE PACKED <u>Month, Day, and Year</u></b></p>
<p><b>UPC Bar and Code</b></p>	

## EXHIBIT 4

### USDA Label Information for Smoked Sliced Turkey Hams

Marking Information: USDA labeling information shall be printed on the principal display panel of each shipping container as provided in Exhibit 2. Markings shall be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. <sup>1</sup>The identification of *smoking method(s)* used below is provided only as an example. The processor shall designate the applicable smoking method used on each label and the labeling shall be approved by FSIS. The UPC 14-digit I 2/5 bar and code, shall be shown in the lower right-hand corner of the principal display panel. The USDA symbol, EXHIBIT 6, shall be a minimum of 2.25 inches (5.72 cm) in height and shall be printed on the "TOP PANEL" or principal display panel. The processor's name, address, and phone number shall be printed on the top panel or the principal display panel. The processor's name and address shall indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.

	
<b>FROZEN FULLY COOKED SMOKED SLICED TURKEY HAM*</b> with 12% Water	
*Cured Turkey Thigh Meat, Chunked and Formed, <i>Smoke Flavor Added (as applicable)</i> <sup>1</sup> 95% FAT FREE	
Ingredients:	
(Food Allergen Statement, Shall be Placed Here)	
Processor's Name, Address, and Phone	Required Nutrition Facts Label Shall Be Placed Here
<b>KEEP FROZEN</b>	
__ Bags Net Weight __ LBS. ( __ KG)	<b>DATE PACKED <u>Month, Day, and Year</u></b>
<b>UPC Bar and Code</b>	

**EXHIBIT 5**  
**“Please Recycle” Symbol and Statement**



**PLEASE  
RECYCLE**



# USDA SYMBOL

