

INCH-POUND

A-A-20164B
February 29, 1996
SUPERSEDING
A-A-20164A
September 28, 1990

COMMERCIAL ITEM DESCRIPTION

NUTS, SHELLLED, ROASTED

The U.S. Department of Agriculture has authorized the use of this Commercial Item Description.

1. SCOPE.

1.1 This Commercial Item Description (CID) covers shelled roasted nuts, packed in commercially acceptable containers, suitable for use by the Federal Government and as a component of operational rations.

2. CLASSIFICATION.

2.1 The shelled roasted nuts shall conform to the following types and styles, as specified in the solicitation, contract, or purchase order.

Types.

- Type I** - Mixed nuts without peanuts
- Type II** - Mixed nuts with peanuts
- Type III** - Mixed nuts without peanuts, dry roasted

Beneficial comments, recommendations, additions, deletions, clarifications, etc., and any data which may improve this document should be sent to: Head, Food Quality Assurance Staff, Fruit and Vegetable Division, Agricultural Marketing Service, U.S. Department of Agriculture, Room 2506, South Building, P.O. Box 96456, Washington, DC 20090-6456 or FAX (202) 690-0102.

FSC 8925

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- Type IV** - Peanuts, roasted
 - (a) Virginia type or Runner type (blanched)
 - (b) Spanish type (unblanched)
- Type V** - Peanuts, Virginia type or Runner type, dry roasted
- Type VI** - Cashews
- Type VII** - Cashews, dry roasted
- Type VIII** - Peanuts, Runner type, roasted, sweetened (unblanched)

Styles.

- Style A** - Salted (Types I-VII.)
- Style B** - Unsalted (No sodium chloride added during processing.)

3. SALIENT CHARACTERISTICS.

3.1 Raw materials:

3.1.1 Almonds: Shelled almonds shall be U.S. No. 1 (or better) as specified in the U.S. Standards for Grades of Shelled Almonds.

3.1.2 Brazil nuts: Brazil nuts shall be U.S. No. 1 as specified in the U.S. Standards for Grades of Brazil Nuts in the Shell.

3.1.3 Cashews: Cashews shall be of good commercial quality.

3.1.4 Filberts: Filberts shall be U.S. No. 1 as specified in the U.S. Standards for Grades of Filberts in the Shell.

3.1.5 Pecan halves: Shelled pecans shall be U.S. No. 1 Halves as specified in the U.S. Standards for Grades of Shelled Pecans. Size designations shall be Extra Large to Mammoth.

3.1.6 Peanuts: Shelled Virginia type peanuts for Type II mixed nuts shall be U.S. Extra Large Virginia. When runner type peanuts are used for Type II and Type VIII peanuts, they shall be Jumbo Grade of the American Peanut Shellers Association's Grades for Shelled Runner Peanuts. Shelled Virginia type peanuts for Type IV (a) roasted peanuts and Type V dry roasted peanuts shall be of U.S. Medium Virginia or U.S. Extra Large Virginia. When Runner type peanuts are used for the Type IV (a) or V peanuts, they shall be U.S. No. 1 Runner. The Type IV (a) and Type V peanuts, shall be U.S. No. 1 Runner. The Type IV (a) and Type V peanuts are specified in the U.S. Standards for Shelled Virginia Type Peanuts and

U.S. Standards for Runner Type Peanuts. Shelled peanuts for Type IV (b) shall be U.S. No. 1 Spanish of the U.S. Standards for Grades of Shelled Spanish Type Peanuts.

3.1.7 Sampling: All shelled raw peanuts used in finished product shall be sampled by the Fresh Products Branch, Fruit and Vegetable Division (FV), Agricultural Marketing Service (AMS), U.S. Department of Agriculture (USDA), for aflatoxin testing. The shelled raw peanuts shall be tested for aflatoxin by the Science and Technology Division (STD), AMS, USDA. Any results for aflatoxin other than negative shall be cause for rejection of the involved product.

3.1.8 Requirements: The shelled raw nuts shall be clean, sound, and wholesome, provided that not more than 5 percent, by weight, of the shelled raw nuts shall be affected by any defect which materially detracts from the appearance of the nut and further provided that not more than 2 percent, by weight, shall be affected by rancidity, mold, decay, or insect or worm injury.

3.1.9 Count: The shelled raw nuts shall meet the count requirements of Table I.

TABLE I. Count of shelled raw nuts

Component	Unit of Type	Not less Measure	Nuts (by count)	
			Not more than	Not more than
Cashews	I, II, III, VI, or VII	Pound	220	320
Pecan halves	I, II, or III	Pound	200	450
Filberts	I, II, or III	Pound	320	520
Brazil nuts	I, II, or III	Pound	110	190
Almonds	I, II, or III	Ounce	16	25
Peanuts, Virginia type	II or IV (a)	Ounce	28	32
Peanuts, Runner type	II, IV (a), or VIII	Ounce	36	42
Peanuts, Spanish type	IV (b)	Ounce	54	58

3.2 Processing: Roasting oil shall be refined vegetable oil. No coconut, palm, or palm kernel oil shall be allowed in the cooking process. The oil shall be thoroughly refined, deodorized, and free from rancidity and objectionable flavor. In addition, the roasting oil shall be stabilized with suitable antioxidants. If used, the salt shall be of Food Chemicals Codex purity, white, refined sodium chloride with or without anticaking agents, free from extraneous matter, and may be treated with antioxidants. If nuts are oil roasted, granule size or type of salt shall be dendritic or fine flake salt. If nuts are dry roasted, a flour salt or a

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pulverized salt, 85 percent of which shall pass through a U.S. Standard No. 200 sieve, shall be used. Iodized salt shall not be used. Dressing oil shall conform to the requirements for roasting oil and shall be used only to the extent necessary with this type of product. If the salt does not have antioxidants, dressing oil shall be treated with antioxidants. Cereal adjuncts shall be food starch, modified starch, dextrin, and gum, which may be used as a binder or filler. In addition, the product may contain spices (including paprika), natural flavors, or yeast to produce a desirable finished product. For Type VIII shelled roasted sweetened peanuts, a coating containing sugar and/or corn syrup shall be applied after roasting (the coating shall not contain honey).

3.3 Finished product requirements: The finished shelled roasted nuts shall be crisp, palatable, and shall not contain bitter, musty, sour, rancid, sprouty, or other undesirable flavors and odors. Nuts shall not be excessively hard and there shall be no evidence of burnt nuts. If used, salt shall be evenly distributed throughout the nuts, and the surface of the nuts shall show no excessive caking of salt. The nuts shall not be excessively coated with oil, and the blanched nuts shall be bright. The product shall not contain mildew stains, husks, filth, or other extraneous matter. The finished shelled roasted nuts shall comply with the requirements specified in Table II through Table V, as applicable. Type VIII shelled roasted sweetened peanuts shall possess a fresh roasted peanut flavor and odor with a secondary sweet, slightly salty flavor. The Type VIII shelled roasted sweetened peanuts shall be a light to medium brown with an internal light brown color and the surfaces shall be dry (not tacky) to the touch.

TABLE II. Composition of mixed nuts

Component	Type I		Type II		Type	
	Mixed nuts		Mixed nuts		Mixed nuts	
	without peanuts		with peanuts		without peanuts,	
	Percent (by weight)		Percent (by weight)		dry roasted	
	Not less	Not more	Not less	Not more	Not less	Not more
	than	than	than	than	than	than
Cashews	35.0	60.0	30.0	40.0	45.0	55.0
Pecans	18.0	22.0	20.0	24.0	18.0	22.0
Almonds	13.0	17.0	15.0	19.0	13.0	17.0
Filberts	4.0	6.0	4.0	6.0	4.0	6.0
Brazil nuts	8.0	10.0	8.0	10.0	8.0	10.0
Peanuts, Virginia type or Runner type (blanched) or mixtures thereof	-----	-----	8.0	10.0	-----	-----

TABLE II. Composition of mixed nuts (Continued)

Component	Type I		Type II		Type	
	Mixed nuts		Mixed nuts		Mixed nuts	
	without peanuts		with peanuts		without peanuts,	
	Percent (by weight)		Percent (by weight)		Percent (by weight)	
	Not less	Not more	Not less	Not more	Not less	Not more
	than	than	than	than	than	than
Cereal adjuncts	-----	-----	-----	-----	2.0	3.0
Salt (coating) (if specified)	0.5	2.0	0.5	2.0	0.5	2.0

TABLE III. Composition of single variety nuts 1/

Component	Percent (by weight)	
	Not less	Not more
	than	than
Type IV (a)		
Peanuts, Virginia type or Runner type, roasted (blanched)	98.0	99.5
Salt (coating) (if specified)	0.5	2.0
Type IV (b)		
Peanuts, Spanish type, roasted (unblanched)	98.0	99.5
Salt (coating) (if specified)	0.5	2.0
Type V		
Peanuts, Virginia type or Runner type, dry roasted	95.0	97.5
Cereal adjuncts	1.0	4.0
Salt (coating) (if specified)	1.0	3.0
Type VI		
Cashews	98.0	99.5
Salt (coating) (if specified)	0.5	2.0

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TABLE III. Composition of single variety nuts 1/ (Continued)

Component	Percent (by weight)	
	Not less than	Not more than
Type VII		
Cashews, dry roasted	95.0	99.0
Cereal adjuncts	0.5	4.0
Salt (coating) (if specified)	0.1	3.0
Type VIII		
Peanuts, Runner type, roasted, sweetened (unblanched)	98.0	99.5
Salt (coating)	0.5	1.5

1/ Style B, Type IV peanuts and Style B, Type VI cashews shall consist of 100 percent peanuts and cashews, respectively.

TABLE IV. Defects of Type I - VIII nuts

Type	Broken 1/	Splits 2/	Small pieces 3/
	Percent (by weight)		4/
Not more than			
Type I	17.0	-----	4.0
Type II	18.0	-----	4.0
Type III	18.0	-----	4.0
Type IV (a)	-----	25.0	4.0
Type IV (b)	-----	5.0	4.0
Type V	-----	25.0	4.0
Type VI	-----	25.0	4.0
Type VII	-----	25.0	4.0
Type VIII	-----	10.0	----

1/ For peanuts, filberts, and brazil nuts, broken means that more than one fourth of the kernel is estimated to be broken off. For pecan halves and almonds, broken means that more than one eighth of the kernel is estimated to be broken off. However, split nuts are not to be classified as broken. See footnote **2/**.

- 2/ A split means the separated half of the kernel.
- 3/ A small piece is defined as any piece one fourth or less of the kernel.
- 4/ Results will be reported to the nearest 0.1 percent.
- No requirement.

3.4 Sampling: Types I, II, III, IV, V, and Type VIII finished shelled roasted sweetened nuts shall be sampled for aflatoxin testing in accordance with Processed Products Branch (PPB), FV, AMS, USDA procedures.

3.5 Analytical requirements: Unless otherwise specified, analytical requirements for Types I, II, III, IV, V and Type VIII finished shelled roasted sweetened nuts shall be as follows: Salt content - see Tables II and III. Moisture content (Type VIII only) - not more than 2.8 percent.

3.5.1 Analytical procedure (testing for salt content): The sample for salt content testing shall be a composite of 16 ounces (453.59 g) of product. The following chart is to be used as a guide for determining the minimum number of sample units to use for deriving the composite for salt content testing:

<u>Container size</u>	<u>Minimum number of sample units</u>
Less than 4 pounds (1.814 kg)	10 <u>1</u> /
4 pounds (1.814 kg) or more	5

- 1/ The composite for examination must consist of a minimum of 16 ounces of product. For mixed nuts in containers smaller than 1.6 ounces (45.36 g), it will be necessary for some sample units to consist of more than one container.

Each container shall be emptied and the composite thoroughly mixed prior to extracting the sample for testing.

3.5.2 Preparation of sample: The contents are ground through a 3/16 inch (0.476 cm) plate, mixed thoroughly and quickly by hand with a rubber spatula and stored in a moisture proof bag. For moisture determination on pouches of about 1.0 ounces (28.3 g), only about 20 grams (0.705 ounces) are collected through the plate when using a grinding assembly requiring a 2 inch (5.08 cm) diameter plate. Samples this small must have duplicate weighing immediately after grinding for moisture analyses. If only one weighing is made, a recheck of that prepared sample will result in an erroneous result because moisture is readily lost to the headspace when the sample reaches equilibrium with the headspace. When weighing the samples in duplicate as described above, the replicates agree very closely. When comparing initial moisture results to moisture results from a sample aliquot held in a moisture proof

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sample bag, the held samples consistently had moisture losses that amounted to variations up to 25 percent. If duplicate weighings are made and the initial moisture is in specification, then the duplicate sample is discarded.

3.5.3 Analytical testing: Analyses shall be made in accordance with the following Official Methods of Analysis of the AOAC International:

<u>Test</u>	<u>Method</u>
Salt <u>1</u> /	950.52
Moisture <u>1</u> /	925.40

1/ In finished product.

3.5.4 Test results: Test samples shall be sent to the appropriate STD laboratory for aflatoxin testing. Failure of product to meet Food and Drug Administration guidelines for aflatoxin in processed peanut products shall be cause for rejection of the product. The test results for salt and moisture shall be reported to the nearest 0.1 percent. Any result not conforming to finished product requirements shall be cause for rejection of the lot.

4. REGULATORY REQUIREMENTS.

4.1 The delivered shelled roasted nuts shall comply with all applicable Federal and State mandatory requirements and regulations relating to the preparation, packaging, labeling, storage, distribution, and sale of the shelled roasted nuts within the commercial marketplace. Delivered shelled roasted nuts shall comply with all applicable provisions of the Federal Food, Drug, and Cosmetic Act and regulations promulgated thereunder.

5. QUALITY ASSURANCE PROVISIONS.

5.1 Contractor's certification. The contractor shall certify and maintain substantiating evidence that the shelled roasted nuts offered meet the salient characteristics of this CID, and that the shelled roasted nuts conform to the producer's own drawings, specifications, standards, and quality assurance practices, and are the same shelled roasted nuts offered for sale in the commercial marketplace. The Government reserves the right to require proof of such conformance prior to first delivery and thereafter as may be otherwise provided for under the provisions of the contract.

5.2 Quality assurance. When required in the solicitation, contract, or purchase order that product quality or acceptability or both be determined, PPB, FV, AMS, USDA, shall be the

certifying activity and shall make the determination in accordance with applicable PPB procedures. The shelled roasted nuts shall be examined or analyzed or both in accordance with applicable provisions in this CID, solicitation, contract, or purchase order, and, when applicable, the United States Standards for Condition of Food Containers in effect on the date of the solicitation.

5.3 Sampling of shelled raw nuts. Shelled raw nuts shall be examined to determine conformance to raw material requirements shown on pages 2 and 3 of this CID. The sample unit for examination shall be 1 pound (0.45 kg) of product from a container and the sample size shall be five with the following exception: If a lot consists of less than five containers, less than five samples may be drawn as long as a sample is extracted from each container in the lot and a total of 5 pounds (2.27 kg) of product is drawn. One or more sample units not conforming to raw material requirements shall be cause for rejection of the lot.

5.4 Examination of shelled raw nuts. Each of the component nuts shall be examined to determine conformance to the count requirements of Table I. The sample unit for examination shall be 1/4 pound (0.113 kg) of each component nut, selecting only whole nuts, except for pecan halves. The sample shall be derived from a minimum of five containers, except that when a lot consists of less than five containers, a sample unit shall be extracted from each container in the lot. Nonconformance to count per pound/ounce (calculated from the 1/4-pound [0.113 kg] samples) shall be cause for rejection of the lot.

5.5 Determining conformance. Unless otherwise specified, the following will be used as a guide for determining conformance with finished product requirements.

5.5.1 Conformance with finished product requirements. The lot size will be expressed as the number of primary containers in the lot. A sample unit will be one filled and sealed primary container. A defective unit will be one sample unit failing to meet one or more of the finished product requirements. One or more sample units not conforming to finished product requirements shall be cause for rejection of the lot.

5.5.2 Sampling plan for finished product requirements. For lot sizes of 35,000 or less, 5 primary containers shall be selected. One or more sample units not conforming to finished product requirements shall be cause for rejection of the lot. For lot sizes greater than 35,000, 20 primary containers shall be selected. Two or more sample units not conforming to finished product requirements shall be cause for rejection of the lot.

5.6 Examination for composition of mix (Types I, II, and III). Examination shall be performed to determine conformance with Table II. The sample for examination shall be a composite of not less than 80 ounces (2.268 kg) of product. The following chart is to be used as a guide for determining the minimum number of sample units to use for deriving the

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composite for examination:

Container size		Minimum number of sample units
Greater than or equal to	but less than	
0 ounces	5 ounces	20 <u>1</u> /
5 ounces	6 ounces	16
6 ounces	7 ounces	14
7 ounces	8 ounces	12
8 ounce	-9 ounces	10
9 ounces	10 ounces	9
10 ounces	12 ounces	8
12 ounces	14 ounces	7
14 ounces	16 ounces	6
16 ounces and up		5

1/ The composite for examination must consist of a minimum of 80 ounces (2.268 kg) of product. For mixed nuts in containers smaller than 4 ounces (113.40 g), it will be necessary for some sample units to consist of more than one container.

For mixed nuts in containers less than or equal to 16 ounces (453.59 g), the entire contents of each sample unit shall be used to form the composite sample.

For mixed nuts in containers larger than 16 ounces (453.59 g), a composite of 80 ounces (2.268 kg) of nuts from the five samples shall be formed as follows:

1. Empty contents of all the sample units into a deep pan or other container which will allow free manipulation of product.
2. Mix nuts thoroughly.
3. Extract 80 ounces (2.268 kg).

Utilize all nuts in the composite sample, including identifiable (as to kind) broken pieces. Calculate percentage of each kind of nut based on total weight of nuts in the composite sample.

6. PACKAGING.

6.1 Preservation, packaging, packing, labeling, and marking. The shelled roasted nuts shall be preserved, packaged, packed, labeled, and case marked in accordance with good commercial practice.

7. NOTES.

7.1 Sources of documents.

7.1.1 Sources of information for nongovernmental documents are as follows:

Copies of the Official Methods of Analysis of the AOAC International may be obtained from: **AOAC International, 481 North Frederick Avenue, Suite 500, Gaithersburg, MD 20877.**

Copies of the Food Chemicals Codex may be obtained from: **National Academy Press, 2101 Constitution Avenue, NW, Washington, DC 20418.**

7.1.2 Sources of information for governmental documents are as follows:

Applicable provisions of the Federal Food, Drug, and Cosmetic Act are contained in 21 CFR Parts 1 to 199. This document may be purchased from: **Superintendent of Documents, ATTN: New Orders, P.O. Box 371954, Pittsburgh, PA 15250-7954.** Credit card (MasterCard or Visa) purchases may be made by calling the Superintendent of Documents on (202) 512-1800.

Copies of the United States Standards for Condition of Food Containers are available from: **Chairperson, Condition of Container Committee, Agricultural Marketing Service, U.S. Department of Agriculture, Room 2506, South Building, P.O. Box 96456, Washington, DC 20090-6456.**

Civil agencies and other interested parties may obtain copies of this CID from: **General Services Administration, Federal Supply Service Bureau, Specifications Section, Suite 8100, 470 L'Enfant Plaza, SW, Washington, DC 20407.**

Military activities should submit requests for copies of this CID to: **Standardization Documents Order Desk, Building 4, Section D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.**

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MILITARY INTERESTS:

Military Coordinating Activity

Army - GL

Custodians

Army - GL

Navy - SA

Air Force - 35

Review Activities

Army - MD, QM

Navy - MC

DLA - SS

CIVIL AGENCY COORDINATING ACTIVITIES:

DOJ - BOP

HHS - NIH, IHS

USDA - FV

VA - OSS

PREPARING ACTIVITY:

USDA - FV