



**Agricultural
Marketing
Service**

**Livestock and Seed Program
Washington, DC 20250 - 0254**

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**FOR
USDA PURCHASES
OF
COOKED PORK ITEMS**

Effective: April 2005

I. ITEM DESCRIPTION

- Item –
- (1) Pork Taco Filling, Fully Cooked – This item consists of ground pork cooked in lightly seasoned ingredients for use in a variety of applications, including taco fillings, burritos, enchiladas and similar items.
 - (2) Pork Sloppy Joe Mix, Fully Cooked – This item consists of ground pork cooked in seasoned tomato product for use in a variety of applications, including sandwich filling and similar items.
 - (3) Breaded Pork Patties, Fully Cooked – This item consists of ground pork that is formed into round or oval patties, breaded and Individually Quick Frozen (IQF) for use as sandwiches or a stand-alone item. Portion Weight – 3.0 ounces.
 - (4) Pork Sausage Patties, Fully Cooked – This item consists of ground pork with soy protein product (SPP) that is seasoned, formed into round or oval patties, fully cooked, and then IQF for use as sandwiches or a stand-alone item. Portion Weight – 2.7 ounces.
 - (5) Pork Sausage Breakfast Patties, Fully Cooked – This item consists of ground pork with SPP that is seasoned, formed into round or oval patties, fully cooked, and then IQF for use as sandwiches or a stand-alone item. Portion Weight – 1.2 ounce.
 - (6) Pork Sausage Breakfast Links, Skinless, Fully Cooked – This item consists of ground pork with SPP that is seasoned, processed into skinless links cylindrical in shape, fully cooked, and then IQF for use as a stand-alone item. Portion Weight - 1.0 ounce.
 - (7) Pork Sausage Crumbles, Fully Cooked – This item consists of ground pork with SPP that is lightly seasoned and processed to a crumble size of ¼ inch maximum for use in a variety of applications such as chili, sloppy joe, tacos, spaghetti sauce, pizza, lasagna, casseroles, pasta dishes, and any recipe that calls for ground pork.
- Formula - Pork will comprise at least 75% of the raw formula.
- Non-Meat Component – Non-meat components will comprise no more than 25% of the raw formula.
- Fat – Fat will not exceed 15 grams per 100 gram serving.
- Sodium – The sodium content will not exceed 700 milligrams per 100 gram serving.
- Packing – Four (4) 10-pound, five (5) 8-pound, or eight (8) 5-pound primary containers (packages) will be packed in a 40-pound (net weight) shipping container.
- Delivery Unit – Each delivery unit will consist of 1,000 cases and 40,000 pounds except for pork sausage patties and pork sausage breakfast patties which will consist of 950 cases and 38,000 pounds.

II. CHECKLIST OF REQUIREMENTS

All items must be produced in accordance with Food Safety and Inspection Service (FSIS) regulations and the checklist of requirements.

A. MATERIALS

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

1. MEAT COMPONENT

Pork will be the only meat component allowed.

- a) Domestic Origin of Meat Component – All hogs will originate from U.S. produced livestock as defined in this announcement.
- b) Harvesting (Slaughtering) – Hogs will be harvested in facilities that comply with the following requirements:
 - (1) Humane Handling – All hogs will be humanely handled in accordance with all applicable FSIS regulations, directives, and notices.
 - (2) Non-Ambulatory Disabled Hogs – Meat from carcasses of non-ambulatory disabled hogs will not be included in USDA purchased cooked pork items.
- c) Boneless Pork – Boneless pork will comply with the following requirements:
 - (1) Traceability – Contractors are responsible for providing sufficient product traceability and must have records to verify the source of raw materials used in each lot of product.
 - (2) Handling – All boneless pork must be maintained in excellent condition. The contractor's technical proposal shall include detailed production scheduling that addresses time and temperature controls necessary to maintain excellent condition of the boneless pork. Frozen boneless pork may be used provided it is processed into the final product within 60 days from the date of pack.
 - (3) Objectionable Materials – Boneless pork shall be free of skin, bones, cartilages, organ tissue, heavy connective tissue, lymph glands, spinal cord, and foreign materials.
- d) Mechanical Separation – Meat that is mechanically separated from bone with automatic deboning systems, advanced lean (meat) recovery (AMR) systems, or powered knives will not be allowed.

2. NON-MEAT COMPONENTS

- a) Domestic Origin of Non-Meat Component – Significant ingredients (more than 1 percent) will be derived from U.S. produced products.
- b) Seasoning and Ingredient – Seasonings and other ingredients will be used to produce products with mild flavor profiles suitable for institutional feeding systems. For crumbles and patties, seasonings and other ingredients will comprise no more than 2% of the raw formula.

- c) MSG – Monosodium Glutamate (MSG) is not allowed.
- d) Soy Protein Product (SPP) – Pork Sausage Patties, Pork Sausage Links, and Pork Sausage Crumbles must contain SPP in the raw formula that meets the following requirements:
 - (1) The SPP will be hydrated to yield no less than 18% protein (as is basis).
 - (2) The physical characteristics of SPP, in the dry form, must be either granular or textured. The types of soy that may be used are soy concentrate or isolate (65% and 85% as is basis).
- e) Batter and Breading – For Breaded Pork Patties, Only – If flour is used in the batter and breading combination, it must be enriched.

B. PROCESSING

1. GRINDER PLATE

The size of the grinding plate for grinding boneless pork will be declared.

2. BONE COLLECTOR / EXTRUDER SYSTEM

A bone collector/extruder system must be in operation to effectively remove skin, bone, cartilage, and heavy connective tissue during the final grind.

3. PATTIES

- a) Raw Weight – The raw weight of the patties will be declared and charted on control charts featuring average weight and range.
- b) IQF – Patties will be IQF so the individual pieces do not stick together after they are packaged and packed.
- c) Pink Appearance – Patties with pink appearance after cooking will not be allowed.
- d) Shape – Patties will be round or oval shape.

4. LINKS

- a) Skinless – Casing must be removed.
- b) Weight - Target packaged weight per cooked link will be 1.0 ounce. The raw weight of links shall be declared. All weights will be charted on control charts featuring average weight and range.
- c) IQF – Links will be IQF so individual links do not stick together after they are packaged.
- d) Pink Appearance – Links with pink appearance after cooking will not be allowed.

5. CRUMBLES

- a) Size – The size of the crumbles will be no larger than ¼ inch.
- b) IQF – The crumbles will be IQF or may be produced from IQF's materials to prevent it from sticking together after freezing.

c) Flavor – Crumbles must not have a scorched flavor.

6. COOKING TEMPERATURE

All products will be fully cooked in accordance with FSIS regulations.

7. METAL DETECTION

All products will be free of metal contaminants. 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 described.

C. FINISHED PRODUCT LIMITATION

The declared fat and sodium content will be stated on the nutrition facts panel on each label according to FSIS required “referenced amounts customarily consumed” (racc) regulations.

1. FAT

The fat content of the finished product will not exceed 15 percent
(Percent Fat = (Total Fat ÷ Serving Size) x 100).

2. SODIUM

Sodium level, as declared on the nutritional label, must not exceed 700 mg per 100 g serving ((Declared Sodium Level (mg) X 100) ÷ Declared Serving Size (grams - racc*) ≤ 700)).

3. MICROBIAL

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

D. COOKING INSTRUCTIONS AND SERVING SIZE

1. COOKING INSTRUCTIONS

Cooking instructions for the end-user will be provided in the offeror’s technical proposal and must be included in the shipping container, i.e. flyer. The pork links and patties will be prepared so that the end-user may bake them in a conventional or convection type oven.

2. SERVING SIZE

The serving size shall be declared on the nutritional facts panel in accordance with FSIS “referenced amounts customarily consumed” (racc) regulations and requirements.

E. PREPARATION FOR DELIVERY**1. PACKAGING AND PACKING**

- a) Packaging – Patties will be either vacuum packaged or packed in a sealed (tamper proof) package. Pork taco fillings and sloppy joe mix will be hot-filled into reheatable high oxygen and high moisture barrier pouches.
- b) Packing – Four (4) 10-pound, five (5) 8-pound, or eight (8) 5-pound primary containers (packages) will be packed in a 40-pound (net weight) shipping container.

2. LABELING

The shipping containers will be in compliance with the National Motor Freight Classification, or the Uniform Freight Classification, as applicable.

- a) Primary Container Labels – Primary container labels will contain the following information:
 - (1) A “Best-If-Used-By” date.
 - (2) A nutrition facts panel based on actual nutritional analysis of the product.
 - (3) A traceability code that is traced back to establishment number, production lot, and date.
- b) Shipping Container Labels – Shipping container labels will contain the following information:
 - (1) USDA shield at least 2 inches high and appearing on the top of the container or on the principle display panel.
 - (2) Applicable contract number.
 - (3) A traceability code that is traced back to establishment number, production lot, and date.
 - (4) A nutrition facts panel based on actual nutritional analysis of the product.
 - (5) The appropriate product code listed in the table below for each of the items.



Product Code	
Item	Code
Pork Taco Filling, Fully Cooked	A680
Breaded Pork Patties, Fully Cooked	A692
Pork Sloppy Joe Mix, Fully Cooked	A691
Pork Sausage Patties, Fully Cooked, 2.7 ounce	A707
Pork Sausage Breakfast Patties, Fully Cooked, 1.2 ounce	A708
Pork Sausage Links, Skinless, Fully Cooked, 1.0 ounce	A719
Pork Sausage Crumbles, Fully Cooked	A720

All labeling illustrations must be provided.

3. CLOSURE

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

4. PALLETIZED UNIT LOADS

All products will be stacked on new or well-maintained pallets and palletized with shrink wrap plastic.

F. DELIVERY UNIT

Each delivery unit will consist of 1,000 cases and 40,000 pounds except for pork sausage patties and pork sausage breakfast patties which will consist of 950 cases and 38,000 pounds.

G. DELIVERED PRODUCT**1. SIZE AND STYLE OF CONTAINER**

Only one size and style of primary (bags) and shipping containers may be offered in an individual shipping unit.

2. TEMPERATURE

All products will not exceed 0° F at the time of shipment and delivery.

3. SEALING

All products must be delivered to AMS destinations under seal.

H. WARRANTY AND COMPLAINT RESOLUTION**1. WARRANTY**

The contractor will guarantee that the product complies with all contractual requirements.

2. COMPLAINT RESOLUTION

The contractor's technical proposal must provide the 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.

I. NON-CONFORMING PRODUCT

The contractor must include a plan to assure that non-conforming product is not delivered under USDA contracts. The plan must address 1) control and segregation of non-conforming product, 2) removal of any USDA markings, and 3) disposition of non-conforming product.