Commodity Specification

SMOKED TURKEY HAM

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I. GENERAL

A. Product Description

Frozen, fully cooked, smoked turkey hams (hams/commodity) produced under this Specification will be packaged and packed in the following forms as specified in the contract:

Smoked Turkey Ham (234040) - Frozen fully cooked smoked turkey hams produced from non-basted, young ready-to-cook turkey thigh meat. Four approximately10-pound (4.54 kg) hams must be vacuum packaged in shrinkable oxygen and moisture-proof bags or casings, and packed in a fiberboard shipping container to net a weight of 40 pounds (18.16 kg). A purchase unit will total 40,000 pounds (18,165 kg).

Smoked Turkey Ham (Small Pack) (234140) - Frozen fully cooked smoked turkey hams produced from non-basted, young ready-to-cook turkey thigh meat. Twenty approximately 2-pound (0.91 kg) hams must be vacuum packaged in shrinkable oxygen and moisture-proof bags or casings and packed in a fiberboard shipping container to a net weight of 40 pounds (18.16 kg). A purchase unit will total 40,000 pounds (18,165 kg).

B. Food Defense Requirements

Contractors and subcontractors participating in the commodity purchase program must have a documented food defense plan that provides for the security of a plant's production processes and includes the storage and transportation of finished product after production. The plan shall address the following areas: (1) food defense plan management; (2) outside and inside security of the production and storage facilities; (3) slaughter and processing, including all raw material sources; (4) shipping and receiving; (5) storage; (6) water and ice supply; (7) mail handling; (8) personnel security; and (9) controlled access to production and storage areas. The food defense plan shall be made available to the Department of Agriculture's (USDA) Agricultural Marketing Service (AMS) Auditor immediately upon request. Verification of the Food Defense Program at the processing, storage, and distribution facility will be conducted by the USDA, AMS Auditor.

C. Commodity Complaints

The contractor/producer must immediately report all complaints received on the commodity to the USDA Contracting Officer.

D. Humane Handling

All poultry shall be humanely handled in accordance with all applicable USDA, Food Safety and Inspection Service (FSIS) regulations, directives, and notices.

II. COMMODITY SPECIFICATION

A. Basic Requirements

1. Date Processed. The commodity must not be processed more than 90 calendar days prior to the first date of the delivery period.

2. Origin of Turkeys. The commodity must be produced and processed from young turkeys which were produced, raised, and processed in the United States, its territories or possessions, the Commonwealth of Puerto Rico, or the Trust Territories of the Pacific Islands. If the contractor processes or handles turkey carcasses and parts originating from sources other than the United States, its territories or possessions, Puerto Rico, or the Trust Territories of the Pacific Islands, the contractor must have an acceptable identification and segregation plan for those turkey carcasses and parts to ensure they are not used in the commodities produced under this Specification. This plan must be made available to a representative of the Grading Branch, Poultry Programs, AMS, USDA (Grader), and the Contracting Officer or agent thereof upon request. The contractor must ensure that both the contractor and subcontractor(s) maintain records such as invoices, or production and inventory records evidencing product origin, and make such records available for review by the Grader or other Government official(s).

3. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 CFR § 381) and be under the supervision of a representative of USDA's FSIS (Inspector). Inspection for contract and Specification compliance will 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 (AMS 70.200 *et seq.*) under the supervision of a Grader. The Grader will be responsible for certification of compliance with the requirements of this Specification for ready-to-cook turkey carcasses and parts; preparation, formulation, and fabrication of turkey hams; smoking, cooking, and cooling turkey hams; packaging and packing; freezing; labeling and marking; sampling; net weight; and checkloading.

4. FSIS Requirements. The commodity must be produced and processed in an FSIS federally inspected establishment, be accurately marked and/or labeled, and meet all FSIS regulatory requirements, including all microbiological testing requirements, currently in place.

5. USDA Sampling Option. USDA may select additional product for further inspection or may draw samples for laboratory analyses.

6. Definition of a Lot. A lot is the amount of packaged commodity produced during a processing shift.

B. Meat and Skin

1. Sources of Meat.

a. Smoked turkey hams must be produced from boneless skinless turkey thigh meat. Thigh meat (meat) must be from non-basted, young ready-to-cook turkeys (no solution or

ingredients added) (AMS § 70.202). The chilled turkey thighs must be deboned and used in the turkey ham within 7 calendar days after the date of slaughter.

b. Chilled thighs from frozen turkeys may be used when the frozen turkeys: (1) have been packaged to protect them from freezer burn and dehydration during storage, and (2) have not been held more than 180 days in frozen (0 °F (-17.8 °C)) storage and have been identified so the class of turkey can be determined. The resultant boneless skinless thighs must be processed (without refreezing) into the hams within 48 hours from the time of deboning.

c. Frozen thighs may be used when: (1) produced from freshly slaughtered turkeys, (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 (3) held not more than 180 days in frozen (0 °F (-17.8 °C)) storage. After thawing, the thighs must be used in the production of turkey hams within 48 hours.

d. 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 (II.C.4.).

2. Turkey from Other Plants. Turkeys, turkey thighs, and boneless skinless turkey thighs may be transferred or obtained from other processing plants to produce hams, provided they: (a) have been processed, handled, and identified in accordance with this Specification, and (b) comply with the organoleptic, non-basted, and other applicable requirements for turkey carcasses and parts to be used in hams as evidenced by USDA certification.

a. Type, class, and specific name of the product; part or boneless part; date slaughtered, or date placed in frozen storage, as applicable; and the USDA-assigned plant number must be shown on each shipping container.

b. The chilled and/or frozen turkey carcasses and parts must be at an internal product temperature not higher than 40 °F (4.4 °C) when shipped from the origin plant and when received at the destination plant.

3. Requirements for Meat and Skin.

a. Meat. The meat used to produce smoked turkey hams must comply with the following:

(1) Thighs. Meat must be derived from boneless skinless turkey thighs. Thighs must be in recognizable portions; that is, complete thighs, or thighs with no more than one-half of the meat missing.

(2) Optional - thigh trimmings. As an optional ingredient, 15 percent of the meat portion of the formula may be turkey thigh trimmings as provided in II.B.1.d.

b. Unacceptable meat. Mechanically separated turkey (comminuted) cannot be used.

c. Skin. All skin must be removed from each thigh.

d. Maximum temperature. The temperature of the meat must not exceed 55 °F (12.8 °C) at any time during preparation or processing into turkey ham.

e. Cooling requirements. Boneless skinless thighs and thigh trimmings, which are not used in the turkey ham on a continuous basis, must be cooled by cooling methods/media that ensure that the internal product temperature is continuously lowered to 40 °F (4.4 °C) or lower.

f. Cooling medium.

(1) Cooling methods and media (e.g., liquid carbon dioxide (CO_2), dry ice or liquid nitrogen (N_2)) may be used to maintain the temperature of meat.

(2) Containers of boneless skinless thighs and thigh meat must not contain added water (e.g., water from ice or slush ice and water). Liquid associated with normal product purge is acceptable.

g. Organoleptic requirements. Boneless skinless thighs and thigh trim will be examined on a continuous basis for organoleptic requirements shown in Table 1. Any product that does not comply with the organoleptic requirements will be rejected for use under this Specification.

h. Meat defects. Boneless skinless thighs and thigh trim will be examined for defects on a sampling interval basis.

(1) A sample of 30 pieces of boneless skinless thighs and 2 pounds (0.91 kg) of thigh trim (as applicable) will 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 will be those outlined in the Poultry Programs' Sample Plan Level 1 (SPL-1) for boneless thighs; and Sample Plan Level 2 (SPL-2) for thigh trim. Separate examinations will be made for: (a) bone and (b) other defects.

(2) Thigh trim that is size-reduced using equipment described in II.C.1.b.(2), shall be examined for bone, bone-like material, cartilage (gristle), cartilage-like material, or hard tendons or tendinous material after size reduction only. Regardless of the size-reduction system used, thigh trim will be examined for skin, blood clots, and discolorations prior to size reduction.

(3) Regardless of the kind and number of defects (within Table 1) found, any sample with bone or bone-like material greater than 0.40 inch (1.02 cm) will be cause for the rejection of the product the sample represents.

(4) If the number of bone defects exceed the maximum for the "target" level, or results in a rejection, the frequency of sampling for bone defects will be increased to 30 pieces of boneless skinless thighs and/or 2 pounds (0.91 kg) of thigh trim (as applicable) drawn twice each sampling interval until the cumulative number of bone defects reverts back to the "target" level.

(5) If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

Table 1. Organoleptic Requirements and Defects for Meat

Organoleptic Requirements:	**Meat must not:** (a) be rancid; have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign or off-odors; contain foreign materials (e.g., glass, paper, rubber, metal, plastic); and must have a bright color; and (b) show evidence of mishandling or deterioration; or dehydration or freezer burn or thawing and refreezing.
Boneless Meat and Trim:	**Defects**
Bone:	**Bone or bone-like material** greater than 0.40 inch (1.02 cm). See II.B.3.h.(3).
Discoloration:	**Moderate discolorations** exceeding an area equivalent to the area of a circle with a diameter of 0.50 inch (1.27 cm). **Lightly shaded discolorations** exceeding an area equivalent to the area of a circle with a diameter of 1 inch (2.54 cm). Slight discolorations are permitted, provided the discoloration does not detract from the overall appearance of the meat.
Other:	**Cartilage** (gristle), hard tendons or tendinous material (except as provided in (II.C.1.b.), or blood clots (thigh meat only).
Additional - Pertaining to Trim Meat:	**Blood clots** exceeding an area equivalent to the area of a circle with a diameter of 0.25 inch (0.64 cm).
Boneless Thighs:	**Thigh with** more than one-half of the meat missing.

C. Processing

1. Size Reduction.

a. Thigh meat. Thigh meat must be reduced in size through a plate with openings that are not less than 0.50 inch (1.27 cm) and not greater than 1.00 inch (2.54 cm).

b. Trim meat.

(1) Thigh trimmings must be ground through a plate with holes no less than 0.125 inch (1/8 inch) (3.175 mm) in diameter; or reduced through a desinewer plate or screen with holes 0.0591 inch to 0.0787 inch (1.50 mm to 2 mm) 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.

(2) Additionally, the plate, screen, or equipment must be designed to extract and discharge bone, bone-like material, cartilage, etc., simultaneously with size-reduction. The system must provide a continuous flow of discharge material during size-reduction. The

system must provide a continuous flow of discharge material during size-reduction. The discharge material must not be used in the commodity produced under this Specification.

c. Other methods. The meat may be reduced to an equivalent size by other methods reviewed and found acceptable by supervisory personnel of the Grading Branch, Poultry Programs.

2. Requirements for Size-Reduced Meat.

a. Organoleptic requirements and defects.

(1) Organoleptic requirements. The size-reduced meat and size-reduced trim meat will 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 will be rejected for use under this Specification.

(2) Defects. A 5-pound (2.27-kg) sample of size-reduced meat and a 2-pound (0.91-kg) sample of size-reduced trim meat will be drawn and examined in the fresh state for the defects listed in Table 2 prior to formulation.

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

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

(3) 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 will be rejected for use under this Specification.

b. Temperature requirements. Size-reduced meat or trim which is not used in the turkey ham on a continuous basis, must be cooled by using cooling methods or media (e.g., use of liquid CO_2, dry ice or liquid N_2) that ensure that the internal product temperature is lowered to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C). Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat or trim must 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.

3. Processing Sequence. Unless otherwise specified, the size reduction; formulation; mixing; stuffing, into casings, smoking/cooking, and cooling; packing; and freezing of the

commodity must be a continuous process that complies with the time and temperature requirements of this Specification.

4. Formulation.

a. Smoked turkey ham must be prepared from size-reduced thigh meat (may contain thigh trimmings (up to 15 percent of the meat portion)), water, and the following other ingredients:

	Pounds per 100 lbs. of meat
Other Ingredients:	
Salt (Na Cl)	1.50
Lite Salt (Na Cl+K Cl)	0.50
Sugar	2.00
Sodium Phosphate	0.50
Binder(s) (maximum)	1.00
Sodium or Potassium Lactate/Diacetate (maximum)	2.50
Sodium Erythorbate or Sodium Ascorbate	468.00 PPM
Sodium Nitrite	156.00 PPM

(1) Sugar may be sucrose, brown sugar, dextrose, or a combination thereof.

(2) Sodium or Potassium lactate or diacetate can be used in any combination thereof.

(3) Water and/or ice must be added to assist in the processing of turkey hams. The amount of water/ice and other ingredients must comply with the "12-percent water added" statement for the finished turkey ham. See EXHIBIT 1 for an example of this calculation.

(4) 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 (also see II.C.5.).

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

(6) Verification of compliance with actual percentages of sodium erythorbate or sodium ascorbate and sodium nitrite used will be monitored by FSIS.

(7) The Grader will monitor the "other ingredients" (salt, sodium phosphate, binder, cure, and cure accelerator) formulation requirements. FSIS will monitor compliance with the labeled "12-percent added water" statement.

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

c. Processing aids (e.g., anti-caking agents, anti-dusting agents, or other manufacturing aids) are allowed. If processing agents are used, the ingredients and amount of ingredients listed in the formulation (II.C.4.a.) must remain the same.

d. Formulated batches of ingredients which do not comply with II.C.4.a., b., and c. will be rejected.

5. Mixing. The brine solution must 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 must be thoroughly mixed (by mixing/blending, or tumbling or massaging with or without vacuum) to ensure even distribution of ingredients throughout the batch.

6. Stuffing into Casings.

a. After blending, the formulated batches of ingredients must be stuffed into standard fibrous casings; or smoke impregnated fibrous casings, cook-in-film bags, or plastic moisture-proof casings that are round in shape.

b. Formulated batches of ingredients must be stuffed into casings (pre-smoked casing is allowed) that conform to the finished smoked ham commodity requirements of 4 to 5 inches (10.16 to 12.70 cm) in diameter and approximately10 pounds (4.54 kg) or 2 pounds (0.91kg) net weight.

c. In no case will the stuffing of the formulated batches of ingredients into casings be delayed longer than 48 hours or be held at a temperature higher than 40 °F (4.4 °C) or lower than 26 °F (-3.3 °C).

7. Smoking. Stuffed casings of formulated product must be smoked. Liquid smoke flavoring and smoke impregnated fibrous casings or packages may be used. The processor will inform the Grader of the smoking method being used, and appropriately label that method on each commodity label.

8. Cooking. The turkey hams must be smoked/cooked to an internal product temperature of 155 °F (68.3 °C) or higher. Cooking methods and product temperature will be monitored by FSIS personnel.

9. Cooling. After cooking, the hams must be cooled to an internal product temperature of 40 °F (4.4 °C) or lower.

10. Packaging and Packing Materials. All packaging and packing materials must be clean and in new condition, must not impart objectionable odors or flavors to the product, must be safe (cannot adulterate product or be injurious to health) for use in contact with food products, and must be tamper-evident. Tamper-evident is defined as packaging and packing materials with one or more indicators or barriers to entry, which, if breached or missing, can reasonably be expected to provide visible evidence that tampering has occurred.

a. Bags and casings. Packaging materials--bags and casings--for packaging the commodity must be made of waterproof film with oxygen barrier properties, be heat-shrinkable, and must protect the product from dehydration, freezer burn, quality deterioration or contamination during the conditions of use.

b. Shipping containers. Shipping containers must: (1) be good commercial fiberboard containers that are acceptable by common or other carrier for safe transport to point of destination, (2) be of such size to pack the commodity without slack filling or bulging; (3) withstand the stresses of handling, shipping, stacking, and storage, and (4) be closed by commercially accepted methods and materials. Steel or wire straps must not be used for final closure. Staples must 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.

11. Packaging and Packing.

a. Packaging. When fibrous casings are used, the casing must be removed from turkey hams after the smoking, cooking, and cooling processes just prior to packaging.

(1) Turkey hams must be packaged in a heat shrinkable oxygen- and water-proof bag or casing (as described in II.C.10.a.). The excess air must be removed (by vacuum) from each bag or casing. The bag or casing must be shrunk to fit tightly against the surface of the hams.

(2) After the air is removed, the bags or casings must 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 must not be used for sealing bags or casings.

b. Packing. Four approximately 10-pound (4.54 kg) or twenty approximately 2-pound (0.91 kg) packaged hams must be packed in each shipping container.

12. Freezing. Packaged smoked turkey hams must be placed in a freezer within 24 hours of packaging and must 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. If the packaged hams are not placed in a freezer immediately after packaging, the hams must be held at a temperature not higher than 36° F (2.2° C) and not lower than 26° F (-3.3° C) for no longer than 48 hours. When packaged hams are held at a temperature below 26° F (-3.3° C), the turkeys will be considered to be in a freezer and subject to the 72-hour freezing requirement which begins when the hams enter the freezer.

D. Metal Detection

Each fabricated turkey ham must 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 wire. Turkey hams must be examined prior to or after placing hams in the bags or casings in accordance with the procedures in AMS 910, Poultry Grader's Handbook.

As an alternate method, the formulated ham 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 in II.E.3., the hams must also be examined by a metal detection device prior to or after it is placed in the bag or casing.

Product found to be contaminated with metal will be handled in accordance with FSIS procedures. Other procedures for examination of the commodity must be approved by the Deputy Administrator of Poultry Programs, in writing.

E. Finished Smoked Turkey Ham Requirements

1. Skin. Skin must not be used in the smoked turkey hams.

2. Fabrication. Turkey hams must be fabricated, packaged, and packed so they can be hand-sliced or sliced by a meat slicer with minimal separation.

3. Physical Requirements. Packaged smoked turkey hams must (a) be 4 to 5 inches (10.16 to 12.70 cm) and round in diameter, and (b) weigh approximately either 10 pounds (4.54 kg) each or 2 pounds (0.91 kg) each.

4. Water Added Statement. The finished smoked turkey ham must be formulated with water and other ingredients in a manner that complies with the required labeling of "12-percent water added" for each ham.

5. Percent Fat Free Statement. The finished hams must be formulated to comply with the requirements of this Specification, 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.

6. Defects. Ten finished hams will be examined for the organoleptic requirements and defects shown in Table 3 prior to freezing. A Grader will examine 10 hams each sampling interval for exterior defects. Two (2) of the 10 samples will then be sliced into three approximately equal portions and two interior surfaces will be examined (excluding mirrored sides) for interior defects. The frequency of sampling and the number of defects allowed will be those outlined in Poultry Programs' SPL-2 found in the Poultry Graders Handbook. Examination for the defects shown in Table 3 will be made separately.

a. Any product that does not comply with the organoleptic requirements will be rejected for use under this Specification.

b. The color of the hams must be a uniform mahogany color that is no lighter than the "light tolerance" or darker than the "dark tolerance" shown in the color control guidelines for

smoked turkey ham examples prepared by Poultry Programs, dated July 1994 (provided by Poultry Programs to plants with a contract).

c. If the sample has more interior and/or exterior defects than the maximum tolerance for sample plan, the product the sample represents will be rejected and may be reworked in accordance with II.E.7.

Table 3. Organoleptic Requirements and Defects for Turkey Hams

Organoleptic Requirements:	**Ham must not:** Be rancid; have a sour, stale, fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, acidic, or other off or foreign odors; contain foreign materials (e.g., glass, paper, rubber, metal); or have foreign flavors such as, but not limited to, burnt, scorched, or stale.
	Defects
Exterior: **(10 hams examined)**	**The exterior of finished ham contains** individual major surface voids (including air voids, fat pockets, and purge pockets) exceeding an aggregate area equivalent to the area of a circle with the diameter 0.75 inch (1.91 cm). The depth of a void or pocket must be no greater than 0.50 inch (1.27 cm). Unobtrusive purge is allowed; however, pockets and voids holding purge, fat, or air must not exceed the aggregate diameter of 0.75 inch (1.91 cm). **The hams show evidence of** excessive heating (darkened or scorched). **Individual hams that are not** 4 to 5 inches (10.16 to 12.70 cm) and round in diameter. **An individual ham** that does not have a mahogany color associated with smoked meats, or one with a mahogany color lighter than or darker than the tolerance.
Interior: **(2 hams examined)** Hams will be cut (widthwise) in three approximate equal pieces.	**The interior of ham contains:** Voids, gelatin, or fat pockets on the sliced surfaces which exceed an aggregate area per surface equivalent to the area of a circle with the diameter 0.75 inch (1.91 cm).

7. Reworked Turkey Hams. 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:

a. The 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;

b. The hams are reworked within 72 hours from the end of the shift they were packaged;

c. The hams are ground through a plate with holes 0.125 inch (1/8 inch) (3.175 mm) in diameter;

d. The hams are incorporated at a maximum of 2 percent of the formulated batch (2 percent of the total 15 percent trimmings allowed); and

e. The hams are added to formulated product that will undergo the same smoking method(s).

III. LABELING

Smoked turkey ham (234040) must use either commercial labeling (III.A. and III.F.-G.) or USDA labeling (III.B.-G.). When commercial or USDA labeling is selected, both the packages and shipping containers within a purchase unit must be labeled in that format. THE CONTRACTOR MUST USE THE SAME LABEL FORMAT (EITHER COMMERCIAL OR USDA) WITHIN A PURCHASE UNIT. However, Smoked Turkey Hams (Small Pack)(234140) must be labeled using commercial labeling format for packages and shipping containers.

A. Commercial Labeling Requirements

Commercially labeled packages and shipping containers must be labeled in accordance with FSIS requirements. Labeling must be approved by FSIS prior to acceptance for use under this Specification.

1. Commercial Labels. Commercial labels must be the processor's own commercial label. Distributors' labels are not allowed.

2. Traceable Product. The processor must 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 Specification and commercial product, the identification system must 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, must be reviewed by USDA, AMS before production begins for the contract(s).

B. USDA Labeling Requirements

When USDA labeling is used, any deviations from the USDA labeling requirements in this

Specification must be approved by the Contracting Officer, in writing, prior to start of production. Labeling and marking of the commodity must be in accordance with this Specification. Labeling and marking information must be water-fast, nonsmearing, of a contrasting color, clear, and readable.

C. USDA-Labeled Packages

1. USDA Plant Number. The USDA-assigned plant number must be shown on each bag or casing in legible form.

2. Production Date. The date of production (month, day, and year) must be shown on the bag or casing of each ham.

D. USDA-Labeled Shipping Containers

1. Labeling and Marking Information.

a. Requirements. Labeling and marking information must be preprinted, stamped, or stenciled on each shipping containers, or printed on a pressure-sensitive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 2 - 3.

b. Nutritional labeling. A nutritional label, indicating the nutrient content of the commodity, is required on the principal display panel of each shipping container. This nutritional facts information or "nutrition facts panel" must comply with all labeling requirements of FSIS, and, in addition, include the declaration of trans fat consistent with FSIS policy. The nutritional facts information or "nutrition facts panel" must be preprinted on the principal display panel of each shipping container, or printed on a pressure-sensitive label and applied to the principal display panel of each shipping container. The pressure-sensitive label must not cover or conflict with the labeling requirements of this Specification.

c. Ingredient labeling. Must comply with all labeling requirements of FSIS. In addition, must include the source declaration of allergens when the source is not identified in the names of ingredients from any of the eight major allergens categories.

d. Universal product bar code.

(1) A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on each shipping container. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop indicators will be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance with UPC guidelines published by Uniform Code Council, Inc., Princeton Pike Corporate Center, 1009 Lenox Drive, Suite 202, Lawrenceville, NJ 08648.

(2) The contractor will use the code furnished by USDA. USDA has acquired a unique processor's identification number for the commodity purchase programs and will use a unique item code number for turkey hams purchased under this Specification. The contractors

need not join Uniform Code Council, Inc.

(3) The 14-digit UPC code for shipping containers of 10-pound turkey hams is: 1 07 15001 01548 5.

(4) The UPC code must be placed in the lower right-hand corner of the principal display panel of each shipping container.

2. Recycle Symbol and Statement. The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 4. The statement "PLEASE RECYCLE" is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.

3. Inventory Control Label. The processor may use a pressure-sensitive label to place any additional information (including bar codes) for processor inventory control purposes. This label may be applied somewhere on the surface of the shipping container. The label must not cover or conflict with the labeling requirements of this Specification.

E. Use of Previously Printed USDA Labeling Materials

Carryover inventories of existing supplies of printed packing materials (USDA labeling) from the Commodity Specification for Smoked Turkey Ham dated March 2007, may be used. If the ingredients statement, smoke ingredients, labeling of smoke ingredients, or nutrition facts panel changes from that printed on existing supplies, the contractor/processor must request temporary approval for use of carryover inventories from FSIS.

Shipping containers or labels with incorrect: (1) contract number, (2) plant number, (3) net weight, (4) date packed, (5) name of product, (6) qualifying statement, (7) ingredients statement, or (8) nutrition facts information or panel must be corrected before they are used. The incorrect information must 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 must appear on each shipping container.

F. Additional Labeling Issues

The following are not acceptable for use under this Specification:

-- Commercial labels that do not have a processor traceability system and code.

-- Commercial labeling traceability coding and systems that have not been reviewed by a representative of Poultry Programs, Grading Branch.

-- Distributor commercial labels.

-- Two or more different commercial labels in the same purchase unit.

-- Commercial labels and USDA labels in the same purchase unit.

G. F.A.S. Vessel Deliveries

F.A.S. vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Notice to Deliver. The address must be clearly printed on at least two sides of each pallet.

IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY

A. Material and Net Weight Compliance

1. Verification of Materials and Defects.

a. Verification of packaging and packing materials. The contractor must verify compliance with packaging, packing, and marking material requirements by furnishing the Grader the following certification on company stationery signed by a person authorized to do so by the contractor:

"(I)(We) certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under the terms of this Commodity Specification for Smoked Turkey Ham dated March 2008, comply or will comply with the terms of this Commodity Specification.

Name _____
Title _____"

One certification is adequate for all production under this Specification.

b. Packaging defects. Packages in a delivery unit will 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.

c. Packing defects. Shipping containers in a delivery unit will be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers.

d. 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 Poultry Programs' sample plan, the delivery unit will be rejected.

2. Net Weight. A purchase or delivery unit must total 40,000 pounds (18,144 kg) net, or multiples thereof.

a. Test weighing procedures.

(1) The tare weight of all packing materials will be determined by weighing a representative sample of all packaging components such as plastic-film bags, clips, and fiberboard containers.

(2) A representative sample will 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
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.

b. Weight variations. USDA will pay the contractor only for the amount of commodity delivered. Net weight for hams will be determined at origin.

c. Alternate net weight verification. As an alternative to test weighing at time of loading, the contractor may request on-line verification of net weights. Upon receiving the request, a Federal-State supervisor, Grading Branch, Poultry Programs (or their designee), will determine that the facilities and procedures are in accordance with the applicable Poultry Programs' instructions for this Specification.

B. Prerequisites for Loading and Shipping Frozen Commodity

1. Visual Inspection. Frozen commodity showing any evidence of thawing, refreezing, or freezer deterioration will be rejected for use under this Specification.

2. Internal Product Temperature.

a. Requirements. The internal product temperature of frozen commodity must 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) will 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 will be rejected.

b. Optional temperature verification. As an option to verifying internal product temperature at time of loading, the contractor may request an alternate method utilizing product temperature-sensing devices. If this option is selected, a Federal-State supervisor will 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 Poultry Programs' instructions for this Specification.

C. Inspection and Checkloading

1. Requirements. Inspection for contract compliance will be made by a USDA representative, in accordance with 7 CFR part 70, FSIS regulations, and this Specification, at site of processing, both during and after processing and packaging. A USDA representative may select samples or inspect the commodity at any point in transit and after delivery to point of destination. Inspection records must be complete and made available to USDA, as requested, to assure contract compliance.

2. Procedures. The inspection and checkloading must be performed by the Grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest Grading Branch field office or the Chief of Grading Branch, Poultry Programs, AMS, USDA, Room 3938-S, STOP 0258, 1400 Independence Avenue, SW, Washington, D.C. 20250-0258, telephone (202) 720-3271.

The quality, quantity, weight, packaging, packing, and checkloading of the commodity must be evidenced by certificates issued by the Grader. Contractor must not ship the commodity unless informed by the Grader that the designated commodity to be shipped meets contract specifications.

V. UNITIZATION

Each delivery unit of smoked turkey hams must be unitized (palletized and stretchwrapped) and comply with the following:

A. Pallets

Pallets must be good quality, wood, 48 inches x 40 inches, nonreversible, flush stringer, and partial four-way entry. Each pallet of shipping containers must be stretchwrapped with plastic film in a manner that will secure each container and layer of containers on the pallet. Palletized product must be loaded in a way that will prevent shifting and damage to the containers of product. Pallet loads shall be stacked in a manner that minimizes the overhang of the shipping containers over the edges of the pallets and exposes the principle shipping container display panels to facilitate certification examinations.

B. Pallet Exchange

Contractors may arrange for pallet exchange with consignees; however, USDA is in no way responsible for such arrangements.

VI. SHIPMENT AND DELIVERY

Shipment and delivery must be made in accordance with this Specification, and the applicable Announcement and Invitation. In addition, the following provisions must be adhered to:

A. Contract Compliance Stamp

Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number. A Grader, or other authorized personnel under the supervision of the Grader, will 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.

B. Grading Certificate

A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading must accompany each shipment.

1. Railcar or Piggyback. If shipment is by rail or piggyback, the certificate must be placed in the railcar or trailer for easy access to the Grader, warehouseman, or consignee, as applicable.

2. Trucks. If shipment is by truck, the driver must, upon delivery, give the certificate to the Grader, warehouseman, or consignee, as applicable.

C. Loading and Sealing of Vehicles

Loading must be in accordance with good commercial practices and the initial sealing must be done at origin under the supervision of a Grader. Thereafter, all delivery units--truck lot and less-than-truck lot (LTL) quantities--must be secured at all times prior to unloading with tamper proof, tamper resistant, serially numbered, high security seals. Suppliers of commodities, products and/or services shall be responsible for placing a seal(s) on all doors of each transportation conveyance upon completion of loading or servicing. Seals shall be serially numbered, barrier-type and meet the American Society for Testing and materials (ASTM) standards. Seals shall be $1/8^{th}$ inch diameter cable, high security bolt, or equivalent. The contractor must maintain a record of each seal number used for truck lot and LTL delivery units. Additionally, the contractor must ensure that the applicable seal identification number is on each bill of lading, shipment manifest, or other delivery documents for each delivery destination. When LTL delivery units are transported on the same trailer or railcar and destined for multiple recipients, the trailer or railcar must be sealed after each delivery. The seal number must be recorded on the appropriate delivery documents and correspond with the applied seal at the time of arrival at the next destination. It will be the responsibility of the contractor to provide a sufficient number of seals and ensure that the carrier service (truck or rail) secures the trailer or railcar after each delivery destination. Failure to seal the trailer or railcar after each stop may result in rejection of the shipment by the recipient agency at the next scheduled stop and rejection of any subsequent deliveries on the trailer or railcar.

1. Railcar. Each railcar must be sealed. The contractors are responsible for arranging for railcar deliveries of more than one delivery unit so that each delivery unit contained in the same railcar can be completely separated and sealed.

2. Truck or Piggyback. Truck or piggyback shipments must be sealed at origin. A delivery unit shipped by truck or piggyback which includes split deliveries to multiple destinations will require sealing after each drop in accordance with Section VI.C of this Specification.

D. Delivery Notification

The contractor must follow the instructions in the Notice to Deliver issued by the Kansas City Commodity Office (KCCO) concerning delivery notification. Such notification and information of impending delivery are vital in proper execution of delivery. The contractor must notify the State distributing agency and the consignee of shipment per instructions in the Notice to Deliver. For rail or piggyback shipments, notification shall be made on the day of shipment. For truck shipments, notification of the estimated arrival time should be made as far in advance of delivery as possible. In addition, for truck or piggyback shipments, the contractor must request and keep scheduled appointment(s). Unloading appointments for truck or piggyback shipments must be requested from the consignee contact party(ies) at least 24 hours in advance of delivery.

1. In-Plant Deliveries. When in-plant delivery is made, the contractor must notify the appropriate resident Grader and furnish applicable information.

2. Delivery in Storage. Delivery may be made in store provided the destination in the Notice to Deliver and the place the contractor has the commodity in storage are the same. Inspection and certification by a Grader are also required for transfers in store.

E. Split Deliveries

The contractor is responsible to deliver the quantity stated on each Notice to Deliver to each destination. Contractors must provide to the Grader, at time of shipment, the number of boxes and pounds for each destination. At the option of the contractor, a purchase unit with two or more Notices to Deliver (split deliveries) for multiple destinations may be delivered on separate trucks provided each truck ships the total quantity stated on the Notice to Deliver. Any additional costs will accrue to the contractor's account.

VII. DESTINATION EXAMINATION

The cost of a destination examination, before or after delivery, by a Grader on accepted product will be for the account of USDA. Costs for destination examinations of rejected delivery units will be for the account of the contractor. The origin Grader will make arrangements for destination examination prior to delivery.

A. Commodity Requirements

Before acceptance by consignee, the commodity may be examined by a 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.

B. Temperature

The commodity must 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). Commodity not meeting these requirements will be rejected for use under this Specification.

Rex A. Barnes
Deputy Administrator
Poultry Programs

Attachments

EXHIBIT 1
Example Formulation For Smoked Turkey Hams

In the formulation of turkey hams, the meat portion and the added water (all other non-meat ingredient) portion are considered two separate components. The meat portion is cited in section II.C.4.a., page 7 of this Specification. Water/ice and other ingredients must be added to the meat portion to assist in the processing of turkey hams. 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 must comply with the 12 percent water added requirement (percentage includes water and all other non-meat ingredients) and this Specification. The added water statement will be calculated on the formulation using the raw meat (green) weight and the finished cooked weight of the product as shown below.

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

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

	Number of Pounds
Meat Portion (Green Weight)	
Size-Reduced Turkey Thigh Meat (may contain up to 15% thigh trimmings)	100.00
Raw Meat Weight w/o Water/Ingredients	**100.00 lbs.**
Water / Other Ingredient Portion	
*Water/Ice	17.15
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)	3.50
Raw Batch Weight	126.28 lbs.
**Yield after cooking/smoking	x 0.90
Finished Cooked/Smoked Weight	**113.65 lbs.**

Percent added water calculation:

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

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. Markings must be legibly preprinted, stamped, stenciled on containers, or printed on a separate pressure-sensitive label and applied to containers. The USDA symbol, copy on back of Specification, 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 must be printed on the top panel or the principal display panel. The processor name and address must indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.

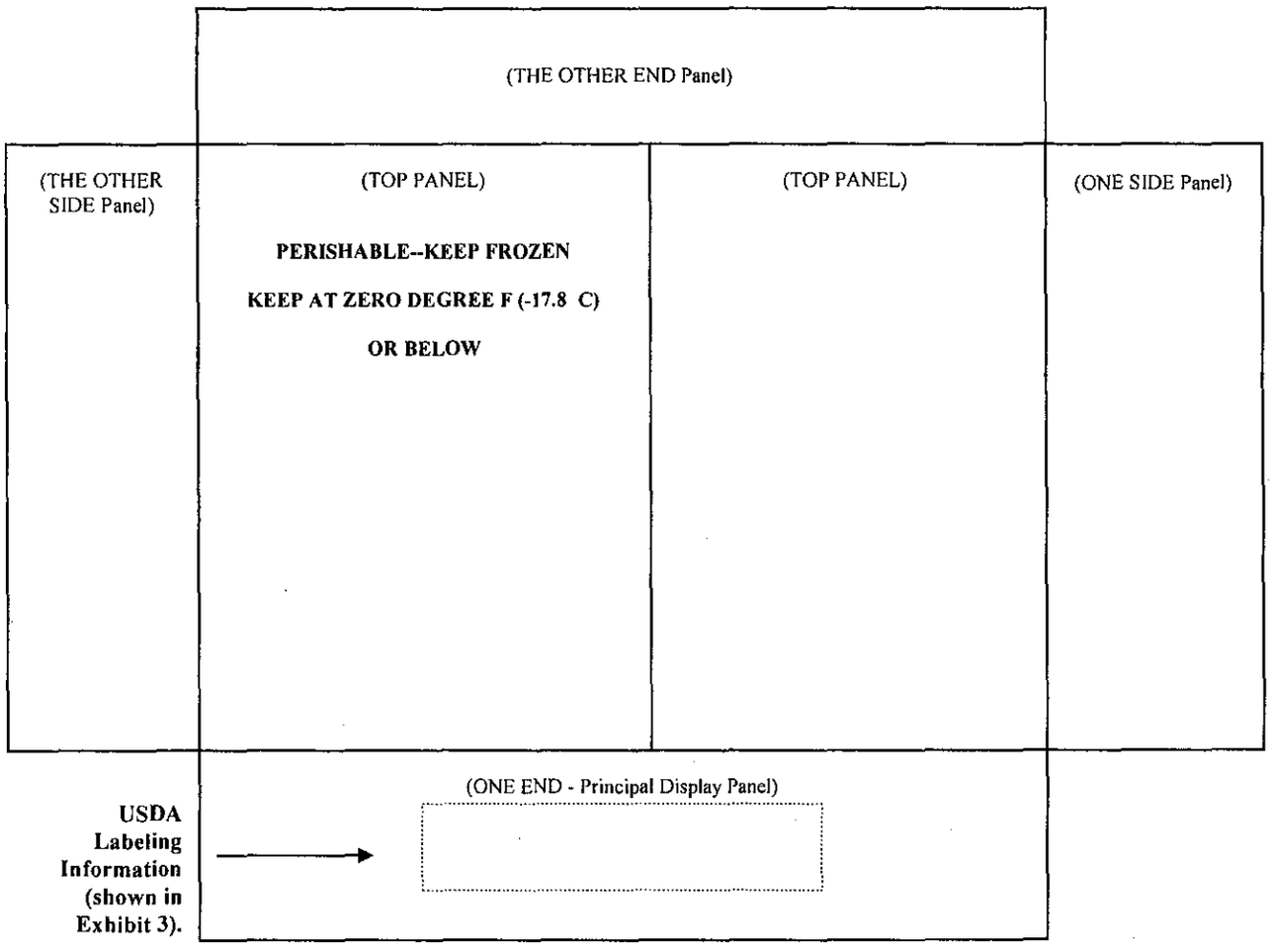


EXHIBIT 3
USDA Label Information

Marking Information: USDA labeling information must be printed on the principal display panel of each shipping container as provided in Exhibit 2. Markings must be legibly preprinted, stamped, stenciled on containers, or printed on a separate pressure-sensitive label and applied to containers. [1]**The identification of *smoking method(s) used* below is provided only as an example. The processor must designate the applicable smoking method used on each label and the labeling must be approved by FSIS.** The UPC 14-digit I 2/5 code (1 07 15001 01548 5), bar and code, must be shown in the lower right-hand corner of the principal display panel. The USDA symbol, copy on back of Specification, must be a minimum of 2.25 inches (5.72 cm) in height and must be printed on the top panel or the principal display panel. The processor's name, address, and phone number must be printed on the top panel or the principal display panel. The processor name and address must indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.

FROZEN FULLY COOKED
SMOKED TURKEY HAM*
with 12% Water
***Cured Turkey Thigh Meat, Chunked and Formed,**
***Smoke Flavor Added (as applicable)*[1] **95% FAT FREE**
Ingredients:

Processor's
Name, Address, and Phone

Nutrition Facts Label
May Be Placed Here

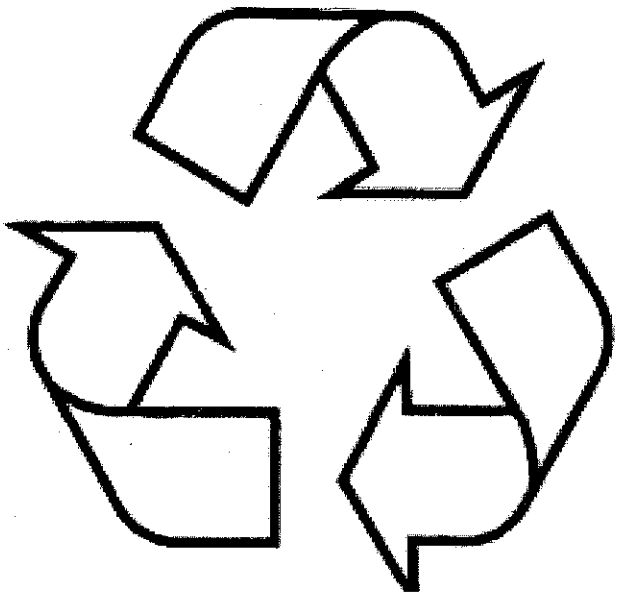
KEEP FROZEN

__ Bags Net Weight
___ LBS. (___ KG)

CONTRACT NO. _____
DATE PACKED Month, Day, and Year

UPC Bar and Code

EXHIBIT 4
"Please Recycle" Symbol and Statement



PLEASE RECYCLE

USDA SYMBOL