



APPROVED

**FEDERAL PURCHASE
PROGRAM SPECIFICATION
(FPPS) FOR SMOKED PIT
HAM, CURED, BONELESS,
FULLY COOKED, WATER-
ADDED, FROZEN**

Agricultural Marketing Service (AMS)
Livestock, Poultry and Seed (LPS) Program
Food Safety and Commodity Specification (FSCS) Division
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Effective: July 2017

100 ITEM DESCRIPTION

110 Smoked Pit Ham, Cured, Boneless, Fully Cooked, Water-Added, Frozen – For this item, six (6) hams (5.0 ± 0.5 lbs. each) shall be packed per shipping container with a catch weight range of 30 ± 2 lbs. Additionally, these hams shall be 94.0 percent fat free (6.0 percent fat), have a minimum Protein Fat Free (PFF) value of 17.0 percent, have a whole muscle appearance with uniform, cured color (no two-toning), minimal fat pockets, and exhibit a firm, non-porous texture post thawing. The exterior shall be tear drop in shape, netting imprinted (e.g. honeycomb) and display a rich mahogany color, typical of smoked ham products.

200 CHECKLIST OF REQUIREMENTS

210 All items shall be produced in accordance with Food Safety and Inspection Service (FSIS) regulations and the AMS Checklist of Requirements listed below.

300 MATERIALS

310 The contractor's technical proposal shall include procedures to address conformance with the following material requirements.

320 MEAT COMPONENT

321 Pork leg insides (*Semimembranosus*), knuckles (*Tensor fasciae latae* & *Quadriceps* group) and/or outsides (*Biceps femoris* & *Semitendinosus*) of the sow and/or hog carcass shall be the only meat components allowed. Pork derived from boars is not permissible.

322 Domestic Origin of Meat Component – All sows and/or hogs shall originate from U.S. produced livestock as defined in the Master Solicitation for Commodity Procurements and this Supplement.

- 323 Harvesting (Slaughtering) – All sows and/or hogs shall be harvested in facilities that comply with the following requirements:
- 323.1 Humane Handling – All sows and/or hogs shall be humanely handled in accordance with all applicable FSIS regulations and AMS requirements.
 - 323.2 Non-Ambulatory Disabled Animals – Meat from carcasses of non-ambulatory disabled livestock shall not be included in USDA Purchase Programs.
- 324 Pork Leg Insides/Knuckles/Outsides – Hams shall be derived from pork leg insides, knuckles and/or outsides that comply with the following requirements:
- 324.1 Traceability – The contractor is responsible for providing sufficient product traceability and shall have records to verify the source of raw materials used in each lot of product.
 - 324.2 Handling – All pork leg insides, knuckles and/or outsides shall be maintained in excellent condition. The contractor’s technical proposal shall include detailed production scheduling with time and temperature controls necessary to maintain excellent condition of the pork leg insides, knuckles and/or outsides.
 - 324.3 Fresh Chilled Only – Hams shall be derived from fresh chilled pork leg insides, knuckles and/or outsides. Previously frozen pork leg insides, knuckles and/or outsides cannot be used.
 - 324.4 Lean Quality – The pork leg insides, knuckles and/or outsides shall not exhibit any evidence of pale, soft, and/or exudative conditions.
 - 324.5 Uniform Color – Pork leg insides, knuckles and/or outsides shall be sorted for color uniformity to preclude two-toning in the finished product.
 - 324.6 Objectionable Materials – Pork leg insides, knuckles and/or outsides shall be free of skin, bone, cartilage, organ tissue, significant glandular tissue, heavy connective tissue and foreign materials.
- 325 Mechanical Separation – Meat that is mechanically separated from bone with automatic deboning systems and/or advanced lean (meat) recovery (AMR) systems shall not be allowed.

330 NON-MEAT COMPONENTS

- 331 All non-meat components shall be listed in the ingredient statements.
- 332 Domestic Origin – Significant ingredients (more than 1 percent) shall be derived from U.S. produced products.

333 Product Formula – The product formula shall include water, dextrose, salt, sodium phosphate, antimicrobial agent(s) and sodium nitrite. Sodium erythorbate, and/or sodium ascorbate, may be used.

334 The following non-meat ingredients shall be precluded from use in the formulation:

334.1 Monosodium Glutamate (MSG).

334.2 Soy Protein Products (SPP).

334.3 Gluten-containing ingredients.

400 PROCESSING

410 PROCESSING DATE

411 Ham products, as delivered to AMS destinations, shall be processed no more than 60 days prior to shipment.

420 PRODUCT COOKING

421 Hams shall be fully cooked and smoked in accordance with FSIS regulations. The use of natural wood smoking and/or liquid smoke may be used to achieve the appropriate standard of identity (“Smoked”).

430 METAL DETECTION

431 All hams shall be free of metal contamination. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required. The equipment, location, detection procedure, sensitivity levels, frequency of equipment validation, and corrective action procedures shall be identified and described.

500 FINISHED PRODUCT LIMITATIONS

510 Fat and protein fat free label declarations shall comply with FSIS labeling regulations.

520 FAT

521 The fat content of the finished product will not exceed six (6.0) percent.

522 Percent Fat = (Total Fat / Serving Size) x 100.

530 PFF

531 The contractor shall target its production to maintain a minimum PFF value of 17.0 percent.

532 $\text{Percent PFF} = (\text{Percent Protein} / (100 - \text{Percent Fat})) \times 100.$

540 SODIUM

541 Sodium level shall not exceed 750 mg per 100 g.

542 $((\text{Declared Sodium Level (mg)} \times 100) \div \text{Declared Serving Size (grams} - \text{reference amount customarily consumed (racc))} < 750).$

550 MICROBIAL

551 Contractor shall have a documented plan to comply with the latest FSIS *Salmonella* and *Listeria monocytogenes* requirements for ready-to-eat foods. Product tested positive for any pathogen shall not be allowed delivery to USDA.

600 STATE OF REFRIGERATION

610 Hams shall comply with the following holding time and temperature requirements:

620 HOLDING TIME

621 After processing, hams shall be refrigerated for a minimum of eight (8) hours.

630 HOLDING TEMPERATURE

631 Hams shall have an internal temperature not to exceed 40°F prior to placement in the freezer.

640 72 HOURS TEMPERATURE

641 Hams shall be 0°F or below within 72 hours after placement into the freezer.

700 PREPARATION FOR DELIVERY

710 PACKAGING

711 Individual hams (5.0 ± 0.5 lbs. each) shall have the netting removed and be vacuum packaged.

720 PACKING

721 Six (6) hams (5.0 ± 0.5 lbs. each) shall be packed per shipping container with a catch weight of 30 ± 2 lbs.

730 LABELING^{1/, 2/}

731 The shipping containers shall be in compliance with the National Motor Freight Classification, or the Uniform Freight Classification, as applicable. Both immediate (packaging material) and shipping containers shall be labeled to include all information required by FSIS regulations.

732 Immediate Container Label – Each immediate container shall contain the following information:

732.1 A traceability code that is traced back to establishment number, production lot, and date.

732.2 A “Best-If-Used-By” date that is 360 calendar days from the date of production.

732.3 Nutrition facts panel based on actual laboratory analysis of the product.

733 Shipping Container Label – Shipping containers shall contain the following information:

733.1 USDA shield at least 2 inches high and appearing on the top of the container or on the principal display panel.



733.2 Appropriate purchase order number.

733.3 A traceability code that is traced back to establishment number, production lot, and date.

733.4 Ingredient declaration.

733.5 A nutrition facts panel based on actual laboratory analysis of the product.

733.6 Product name: Smoked Pit Ham, Cured, Boneless, Fully Cooked, Water-Added, Frozen

733.7 Material number: 110900

733.8 An allergen statement in a 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 _____.

^{1/}All labeling illustrations shall be provided in the contractor's technical proposal.

^{2/}Commercial labeling (Brand "X") of immediate and shipping containers is permissible.

740 CLOSURE

741 Shipping containers shall be closed by strapping, taping or gluing. When strapping is used, the initial closure (usually the bottom of container) shall be secured by gluing or taping.

750 PALLETIZED UNIT LOADS

751 All product shall be stacked on new or well-maintained pallets and palletized with shrink wrap plastic. 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.

800 DELIVERY UNIT

810 Each delivery unit shall consist of 1,280 cases (7,680 individual hams) with a net weight not to exceed 39,050 pounds.

900 DELIVERED PRODUCT

910 SIZE AND STYLE OF CONTAINER

911 Only one size and style of immediate and shipping containers shall be offered in an individual shipping unit.

920 TEMPERATURE

921 All products shall be frozen and not exceed 0°F at the time of shipment. This temperature shall be maintained during transit, from originating establishment to receipt at the final destination.

930 SEALING

931 All products shall be delivered to AMS destinations under seal. Seals shall be serially numbered, barrier-type and meet the American Society for Testing and Materials (ASTM) standards (F-1157-04) and/or the International Organization for Standards (ISO) 17712-2010. Seals shall be 1/8th-inch diameter cable, high security bolt, or equivalent.

1000 PRODUCT ASSURANCE

1010 WARRANTY AND COMPLAINT RESOLUTION

1011 Warranty – The contractor shall guarantee that the product complies with all contractual requirements required of this Supplement.

1012 Complaint Resolution – The contractor’s technical proposal shall provide steps taken to resolve complaints received on the product (i.e. point of contact, cause and effect analysis, corrective and preventative actions taken, and product replacement).

1020 NON-CONFORMING PRODUCT

1021 The contractor shall include a plan and supporting documentation to assure that non-conforming product is not delivered under USDA contracts. The plan shall address 1) control and segregation of non-conforming product, 2) removal of any USDA markings, and 3) disposition of non-conforming product, including vendor documentation of final disposition (e.g., diverted from AMS production or destroyed).

1030 CONTRACTOR CHECKLOADING

1031 Contractor shall perform checkloading examinations at the time of shipment and issue a contractor’s certificate to accompany each shipment that includes the following information:

1031.1 Purchase Order Number/Purchase Order Line Item Number;

1031.2 Sales Order Number/Sales Order Line Item Number;

1031.3 Destination of shipment;

1031.4 Name of Product and applicable Material Number;

1031.5 Shipping Date;

1301.6 Production lot number(s) and date each lot was produced along with shipping container and immediate container code(s) and the code used that provides traceability to establishment number, production lot and date;

1301.7 Count of shipping containers and total projected net weight in each production lot;

1031.8 Identity of car or truck (car numbers and letters, seals, truck license, etc.) as applicable;

1301.9 Contractor certification that product conforms with the applicable specification (FPPS-HP-2017);

1031.10 Count and projected net weight verified and;

1031.11 Signature of company official responsible for checkloading.