



APPROVED

FEDERAL PURCHASE PROGRAM SPECIFICATION (FPPS) FOR TURKEY AND TURKEY PRODUCTS

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

Supersedes: Turkey and Turkey Products March 2015 –
Changes from previous requirements in blue

Effective: July 2018

100 ITEM DESCRIPTION

- 110 Consumer Pack [Whole Turkey](#) (100123) – Frozen, ready-to-cook young turkeys without necks and giblets; basting [is](#) optional. Turkeys [shall](#) weigh 12 to 22 pounds per carcass weighed without necks and giblets. A purchase unit [shall](#) total 38,000 pounds.
- 120 Bulk Pack [Turkey](#) (100124) – Chilled, ready-to-cook young turkeys for further processing without necks and giblets [and](#) non-basted. Frozen may be specified in the Solicitation. The individual turkey weight range [shall](#) be 18 to 32 pounds per carcass weighed without neck and giblets. A purchase unit [shall](#) total 36,000 pounds.
- 130 [Turkey Roasts](#) (100125) – Frozen, ready-to-cook young turkey roasts [shall](#) weigh 8 to 12 pounds. Roasts [shall](#) be packaged in elasticized netting [with](#) moisture proof casings or plastic film bags, packed four roasts per fiberboard shipping container. A purchase unit [shall](#) total 40,000 pounds.
- 140 [Turkey Roasts](#) (111000) – Frozen, ready-to-cook young turkey roasts shall weigh 4 to 6 pounds. Roasts shall be packaged in elasticized netting with moisture proof casings or plastic film bags, packed eight roasts per fiberboard shipping container. A purchase unit shall total 40,000 pounds.

200 APPLICABLE DOCUMENTS

- 210 The following documents are incorporated as part of this USDA, AMS, LP Program, FSCS Division FPPS – Turkey and Turkey Products – July 2018:

- 210.1 AMS/LP Program/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 Consumer Pack Whole Turkey (100123) and Turkey Roasts (100125 and 111000) shall not be processed and packaged more than 90 calendar days prior to the first date of the delivery period for each sales order.
- 531 Bulk Pack Turkey (100124) shall not be processed prior to the date of the 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 § 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 roasts; packaging and packing; freezing; labeling and marking; sampling; net weight; and checkloading.

- 541 AMS Certification – 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, telephone (202) 720-5705.
- 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 Class and Style – Young turkeys shall conform to the definition for the class in AMS 70.202. Young turkeys may be of either sex. Turkey carcasses shall conform to the definitions and standards found in AMS 70.210.
- 551 Clips, tags, or bands shall not be attached to the turkey carcasses.
- 551.1 This restriction does not apply to any devices allowed by FSIS for styling the product; for example, hock locks.
- 560 U.S. Grade – Grading shall be in accordance with 7 CFR § 70 and AMS 70.200 *et seq.* Grading shall be under the supervision of an AMS Grader using LP Program’s Sample Plan Level 1 (SPL-1) for Consumer Pack Whole Turkey (100123) and Sample Plan Level 2 (SPL-2) for Bulk Pack Turkey (100124) and Turkey Roasts (100125 and 111000).
- 561 Consumer Pack Whole Turkey (100123) – U.S. Grade A.
- 562 Bulk Pack Turkey (100124) – U.S. Grade B or Better.
- 563 Turkey Roasts (100125 and 111000) – U.S. Grade A.
- 570 Turkey from Other Plants – Turkey carcasses and parts may be transferred or obtained from other processing plants to produce roasts, provided it:
- 570.1 has been processed, handled, and identified in accordance with this FPPS, and

- 570.2 complies with the organoleptic, non-basted, and other applicable requirements for turkey carcasses and parts to be used in roasts as evidenced by USDA certification. USDA certification may occur either at the plant of origin or at the receiving plant.
- 570.3 Bulk Pack (100124) – Limited substitution of donated poultry commodities with certified commercial product of the same quality for use in the state reprocessing program is allowed and shall meet the General Requirements section in QAD Instruction 630a Poultry Substitution Guidelines.
- 571 Type, class, and specific name of the product, part, boneless 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.
- 572 The chilled turkey and turkey 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.
- 580 Meat Time Requirements
- 581 Consumer Pack Whole Turkey (100123) and Bulk Pack Turkey (100124) – The chilled commodity shall be processed, packaged and packed, and placed in a freezer within 7 calendar days from the date of harvest.
- 581.1 Within this 7-day timeframe, the commodity shall be placed in a freezer within 48 hours after packaging. 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).
- 581.1 Packaged commodity shall 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. 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.
- 582 Chilled Bulk Pack Turkey (100124) – Turkey carcasses shall be chilled to an internal product temperature of 40 °F (4.4 °C) or lower immediately after processing. Chilled bulk pack turkey carcasses shall be delivered to destination within 5 calendar days after the date of harvest.
- 590 Roasts – Sources of Meat and Skin
- 591 Meat (breast and thigh) and skin shall be from non-basted (no solution or ingredients added), young turkeys and turkey parts. The chilled breasts and thigh meat and skin shall be deboned and used in the turkey roast within 7 calendar days

after the date of [harvest](#).

- [591.1](#) Chilled meat from boneless breasts and thigh, and skin from previously frozen turkeys may be used when:
- [591.1.1](#) the frozen turkeys have been packaged to protect them from freezer burn and dehydration during storage;
 - [591.1.2](#) 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
 - [591.1.3](#) 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.
- [591.2](#) Frozen boneless breasts and thighs, meat, and skin may be used when:
- [591.2.1](#) produced from freshly [harvested](#) turkeys;
 - [591.2.2](#) 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
 - [591.2.3](#) held not more than 180 days in frozen (0 °F or -17.8 °C) storage. After tempering, the meat [shall](#) be used in the production of turkey roasts within 48 hours. The temperature of the meat [shall](#) not exceed 40 °F (4.4 °C) during the process.
- [592](#) Frozen [Turkey Roasts \(100125 and 111000\)](#) – [Commodity shall](#) be placed in a freezer within 48 hours [after packaging](#). [If the commodity is](#) not placed in a freezer immediately after [packing](#), the roasts [shall](#) be held at a temperature [between](#) 26 °F (-3.3 °C) [to](#) 36 °F (2.2 °C).
- [592.1](#) [Packaged commodity shall](#) 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. 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.
- [5000](#) Organoleptic Requirements – [Chilled \(or frozen for roasts\) turkey and parts shall](#) be examined on a continuous basis for the following organoleptic requirements: [chilled turkey and parts shall](#) be free of rancidity; free of fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign or off-odors; free of foreign materials (e.g., glass, paper, rubber, plastic, wood, metal); [shall](#) show no evidence of mishandling or deterioration; and [shall](#) have a bright color [and show](#) no evidence of dehydration or freezing and thawing. Any turkey carcasses and parts that do not comply with the organoleptic requirements [shall](#) be rejected for use under this FPPS.

- 5010 Basting Option – Consumer Pack Whole Turkey (100123) may be injected with approximately 3.0 percent basting ingredients (+/- 0.3 percent) per the lot average. Basted turkeys shall be in the weight range specified for consumer pack turkeys with the net weight including the basting ingredients.
- 5011 Non-basted – No solution or ingredients can be added.
- 5100 Weight Requirements for Consumer Pack Whole Turkey (100123) and Bulk Packed Turkey (100124) – Carcasses shall be examined for compliance prior to packaging with the individual weight range requirements. Consumer Pack Turkey (100123) shall be examined after basting.
- 5100.1 A sample of 10 carcasses shall be randomly drawn and individually weighed. The frequency of sampling and the number of defects allowed shall be those outlined in the LP Program's SPL-2.
- 5200 Turkey Roast Processing
- 5210 Meat shall be derived from the breast and thigh and 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.
- 5211 Fatty blubber and spongy fat shall be removed from the breast meat in the crop cavity.
- 5212 Unacceptable Meat – Mechanically separated turkey (comminuted, ground, chopped, or desinewed).
- 5220 Skin Covering Options – Skin shall be used only to cover the outer surface of the roasts and 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.
- 5220.1 Skin may be attached to the meat or used as a wrap, or
- 5220.2 Roasts packaged in oven-ready containers are not required to have the exposed outer surface covered in skin and therefore not required to meet the skin covering requirements in this FPPS.
- 5230 Containers of breasts, boneless thighs, meat, or skin shall not contain added water (for example, water from ice or slush ice and water).
- 5240 Defects – Boneless breasts and thighs, meat, and skin shall be sampled and examined for the defects shown in Table 1.

5241 A sample of 30 pieces of each meat component and 30 pieces of skin shall 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 shall be those outlined in LP Program's SPL-1. Separate examinations shall be made for: (1) bone and (2) other defects.

5241.1 Regardless of the kind and number of defects found within Table 1, any sample with bone or bone-like material greater than 0.40 inch shall be cause for the rejection of the product the sample represents.

5241.2 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 shall 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.

5241.3 If the samples of meat and skin have more defects than the maximum tolerance for the sample plan, the product the sample represents shall be rejected.

5300 Formulation for Roasts

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

5301 A different salt or a salt mix such as sodium chloride and potassium chloride may be used.

5310 Except as otherwise specified, only the ingredients and the percentages of ingredients listed in the formulation above may be used. The sodium content of the turkey roast shall contain no more than 500 mg per 100 g based on actual analysis of the product as evidenced by the Nutrition Facts panel.

5321 Soy and gluten are not allowed.

5320 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.

5400 Mixing – Sodium phosphates and salt shall be mixed with the water and added as a solution to the meat and skin during tumbling, massaging, or injecting. Sodium

phosphates **shall** be thoroughly mixed with the water prior to the addition of the salt to the solution.

- 5410 Salt, sodium phosphates, and water **shall** be incorporated into the meat and skin by tumbling, massaging, or injecting **and shall** be accomplished without deforming, shredding, mutilating, or breaking up the pieces of meat.
- 5420 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.
- 5421 Tumbled, Massaged, or Injected:
- 5421.1 When both the meat and skin have been tumbled, massaged, or injected, 50.27 percent breast meat (minimum), 36.36 percent thigh meat (**up to**), and 13.37 percent skin (**up to**).
- 5421.2 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 (**up to**), and 12.50 percent skin (**up to**).
- 5421.3 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.
- 5421.4 Substitution of Thigh Meat for Skin – the maximum percentage of thigh meat permitted **shall** be increased proportionately to the decrease in percentage of skin.
- 5422 Mechanical Forming or Stuffing **Fabrication Process shall**:
- 5422.1 result in finished roasts with recognizable pieces of breast and thigh meat;
- 5422.2 not intermingle the breast meat and thigh meat;
- 5422.3 result in a lengthwise layering effect of the breast meat and thigh meat throughout the length of the finished roast;
- 5422.4 not interfere with the uniform distribution and the appearance of the skin covering; and
- 5422.5 be approved by **the LP Program**.
- 5422.5.1 Approval **shall** 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 **QAD, LP Program, USDA/AMS**.

5423 Hand Forming or Stuffing Fabrication Process:

5423.1 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. 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.

5430 Skin Coverage – Except for roasts that are packaged in an oven-ready container, for all other roasts, at least 50 percent of the outer surface of the roasts shall be covered with skin and uniformly distributed over the outer surface of the roast.

5431 Skin covering may overlap without limit in all areas provided:

5431.1 the fatty tissue has been removed from the sternal and pectoral feather tracts;

5431.2 the percentage of the skin does not exceed the maximum amount listed in the formula, and

5431.3 the areas are smooth in appearance.

5431.4 When fat is not removed from the sternal and pectoral feather tracts, no overlapping is permitted in these particular areas.

5431.5 Skin cannot be used in the interior of the roasts.

5500 Netting – After assembling, the formed roast shall be enclosed in an elasticized netting.

5510 Roasts shall be fabricated, netted, packaged, and packed so they retain their unfrozen and netted shape after cooking, and each slice can be served with minimal separation.

5600 Roast Weight, Length, and Diameter Requirements

5610 Unfrozen packaged roasts shall comply with the following size requirements:

5610.1 Turkey Roast (100125) – Each roast shall weigh between 8 to 12 pounds; and

5610.1.1 Measure between 9 to 17 inches in length and between 4 to 7 inches in diameter.

5610.2 Turkey Roast (111000) – Each roast shall weigh between 4 to 6 pounds; and

5610.2.1 No length or diameter requirements.

5700 Examination for Fabrication Requirements and Defects

- 5710 Three packaged roasts shall be sampled and examined for compliance with the fabrication defects (requirements for meat and skin percentages) as shown in Table 2. The frequency of sampling and number of defects allowed in a sample shall be those outlined in LP Program's SPL-2.
- 5710.1 Sample roasts with more fabrication defects than the maximum tolerance for the sample plan shall result in the rejection of the product the samples represent.
- 5710.2 USDA may select additional samples of packaged roasts to examine for compliance with fabrication requirements prior to shipment or at destination.
- 5720 Defects Examination – Packaged roasts shall 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.
- 5720.1 Three roasts shall be examined for the defects shown in Table 2. The number of defects allowed shall be as outlined in the LP Program's SPL-2.
- 5720.2 If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents shall be rejected.
- 5800 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.
- 5801 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.
- 5802 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.
- 5900 Ready-to-Cook Roasts for Further Processing – Roasts may be delivered within the plant 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 shall be netted and delivered on a lot or sub-lot basis in the chilled state (at an internal product temperature between 26 °F (-3.3 °C) and 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 shall be under procedures approved by QAD.

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, must not impart objectionable odors or flavors to the commodity, shall be safe (cannot adulterate product or be injurious to health) for use in contact with food products, 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)).
- 621 **Consumer Pack Whole Turkey (100123)** – Each turkey shall 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 shall be removed from the bag, and the bag shall be sealed and shrunk so that it snugly adheres to the turkey.
- 622 **Bulk Pack Turkey (100124)**
- 622.1 **Chilled turkey carcasses shall be:**
- 622.1.1 packed in wax-coated fiberboard containers with a commercial cooling medium,
- 622.1.2 packed in covered combo bins as loose chilled pack, or
- 622.1.3 packaged in plastic-film bags and packed in fiberboard shipping containers.
- 622.2 **Frozen turkey carcasses shall be either:**
- 622.2.1 packaged in plastic-film bags or packed in containers lined with plastic-film bags, or
- 622.2.2 packed in fiberboard containers or commercial bulk containers.
- 622.2.3 **Plastic-film Bags for Bulk Pack Turkey (100124)** – Shall 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 shall be closed by commercial methods and materials.
- 623 **Turkey Roasts (100125 and 111000)** – After netting, a mechanically formed roast shall be packaged in a casing and a hand-stuffed roast shall be packaged in a plastic-film bag, casing, or heat-shrinkable plastic-film bag. The casings and bags shall 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 shall protect the commodity from dehydration,

freezer burn, quality deterioration, or contamination during the conditions of use.

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

623.2 Commercial oven-ready containers for the roasts may be used instead of casings or plastic-film bags.

630 Packing

631 Consumer Pack Whole Turkey (100123) – Packaged turkeys shall be packed into shipping containers with:

631.1 not more than four turkeys weighing up to 14 pounds per container; or

631.2 not more than two turkeys weighing over 14 pounds per container.

631.3 The difference between individual carcass weights per container shall be no more than 2 pounds. The 2-pound increments shall be: 12-14, 14-16, 16-18, 18-20, or 20-22 pounds.

631.3.1 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 weight range shall contain turkeys weighing 12-14 pounds only.

632 Turkey Roasts (100125) – Four packaged roasts shall be packed in each shipping container.

633 Turkey Roasts (111000) – Eight packaged roasts shall be packed in each shipping container.

640 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 acceptable 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 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.
- 650 Bulk Pack [Turkey \(100124\)](#) Containers
- 651 Commercial fiberboard shipping containers used for bulk pack turkeys **shall** be closed by commercial methods and materials.
- 700 LABELING**
- 710 [Turkey Roasts \(100125\)](#) – 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 Commercial labeling or USDA labeling **shall** be used **for all Turkey and Turkey Products except Turkey Roasts (111000)**. When commercial or USDA labeling is selected, both the **individual** packages and shipping containers within a purchase unit **shall** be labeled in that format. The contractor **shall** use the same label format (**either** commercial or USDA) within a purchase unit.
- 721 [Turkey Roasts \(111000\)](#) – **Only commercial labeling shall be used and each individual package and shipping container shall be commercially labeled.**
- 730 Commercial Labeling Requirements
- 731 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.
- 732 Commercial Labels **shall** be the processor's own commercial label.
- 733 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).

734 USDA Grademark – In addition to the FSIS commercial labeling requirements, the USDA grademark shall be shown on each shipping container of consumer pack graded commodity. If individual packages are commercially labeled, the USDA grademark shall be printed on each package.

735 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>

740 USDA Labeling Requirements

741 When USDA labeling is used, any deviation from the 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.

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

743 USDA Labeled Packaged

743.1 Plant number, production date, and net weight on each package. The following information shall be legibly preprinted, stamped, stenciled, or a label 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:

743.2.1 the USDA-assigned plant number;

743.2.2 date of production (month, day, and year); and

743.2.3 the net weight shall be shown, except for in-plant delivery where the turkey roasts (100125) are delivered without packaging in casings or bags.

- 744 Additional Labeling Requirements – There **shall** be no other labeling of the packaging materials.
- 745 USDA Labeled Shipping Containers
- 745.1 Labeling and Marking Information **shall** 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**.
- 745.2 Qualifying Statement (as applicable) – For consumer pack basted commodity, the asterisks (*) **shall** appear on each shipping container (as shown in **Exhibit 3**) beside the commodity name and qualifying statement.
- 745.3 The USDA grademark **shall** be shown on the “one end” designated panel of each shipping container of commodity.
- 745.4 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>
- 746 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 **shall** not cover or conflict with the labeling requirements of this FPPS.
- 750 Universal Product Code (UPC)
- 751 The UPC symbol and code, called Interleaved 2 of 5 (I 2/5), **shall** appear on 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 GS1 US, 1009 Lenox Drive, Suite 202, Lawrenceville, **New Jersey** 08648, (609) 620-0200.
- 751.1 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 **Consumer Pack Whole Turkey (100123)**

and Turkey Roasts (100125 and 111000) purchased under this FPPS. The contractors need not join GS1.

- 751.2 The 14-digit UPC code for shipping containers is:
 - 751.2.1 Consumer Pack Whole Turkey (100123) –1 07 15001 00123 5.
 - 751.2.2 Turkey Roasts (100125) – 1 07 15001 00125 9.
- 751.3 The UPC code shall be placed in the lower right-hand corner of the principal display panel of each shipping container.
- 752 Bulk Pack Turkey (100124) – USDA-assigned plant number, type and name of the product, date of production, and net weight of the product shall be shown on each container or bin.
 - 752.1 In-Plant Deliveries – When in-plant delivery is made the contractor shall label and mark the end product(s) according to the requirements of the State distributing agency.
- 753 Shipping containers or labels with incorrect contract number, plant number, date packed, USDA Grade, name of product, ingredients statement, net weight, allergen statement, or nutrition facts information or label shall be corrected before they are used. The incorrect information shall 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 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 LP Program, 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 overseas destination's 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, 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 Each delivery unit shall be examined for compliance with the net weight requirements at time of checkloading.
- 841 Net weight for Consumer Pack Whole Turkey (100123), Turkey Roasts (100125 and 111000), and frozen Bulk Pack Turkey (100124) shall be determined at origin, and for chilled Bulk Pack Turkey (100124), at the destination specified in the contract. The net weight of each delivery unit shall be determined an AMS Grader at the contractor’s expense.
- 841.1 As an alternative to test weighing at time of checkloading, the contractor may request on-line verification of net weights for Consumer Pack Whole Turkeys (100123) and Turkey Roasts (100125 and 111000). Upon receiving the request, a Federal-State supervisor (or his/her designee) shall determine that the facilities and procedures are in accordance with applicable LP Program’s instructions for this FPPS.
- 842 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.
- 843 A representative sample shall 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

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

- 843.1 For large bulk containers (combo bins, tanks, etc.), the representative sample size shall be reduced by one-half the amount listed.
- 844 Consumer Pack [Whole Turkey \(100123\)](#) – A purchase unit shall total 38,000 pounds net weight, or multiples thereof.
- 844.1 A weight variation of minus 1 percent ([37,620 pounds](#)) is permitted on each delivery unit. USDA shall pay [only](#) for the amount of commodity delivered within the required weight range.
- 845 [Turkey Roasts \(100125 and 111000\)](#) – A purchase unit shall total 40,000 pounds net weight, or multiples thereof.
- 845.1 A weight variation of minus 1 percent ([39,600 pounds](#)) is permitted on each delivery unit. USDA shall pay [only](#) for the amount of commodity delivered within the required weight range.
- 846 Each delivery unit of [Consumer Pack Whole Turkey \(100123\)](#) shall contain all basted or all non-basted birds. Non-basted product shall not have solutions or ingredients added.
- 846.1 The net weight per carcass within individual shipping containers shall not vary more than an increment of 2 pounds. The 2-pound increments shall be: 12-14, 14-16, 16-18, 18-20, or 20-22 pounds.
- 846.1.1 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 weight ranges, it may not contain turkeys smaller than 14 pounds or larger than 18 pounds.
- 847 Bulk Pack [Turkey \(100124\)](#) – A purchase unit of bulk pack turkeys shall total 36,000 pounds net weight, or multiples thereof. Less than 36,000 pounds shall be rejected. Containers used to ship bulk pack shall be uniform in both type and size in each delivery unit. Bulk pack shall be delivered chilled, [however delivered frozen may be specified in](#) the applicable Solicitation.
- 850 Loading and Shipping Frozen Commodity
- 851 Visual Inspection – Frozen [commodity](#) shall be a uniform light and bright color. Moisture (ice) present in a packaged roast or consumer packaged turkey shall not

exceed occasional small areas showing a thin layer of clear or pinkish-colored ice.

- 851.1 Frozen commodity showing evidence of purge beyond the tolerance; or defrosting, 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 LP 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 regulatory requirements, and this FPPS, at the 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 **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 3932-S, STOP 0258, 1400 Independence Avenue, SW, Washington, D.C. 20250-0258, telephone (202) 720-3271.**
- 862.1 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 – 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 In-Plant Deliveries – When an in-plant delivery is made, the contractor shall notify the appropriate resident AMS Grader and furnish applicable information.

- 1040.1 Bulk Pack Turkey (100124) – Up to three sublots per purchase unit is permitted when the contractor harvests 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 shall be done in accordance with procedures established by LP Program.
- 1040.2 Turkey Roasts (100125) – May be delivered in unfrozen form without casings or bags or without being packaged in containers for further processing. Such deliveries shall be discounted, against the contractor's account, by 3.5 cents per pound.
- 1040.3 Delivery In Storage – The destination in the Sales Order/Item number and the place the contractor has the commodity in storage shall be the same. Inspection and certification by an AMS Grader is required for transfers in storage.
- 1050 Split Deliveries
- 1051 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 examinations 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
- 1130.1 Chilled bulk pack turkey shall arrive at destination at an internal product temperature between 26 °F (-3.3 °C) and 40 °F (4.4 °C).
- 1130.2 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).
- 1130.3 Commodity not meeting this requirement shall be rejected for use under this FPPS.

1200 PRODUCT ASSURANCE AND COMPLAINT RESOLUTION

1210 Product Assurance – 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.

1211 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>

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.

Commodities – Summary Table

	a. Consumer Pack	b. Bulk Pack	c. Roasts
Type:	Frozen	Chilled or Frozen	Frozen
Class:	Young	Young	Prepared from breast meat, thigh meat, and skin of young ready-to-cook turkeys
Style:	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
Neck and Giblets:	Without neck and giblets	Without neck and giblets	N/A
Weight Range:	12 to 22 lbs. per whole, ready-to-cook carcass weighed without neck and giblets	18 to 32 lbs., weighed without neck and giblets	111000 – 4 to 6 lbs. 100125 – 8 to 12 lbs.
U.S. Grade:	U.S. Grade A	U.S. Grade B or better	U.S. Grade A

Table 1. Meat and Skin Defects

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

Table 2. Defects for Finished Roasts

	Defect
Fabrication:	<p>A fabrication defect for a finished roast is when:</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 requirements in this FPPS.</p>
Size:	<p>A size defect for a finished roast is when the roast:</p> <p>100125 – Weighs less than 8 pounds or more than 12 pounds;</p> <p>Measures less than 9 inches or more than 17 inches in length; or</p> <p>Measures less than 4 inches or more than 7 inches in diameter.</p> <p>111000 – Weighs less than 4 pounds or more than 6 pounds.</p>
Skin Coverage:	<p>Less than 50 percent of the outer surface of the roast is covered with skin, or when the skin or skin coverage does not comply with requirements in this FPPS. Does not apply to roasts packaged in oven-ready containers.</p>
Exterior:	<p>Three or more feathers greater than 0.75 inches in length.</p> <p>Any moderate discolorations.</p> <p>Lightly shaded discoloration on the skin or meat exceeding an area equivalent to the area of a circle having a diameter of 1.50 inches.</p>

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 **shall** be legibly preprinted, stamped, stenciled, or printed on a separate self-adhesive label and applied to containers. The USDA symbol, EXHIBIT 5, 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 **shall** be preprinted or applied as a separate self-adhesive label on each package or shipping container.

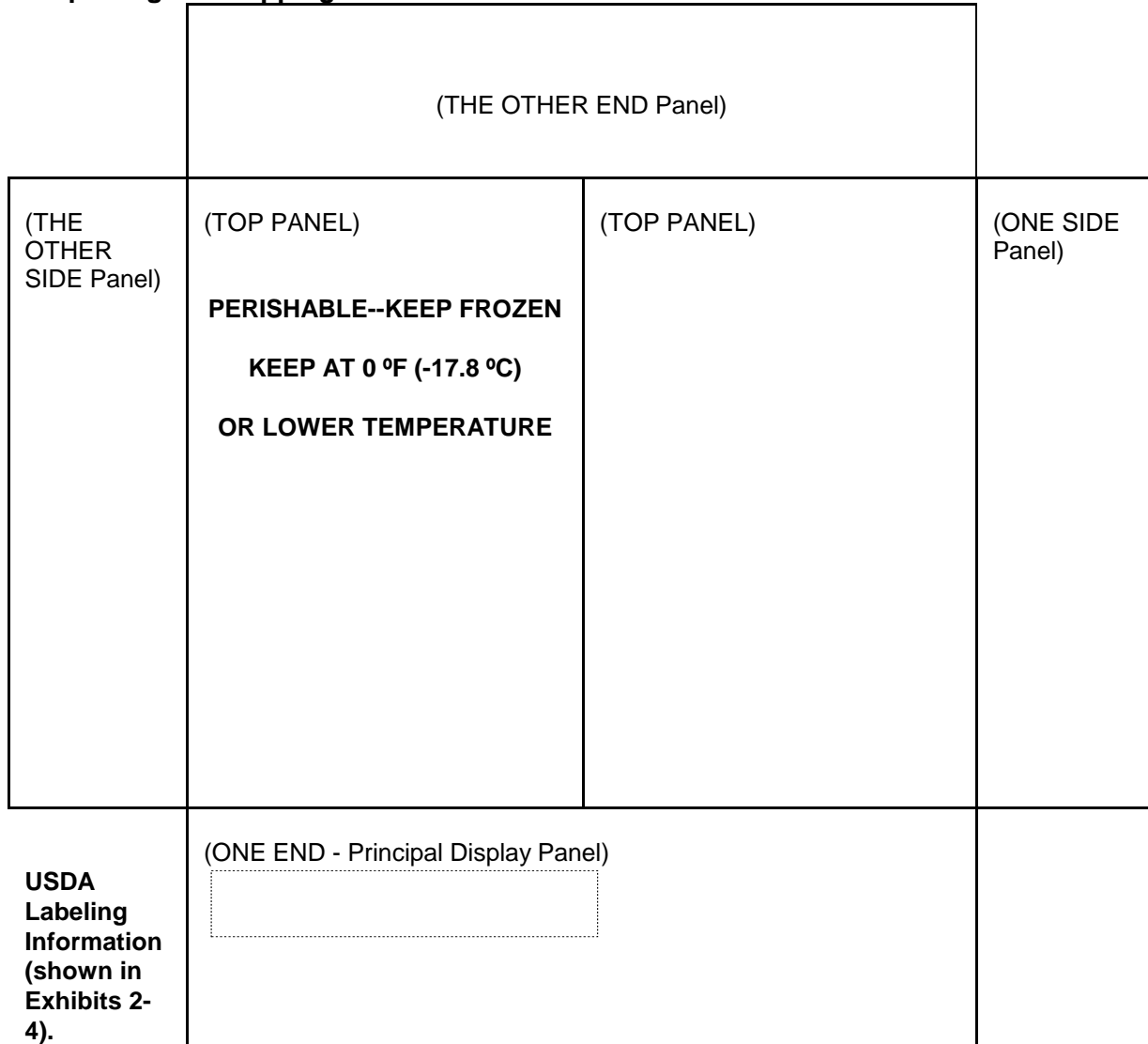


EXHIBIT 2
USDA Label Information for Turkey Roasts

Marking Information: USDA labeling information **shall** be printed on the principal display panel of each shipping container as provided in Exhibit 1. Markings **shall** 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, **shall** be shown in the lower right-hand corner of the principal display panel. The USDA symbol, EXHIBIT 5, **shall** 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 **shall** 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
Shall be placed here)

Processor's
Name, Address, and Phone

Required
Nutrition Facts Label
Shall Be Placed Here

Safe Handling Instructions
Shall 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 **shall** be printed on the principal display panel of each shipping container as provided in Exhibit 1. Markings **shall** 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, **shall** be shown in the lower right-hand corner of the principal display panel. The USDA symbol, EXHIBIT 5, **shall** 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 **shall** 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
Shall be placed here)

Processor's
Name, Address, and Phone

Required
Nutrition Facts Label
Shall Be Placed Here

Safe Handling Instructions
Shall 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 **shall** be printed on the principal display panel of each shipping container as provided in Exhibit 1. Markings **shall** 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, **shall** be shown in the lower right-hand corner of the principal display panel. The USDA symbol, EXHIBIT 5, **shall** 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 **shall** 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
Shall be placed here)

Processor's
Name, Address, and Phone

Required
Nutrition Facts Label
Shall Be Placed Here

Safe Handling Instructions
Shall Be Placed Here.

KEEP FROZEN

Net Weight ___ LBS. (___ KG)

DATE PACKED (Month, Day, and Year)

UPC Symbol and Code

Exhibit 5
USDA SYMBOL

