



**Agricultural
Marketing
Service**

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

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**FOR
USDA PURCHASES
OF
PORK LEG (FRESH HAM) ROASTS,
BONELESS, TRIMMED, FROZEN
AND
PORK SHOULDER, PICNICS,
BONELESS, FROZEN**

Effective: April 2005

I. ITEM DESCRIPTION

- Items –
- (1) Pork Leg (Fresh Ham) Roasts, Boneless, Frozen – This item consists of a boneless ham with the shank removed and divided into approximately two equal roasts which are netted and vacuum packaged.
 - (2) Pork Shoulder, Picnics, Boneless, Frozen – This item consists of a boneless picnic bulk packaged in leak-proof shipping containers.

II. CHECKLIST OF REQUIREMENTS

These pork items must be produced under Food Safety and Inspection Service (FSIS) regulations and this checklist of requirements.

A. ITEMS

Contractors must describe the necessary processing steps with pictures to comply with the items below.

1. PORK LEG (FRESH HAM) ROASTS, BONELESS, FROZEN

This item is a netted boneless pork leg with all shank meat (inner shank (*gastrocnemius* and *flexor digitorum superficialis*) and outer shank) excluded. In addition, all bones, cartilages, skin, flank muscle (*rectus abdominus*), *cutaneous trunci*, fat and lean above the aitch bone and exposed lymph glands shall be excluded. The item will be trimmed practically free of surface fat and star fat. Also, the boneless item will be divided into two approximate equal portions (roasts) by a cut perpendicular to the longest dimension of the netted roast.

2. PORK SHOULDER, PICNICS, BONELESS, FROZEN

This item is a boneless pork picnic with the cushion (*triceps brachii group*) attached. In addition, all bones, cartilage, and skin shall be excluded.

B. MATERIALS

1. MEAT COMPONENT

Pork will be the only meat component allowed.

- a. Domestic Origin Of Meat Component – Pork must 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 shall be humanely handled in accordance with all applicable FSIS regulations, directives, and notices.
 - (2) Non-Ambulatory Hogs – Meat from carcasses of non-ambulatory hogs will not be included in USDA purchased boneless pork product.

- 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 production lot.
 - (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.
 - (3) Lean Quality – Fresh-chilled pork must be reasonably uniform in color (slightly two tone color is permissible) ranging from light pink to light red. The pork muscles must not exhibit any evidence of pale, soft, and/or exudative conditions.
- d. Fresh-Chilled Pork – Only fresh-chilled pork which has never been previously frozen will be allowed.
- e. Mechanically Separated – Pork that is mechanically separated from bone with automatic deboning systems or advanced meat (lean) recovery (AMR) systems is not allowed.

2. NON-MEAT COMPONENTS

Non-meat components such as bones, cartilages, skin, spinal cord, organ tissue, and foreign material are not allowed.

3. FAT LIMITATIONS

- a. Pork Leg Roasts – The pork leg roasts will be trimmed so they are practically free of surface and star fat. There shall be at least 75% lean/seam surface exposed and the remaining fat shall not exceed $\frac{1}{8}$ inch (3 mm) in thickness at any one point.
- b. Pork Shoulder Picnics – The maximum average fat thickness for pork shoulder picnics shall be $\frac{1}{4}$ inch (6 mm) and the maximum fat thickness at any one point shall be $\frac{1}{2}$ inch (13 mm) or less.

4. WEIGHT RANGE

- a. Pork Leg Roasts – Individual pork leg roast will weight 6 – 10 pounds
- b. Pork Shoulder Picnics – A weight range is not required.

5. NETTING AND TYING

- a. Pork Leg Roasts – Roasts will be netted or tied so that all portions are held intact, without any portions protruding through the ends of the netting to make roasts firm and compact
- b. Pork Shoulder Picnics – Netting and tying is not allowed.

6. STATE OF REFRIGERATION

Product will be frozen to an internal temperature of not higher than 0° F (-17.8°C) within 72 hours from the time of final fabrication of the lot.

C. PREPARATION FOR DELIVERY

The contractor's technical proposal and process will 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.

1. PACKAGING

- a. Pork Leg Roasts – Each leg roast will be vacuum packaged.
- b. Pork Shoulder Picnics – Boneless picnics will be bulk packaged in leak-proof shipping containers.

2. PACKING

- a. Pork Leg Roasts – Vacuum packaged pork leg roasts will be placed into shipping containers to a net weight ranging 36 – 42 pounds. Box liners are not required.
- b. Pork Shoulder Picnics – Boneless picnics will be bulk packaged in leak-proof shipping containers without the use of plastic liner bags to a net weight of 60 pounds.

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. LABELING

Both primary and shipping container labels will be illustrated in the contractor's technical proposal and contain the following information:

- a. Primary Container – Each primary container is required to have a traceability code that is traced back to establishment number, production lot, and date.
- b. Shipping Container – All shipping containers will have 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) Pork leg roasts product code: A672.



(5) Boneless picnics:

- (i) The product code "A632".
- (ii) The words "For Further Processing" will appear on the principle display panel.

D. PALLETIZED UNIT LOADS

All products shall be stacked on new or well-maintained pallets and palletized with shrink wrap plastic, unless otherwise specified in the invitation.

E. DELIVERY UNIT

1. PORK LEG ROASTS

The delivery unit will be 40,000 pounds net weight (plus or minus 30 pounds).

2. PORK SHOULDER PICNICS

The delivery unit will be 40,020 pounds net weight (667 shipping containers).

F. DELIVERED PRODUCT

1. SIZE AND STYLE OF CONTAINER

Only one size and style of primary and shipping container may be used in any one delivery unit.

2. TEMPERATURE

Product temperature will not exceed 0° F at the time of shipment and delivery.

3. SEALING

All products must be delivered to AMS destinations under seal (metal or plastic seal, lock, etc.).

G. 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.

H. 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.