



Commodity Specification

**COOKED AND SLICED
TURKEY ROASTS**

OCTOBER 1999



Table of Contents

	Page
I. GENERAL	1
II. COMMODITY SPECIFICATIONS	1
A. Basic Requirements	1
1. Date Processed	1
2. Class and Style	1
3. Origin of Turkeys	1
4. Inspection	2
5. Product Temperature	2
6. USDA Sampling Option	2
7. Organoleptic Requirements	2
B. Preparation of Roasts	2
1. Sources of Meat	2
2. Turkey Products From Other Plants	3
3. Requirements for Meat and Skin	3
4. Defects	4
Table 1. Defects for Meat and Skin	5
5. Formula	5
6. Mixing	6
7. Meat and Skin Percentages for Turkey Roasts	6
8. Hand and Mechanical Forming or Stuffing	7
9. Skin Coverage	7
C. Raw Roast Requirements	8
1. Weight and Diameter Requirements	8
2. Examination for Defects	8
Table 2. Defects for Fabricated Roasts	9
3. Raw Roasts for Further Processing	9
D. Cooking, Cooling, Slicing, and Finished Product Requirements	9
1. Cooking	9
2. Cooling and Slicing	10
3. Defects for Finished Roasts	10
4. Cooked Roasts for Further Processing	10
E. Metal Detection	10
1. Requirements	10
2. Operating Efficiency and Procedures	10
3. Contaminated Product	11
4. Other Detection Procedures	11
F. Packaging and Packing	11
1. Material Requirements	11
2. Packaging and Packing	12
G. Freezing	12

	Page
III. LABELING	13
A. Packaged Roasts	13
1. Nutritional Labeling	13
2. USDA Grade	13
3. Universal Product Bar Code	13
B. Shipping Containers	14
1. Recycle Symbol and Statement	14
2. Labeling and Marking Information	14
3. TOP PANEL - Labeling and Marking	14
4. ONE END Panel - Labeling and Marking	15
5. ONE SIDE Panel - Labeling and Marking	16
6. THE OTHER END Panel - Labeling and Marking	16
7. THE OTHER SIDE Panel - Labeling and Marking	17
8. Inventory Control Label	17
C. F.a.s. Vessel Deliveries	17
IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY	17
A. Material and Net Weight Compliance	17
1. Verification of Materials and Defects	17
2. Net Weight	18
B. Prerequisites for Loading and Shipping Frozen Commodities	19
1. Visual Inspection	19
2. Internal Product Temperature	19
C. Inspection and Checkloading	19
1. Requirements	19
2. Procedures	19
V. UNITIZATION	20
A. Pallets	20
B. Pallet Exchange	20
VI. SHIPMENT AND DELIVERY	20
A. Contract Compliance Stamp	20
B. Grading Certificate	20
1. Railcar or Piggyback	20
2. Trucks	21
C. Loading and Sealing of Vehicles	21
1. Railcar	21
2. Truck or Piggyback	21
D. Delivery Notification	21
1. In-Plant Deliveries	21
2. Delivery In Storage	21
3. Early Delivery	21
E. Split Deliveries	22

	Page
VII. DESTINATION EXAMINATION	22
A. Commodity Requirements	22
B. Temperature	22
C. Cost for Frozen Commodity Destination Examination	22
EXHIBITS	23-25
EXHIBIT 1 - Label Information for Packaged Cooked and Sliced Turkey Roasts	23
EXHIBIT 2 - Label Information for Shipping Containers of Cooked And Sliced Turkey Roasts	24
EXHIBIT 3 - "Please Recycle" Symbol and Statement	25
USDA Symbol	Back of Specification

I. GENERAL

Frozen fully cooked and sliced turkey roasts produced from ready-to-cook young turkeys under this Specification will be packaged and packed in the following form as specified in the contract:

Cooked Roasts (233932) - Frozen cooked and sliced turkey roasts, prepared from U.S. Grade A turkey roasts. Each roast must be packaged in a plastic-film bag and packed four roasts per fiberboard shipping container. A purchase unit will total 40,000 pounds (18,144 kg).

II. COMMODITY SPECIFICATIONS

A. Basic Requirements

1. Date Processed. The cooked and sliced turkey roasts (roasts/commodity) must not be processed prior to the date of the contract.

2. Class and Style. The commodity must be prepared from U.S. Grade A turkey roasts which were produced from young turkeys that conform to the definition for the class in 9 C.F.R. § 381.170 or in AMS § 70.202. Individual carcasses of turkeys must conform to definitions and standards found in 9 C.F.R. § 381.170 or AMS § 70.210.

3. Origin of Turkeys. Cooked and sliced roasts 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 products 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 products 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 USDA grader or other Government official(s) in accordance with Article 76 of USDA-1.

II.A.

4. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 C.F.R. Part 381) and be under the supervision of a representative of USDA's Food Safety and Inspection Service (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 C.F.R. Part 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*) under the supervision of a USDA grader. The USDA grader will be responsible for certification of compliance with the requirements of this Specification for ready-to-cook turkey products: preparation, formulation, and fabrication of turkey roasts; turkey roasts; cooking; slicing; packaging and packing; freezing; labeling and marking; sampling; net weight; and checkloading.

5. Product Temperature. Temperature of the products, unless otherwise specified, must comply with 9 C.F.R. § 381.66 and the FSIS Directive 7110.3 (Time/Temperature Guidelines For Cooling Heated Products) throughout all operations including transportation between plants.

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

7. Organoleptic Requirements. The chilled or frozen young turkey and turkey products will be examined on a continuous basis for the following organoleptic requirements: Chilled young turkey and turkey products must be free of rancidity; free of fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, chlorine, or other foreign or off-odors; free of foreign materials (e.g., glass, paper, rubber, metal); must show no evidence of mishandling or deterioration; and must have a bright color with no evidence of dehydration or freezing and thawing. Any turkey or turkey product that does not comply with the organoleptic requirements will be rejected for use under this Specification.

B. Preparation of Roasts

1. Sources of Meat.

a. Breast and thigh meat (meat) and skin must be from nonbasted (no solution or ingredients added), young turkeys and turkey parts. All preparation and processing of the finished commodity must be completed within 7 calendar days after the day the turkeys are slaughtered.

b. Chilled boneless breasts and thighs, meat, and skin from frozen turkeys may be used when: (1) The frozen turkeys have been packaged to protect them from freezer burn and dehydration during storage, (2) the turkeys have not been held more than 180 days in frozen storage and have been identified so the class of turkey can be determined, and (3) the

resultant boneless breasts and thighs, meat, and skin are processed into the roasts (without refreezing) within 48 hours from the time of deboning.

c. Frozen boneless breasts and thighs, meat, and skin 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 60 days in frozen storage. After thawing, the boneless breasts and thighs, meat, and skin must be used in the production of turkey roasts within 24 hours.

2. Turkey Products From Other Plants. Chilled and/or frozen turkey and turkey products may be transferred or obtained from other processing plants to produce roasts, provided they: (a) have been processed, handled, and identified in accordance with this Specification, and (b) comply with the organoleptic, nonbasted, and other applicable requirements for turkey products to be used in roasts as evidenced by a USDA certification.

a. Type, class, and specific name of the product, part, boneless part or meat; 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 products 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.

(1) Meat must be derived from the breast and thigh. Meat must be in recognizable portions; that is, whole, half, or quartered breasts, tenderloins, complete thighs, or thighs with no more than one-half of the meat missing. Scapula portion may be used, provided it is attached to the breast meat portion.

(2) Fatty blubber and spongy fat must be removed from the breast meat in the crop cavity.

(3) Mechanically separated turkey (comminuted, ground, chopped, or desinewed) cannot be used.

b. Skin.

(1) Skin must be used only to cover the outer surface of the roasts.

II.B.3.

(2) Skin for covering a roast may include the skin covering the crop area and the neck skin up to the whisker if the fatty blubber, spongy fat, and membranes have been removed from these areas.

c. Containers of breasts, thighs, meat, or skin must not contain added water (for example, water from ice or slush ice and water).

4. Defects. Boneless breasts and thighs, meat, and skin, as applicable, will be sampled and examined for compliance with the defect requirements shown in Table 1.

a. A sample of 10 pieces of each meat component and 10 pieces of skin will be sampled and examined for the defects shown in Table 1, prior to being used in the formula. The frequency of sampling and the number of defects allowed will be those outlined in Poultry Programs' Sample Plan Level 2 (SPL-2). Separate examinations will be made for: (1) bone and (2) other defects.

b. Regardless of the kind and number of defects (within Table 1) found, any sample with bone or bone-like material greater than 0.75 inch (1.91 cm) will be cause for the rejection of the product the sample represents.

c. If the number of bone defects exceeds an "accept" level for the respective sample number, or results in a rejection, the frequency of sampling for bone defects will be increased to 10 pieces of the meat or skin drawn twice each sampling interval until the cumulative number of bone defects reverts back to an "accept" level.

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

Table 1. Defects for Meat and Skin

<p>Meat Defects: Bone:</p>	<p>Bone or bone-like material greater than 0.75 inch (1.91 cm) (see II.B.4.b).</p> <p>Bone or bone-like material less than or equal to 0.75 inch (1.91 cm).</p>
<p>Other Meat Defects:</p>	<p>Cartilage, bruise, blood clot, fatty blubber and spongy fat from the crop cavity or areas of discolorations as described below.</p> <p>Any moderate discolorations.</p> <p>Lightly shaded discolorations exceeding an area equivalent to the area of a circle having a diameter of 0.50 inches (1.27 cm). Slight discolorations are permitted, regardless of the area, provided the discoloration does not detract from the overall appearance of the meat.</p>
<p>Skin Defects:</p>	<p>Feathers, blemishes, fatty blubber, spongy fat, membranes, or areas of discoloration as described below.</p> <p>Any moderate discolorations.</p> <p>Lightly shaded discolorations exceeding an area equivalent to the area of a circle having the diameter of 1.50 inches (3.81 cm). Slight discolorations are permitted on the skin, regardless of area, provided the discoloration does not detract from the appearance of the roast.</p>

5. Formula.

a. Formula. Proportions of ingredients required in preparing the commodity:

	<u>Percent of Total</u>
Breast meat (minimum)	47.0
Thigh meat (maximum)	33.0
Skin (maximum)	12.5
Water (maximum)	5.0
Salt (maximum)	1.0
Binder(s)	1.0
Sodium phosphates	<u>0.5</u>
	100.0

II.B.5.

(1) Except as otherwise specified, only the ingredients and the percentages of ingredients listed in the formulations above may be used. Formulated batches of all ingredients must equal 100 percent.

(2) The amount and kind of restricted phosphates must be limited to those contained in 9 C.F.R. § 381.147.

(3) Amount and kind of binders must be approved and prepared for use in accordance with 9 C.F.R. Part 381 and this Specification. The binder must be a modified starch(s).

(4) Additional breast meat may replace thigh meat. Additional breast meat or thigh meat may replace skin. The maximum percentage of thigh meat in the formulation may be exceeded if thigh meat replaces skin and minimum percentage of breast meat is maintained.

b. Formulated batches of ingredients which do not comply with II.B.5.a. will be rejected for use in the roasts.

c. USDA may select additional samples of packaged roasts to examine for compliance with formulation requirements prior to shipment or at destination.

6. Mixing.

a. Sodium phosphate, binder(s), and salt must be mixed with the water and added as a solution to the meat and skin, as applicable, during tumbling or massaging. Sodium phosphates must be thoroughly mixed with the water prior to the addition of the salt to the solution.

b. Salt, sodium phosphate, binder(s), and water must be incorporated into the meat by tumbling or massaging. Tumbling or massaging must be accomplished without deforming, shredding, mutilating, or breaking up the pieces of meat.

c. The maximum tolerance of moisture, salt, binder(s), and sodium phosphate applies to the raw meat portion of the commodity.

7. Meat and Skin Percentages for Turkey Roasts. The following percentages are required for meat and skin in each turkey roast prior to cooking, and include the amount of salt, binder(s), and sodium phosphates and the moisture pickup permitted during formulation, as applicable:

a. Tumbled or massaged.

(1) When both the meat and skin have been tumbled or massaged, 50.81 percent breast meat (minimum), 35.68 percent thigh meat (maximum), and 13.51 percent skin (maximum).

(2) When only the meat has been tumbled or massaged and the skin has not, 51.41 percent breast meat (minimum), 36.09 percent thigh meat (maximum), and 12.50 percent skin (maximum).

b. Substitution of thigh meat for skin. Where thigh meat has been substituted for skin, the maximum percentage of thigh meat permitted will be increased proportionately to the decrease in percentage of skin.

8. Hand and Mechanical Forming or Stuffing.

a. Roasts may be fabricated by hand or by mechanically forming or stuffing. The mechanical process must: (1) result in finished roasts with recognizable pieces of breast and thigh meat; and (2) be approved in writing by the Deputy Administrator of Poultry Programs. (Approval will be granted on an individual plant basis after a review of the process and when the resulting fabrication is found acceptable by supervisory personnel of the Grading Branch, Poultry Programs, AMS.)

b. For hand-formed or hand-stuffed turkey roasts, pieces of breast and thigh may be cut from the recognizable portions of meat and removed during fabrication of the roast to facilitate meeting the percentages of breast meat or thigh meat (see II.B.7.). One piece of breast and one piece of thigh may be cut from the recognizable portions of meat and added to the roast during fabrication to meet the percentages of breast meat or thigh meat (see II.B.7.).

9. Skin Coverage.

a. At least 50 percent of the outer surface of the roasts must be covered with skin. Skin must be uniformly distributed over the outer surface of the roast.

(1) Skin covering may overlap without limit in all areas provided: (a) the fatty tissue has been removed from the sternal and pectoral feather tracks, (b) the percentage of the skin does not exceed the maximum amount listed in the formula, and (c) the areas are smooth in appearance.

(2) When fat is not removed from the sternal and pectoral feather tracks, no overlapping is permitted in these particular areas.

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

II.

C. Raw Roast Requirements

1. Weight and Diameter Requirements. Raw roasts must comply with the following size requirements:

a. Weight. Each roast must weigh not less than 11 pounds (4.99 kg), and not more than 14 pounds (6.35 kg); and

b. Diameter. Each roast must measure between 4 and 8 inches (10.2 to 20.3 cm) in diameter.

2. Examination for Defects. Three raw roasts will be sampled and examined for the size (weight and diameter), exterior, and fabrication (meat and skin percentages) defects shown in Table 2.

a. The frequency of sampling and number of defects allowed will be as outlined in Poultry Programs' SPL-2.

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

c. USDA may select additional samples of fabricated roasts to examine for defects.

Table 2. Defects for Fabricated Roasts

Size Defects:	<p>A size defect for a fabricated roast is when the roast:</p> <p>Weighs less than 11 pounds (4.99 kg), or more than 14 pounds (6.35 kg).</p> <p>Measures less than 4 inches (10.2 cm), or more than 8 inches (20.3 cm) in diameter.</p>
Exterior Defects:	<p>Three or more feathers greater than 0.75 inches (1.91 cm) in length.</p> <p>Any moderate discolorations.</p> <p>Lightly shaded discolorations on the skin or meat exceeding an area equivalent to the area of a circle having a diameter of 1.50 inches (3.81 cm).</p>
Skin Coverage Defects:	<p>Less than 50 percent of the outer surface of the roast is covered with skin, or when the skin or skin coverage does not comply with II.B.9.</p>
Fabrication Defects:	<p>A fabrication defect for a roast is when:</p> <p>Both meat and skin are tumbled or massaged, and the percentage of breast meat is less than 50.81, the percentage of thigh meat is more than 35.68, or the percentage of skin is more than 13.51;</p> <p>Only the meat is tumbled or massaged, and the percentage of breast meat is less than 51.41, the percentage of thigh meat is more than 36.09, or the percentage of skin is more than 12.50; or</p> <p>The substitution of thigh meat for skin does not comply with II.B.7.</p>

3. Raw Turkey Roasts for Further Processing. Chilled (never frozen) fabricated raw roasts complying with the requirements of this Specification (sections I. through II.C.2.) may be delivered within the plant or to another destination for further processing provided the raw roasts are:

- a. Delivered to the plant in the chilled state at an internal product temperature of not lower than 26 °F (-3.3 °C) and not higher than 40 °F (4.4 °C); and
- b. Held at an internal product temperature of not lower than 26 °F (-3.3 °C) and not higher than 40 °F (4.4 °C) for not longer than 72 hours prior to cooking.

D. Cooking, Cooling and Slicing, and Finished Product Requirements

1. Cooking. After fabrication, the fabricated roast must be cooked in any type of package (as applicable) and by any method(s) approved by FSIS for this product to an internal temperature of 170 °F (76.7 °C). Cooking methods and product temperature will be

II.D.1.

monitored by FSIS personnel in accordance with FSIS procedures.

2. Cooling and Slicing.

a. Cooling. After cooking, roasts must be cooled in accordance with FSIS Directive 7110.3, and sliced (widthwise).

b. Slicing. Each slice must be 3-5 mm (0.30-0.50 cm) thick. Slice thickness will be verified according to procedures established by Poultry Programs.

3. Defects for Finished Roasts. Three cooked and sliced roasts will be sampled and examined for evidence of excessive heating (burnt or scorched).

a. The frequency of sampling and the number of defects allowed will be as outlined in Poultry Programs' SPL-2.

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

c. USDA may select additional samples of roasts to examine for this defect.

4. Cooked Roasts for Further Processing. Cooked roasts complying with the requirements of this Specification (sections I. through II.D.3.) may be delivered within the plant or to another destination for further processing provided the cooked roasts are held for not longer than 24 hours at an internal product temperature of not higher than 40 °F (4.4 °C) prior to slicing/packaging.

E. Metal Detection.

1. Requirements.

a. Each cooked and sliced roast must be examined by a metal detection device: (1) accepted by FSIS; and (2) capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips, metal fragments from cutting equipment, and pieces of wire.

b. The roast must be presented correctly within the detection field pattern of the device. Procedures used must be appropriate for the dimensions, location, and pattern of the detection field, the "orientation effect" on the sensitivity of the device, the environmental conditions, and the commodity.

2. Operating Efficiency and Procedures. The operating efficiency of the metal detection device will be determined hourly by the USDA grader by placing a detection strip with a sphere of 440 stainless steel in the center of the detection field pattern. Poultry

Programs' will provide the detection test strip with the stainless steel sphere of the specified diameter.

a. Roasts must be examined after slicing and/or packaging.

b. The USDA grader will use a detection test strip with a 3.00 mm (0.1181 inch) sphere for the examination of: (1) sliced or packaged roast, (2) roasts packed in a shipping container, or (3) a roast in an in-line system (with slicing equipment), as applicable, for the detection system.

3. Contaminated Product. These guidelines do not relieve the contractor of its responsibilities to provide a safe product. Product suspected of being contaminated with metal or found to be contaminated with metal will be handled in accordance with FSIS procedures.

4. Other Detection Procedures. Other procedures for examination of roasts or meat may be approved by the Deputy Administrator of Poultry Programs, in writing.

F. Packaging and Packing

1. Material Requirements. All packaging and packing materials must comply with the requirements of this Specification, be clean and in new condition, and must not impart objectionable odors or flavors to the commodity.

a. Plastic-film bags and casings. Packaging materials--plastic-film bags or casings--must be safe (cannot adulterate product or be injurious to health) for use in contact with food products. The safety of food contact packaging materials will be determined by FSIS according to the criteria and procedures in 9 C.F.R. § 381.144.

b. Shipping containers.

(1) Requirements. Shipping containers for roasts must: (a) be a fiberboard container; (b) be of such size to pack the product without slack filling or bulging; (c) protect the product against loss and damage; (d) withstand the variations in humidity and temperature during the conditions of use; and (e) have the combined facings weight, the bursting strength, and the compression strength (edge crush value) to withstand the stresses of handling, shipping, stacking, and storage.

(2) Container bottom. Flaps on the bottom of a shipping container must be securely fastened so the bottom remains securely fastened when the top of the container is opened.

II.F.1.

(3) Final closure. Final closure of the shipping containers for roasts must be secure and made with commercially acceptable filament-reinforced tape, plastic-film packaging tape, non-metallic strapping, adhesive, or other similar types of materials that are applicable for cold temperature storage conditions and that provide for safe handling of the commodity. Steel or wire straps must not be used for the final closure. Staples must not be used for the final closing of shipping containers. However, staples may be used to manufacture and to assemble the shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing product into the shipping containers.

2. Packaging and Packing.

a. Packaging.

(1) After slicing, the roast must be packaged in a plastic-film bag or casing (described in (2) below) and hermetically heat sealed.

(2) Bags or casings for packaging the commodity must be made of water-proof film with oxygen barrier properties. Bags and casings must be heat-shrinkable, and have: (a) low-temperature flexibility (not brittle) and durability to resist stress-cracking caused by the temperatures of freezing and frozen storage, and (b) the impact and tensile strength, and tear and abrasion resistance to protect the product from dehydration, freezer burn, quality deterioration or contamination during the conditions of use. Any seams in the bag or casing must provide the protective qualities equivalent to the body of the bag or casing.

b. Packing. Four packaged roasts must be packed in each shipping container.

G. Freezing

Cooked, cooled, sliced, and packaged roasts must be placed in a freezer and 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 roasts are not placed in a freezer immediately after packaging, the roasts must be held at a room temperature not higher than 36 °F (2.2 °C) and not lower than 26 °F (-3.3 °C). When packaged roasts are held at a room temperature below 26 °F (-3.3 °C), the roasts will be considered to be in a freezer and subject to the 72-hour freezing requirement which begins at the end of the shift the roasts enter the 26 °F (-3.3 °C) or lower facility.

III. LABELING

Labeling and marking of the product must be in accordance with this Specification. Labeling is subject to the provisions of 9 C.F.R. § 381.132(c).

Printed, stamped, and stenciled labeling and marking information on shipping containers and packaging materials must be water-fast, nonsmearing, of a contrasting color, clear, and readable. The name and address of the contractor/processor must not be shown on individual packages or shipping containers.

Any deviation from the labeling requirements in this Specification must be approved by the Contracting Officer, in writing, prior to start of production.

A. Packaged Roasts

The labeling information for packaged roasts must be legibly: (a) preprinted, stamped, or stenciled on each casing or bag; (b) printed using appropriate ink on an approved insert placed directly on the surface of the commodity that will be clearly seen through the hermetically sealed bags or casings; or (c) preprinted, stamped, or stenciled on a waterproof tag in water-fast, nonsmearing ink and securely attached to the sealing device of each casing or bag of commodity. The labeling and marking information must be as provided in EXHIBIT 1.

1. Nutritional Labeling. A nutritional label, indicating the nutrient content of the commodity, is required on each package of commodity. This nutritional facts information or "nutrition facts panel" must be in compliance with the FSIS nutritional labeling requirements found in 9 C.F.R. § 381.400(b) through § 381.499.

a. The contractor/processor must select one of the methods of providing the nutrition facts panel described in III.A.

b. NOTE: The nutrition facts information and panel must be pre-approved by FSIS prior to shipment of the commodity. The method of providing and location of this information for each package (III.A.) must be indicated on the FSIS label application. The pre-approved nutrition information must be provided to the USDA inspection personnel at the plant where the commodity is to be packed for shipment.

2. USDA Grade. The USDA grademark, "Prepared From U.S. Grade A Turkey Roasts" shown in EXHIBIT 1, must be shown on each package of commodity.

3. Universal Product Bar Code.

a. A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on each package and 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

III.A.3.

scanability of the bar code must be in accordance with UPC guidelines published by Uniform Code Council, Inc., 8163 Old Yankee Road, Suite J, Dayton, Ohio 45458.

b. The contractor will use the code furnished by USDA. USDA has acquired a unique manufacturer's identification number for the commodity purchase programs and will use a unique item code number for the commodity purchased under this Specification. The contractors need not join Uniform Code Council, Inc.

c. The 12-digit UPC code for individual packages of cooked and sliced turkey roasts is: 7 15001 01574 1

B. Shipping Containers

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

2. Labeling and Marking Information.

a. Requirements. Labeling and marking information must be preprinted, stamped, or stenciled on shipping containers. This information, in essentially the same layout, is provided in EXHIBIT 3, "Label Information for Shipping Containers of Cooked and Sliced Turkey Roasts."

b. "END" and "SIDE" designations. For the purpose of labeling and marking, the "end" and "side" panels may relate to the shortest and longest dimensions of the shipping container at the discretion of the contractor/processor. However, the panels must alternate between "end" panel and "side" panel designation with the two side panels and two end panels being located on opposite panels of the shipping container.

3. TOP PANEL - Labeling and Marking. The following information must appear on the top panel of each shipping container:

a. Type, name, and ingredients statement. The ingredients statement must also be printed on the top panel of the shipping container following the commodity type and name. Ingredients must be listed by proper name and order in accordance with 9 C.F.R. § 381.118.

Frozen Cooked And Sliced
TURKEY ROASTS

Ingredients:

III.B.3.

b. Storing instructions. The following storing instructions must be printed on the top panel of the shipping container:

PERISHABLE--KEEP FROZEN
KEEP AT ZERO DEGREE F (-17.8 °C) OR BELOW

c. Key points for handling commodities. Handling information is required on each shipping container of commodity. The "KEY POINTS FOR HANDLING" must be legibly printed on the top panel of each shipping container. This information, in essentially the same layout, is set out in EXHIBIT 3.

4. ONE END Panel - Labeling and Marking. The following information must appear on one end of each shipping container.

a. Commodity name. The words "COOKED AND SLICED TURKEY ROASTS" must be printed in letters at least 1 inch (2.54 cm) high on the "one end" designated panel of each shipping container.

b. USDA grade. The USDA grademark, "Prepared From U.S. Grade A Turkey Roasts" shown in EXHIBIT 3, must be shown on each shipping container of commodity.

c. Contract number, pack date, and net weight. The following information may be preprinted, stamped, or stenciled on the shipping containers, or on a separate pressure-sensitive label:

(1) Last five digits of the contract number as it appears in the acceptance wire.

(2) Date packed (month, day, and year).

(3) The following net weight statement must be completed and printed on each shipping container:

4 Roasts Net Combined Weight ___ LBS.

d. Inspection mark and plant number. The USDA inspection mark and USDA-assigned plant number must be printed on the "one end" designated panel of each shipping container.

III.B.4.

e. Storing instructions. The following storing instructions must be printed on the "one end" designated panel of each shipping container:

KEEP FROZEN

5. ONE SIDE Panel - Labeling and Marking. The following information must be printed **on the side panel immediately to the right of the "one end" panel** containing the information designated in III.B.4.:

a. Type, name, ingredients statement, and legend. The commodity type and name, ingredients statement, and the legend must be printed on the "one side" designate panel of each shipping container. Ingredients must be listed by proper name and order in accordance with 9 C.F.R. § 381.118.

FROZEN FULLY COOKED AND SLICED TURKEY ROASTS

Ingredients:

Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs.

Not To Be Sold Or Exchanged.

b. USDA symbol. The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height, and must be printed on the "one side" designated panel of each shipping container.

c. UPC code.

(1) A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5) (see III.A.3.), must be printed on the lower right-hand corner of the both side panels of the shipping container.

(2) The 14-digit UPC code for shipping containers of cooked and sliced turkey roasts is: 1 07 15001 01547 8

6. THE OTHER END Panel - Labeling and Marking. For each shipping container, the following information must appear on the end opposite the panel designated "one end:"

a. Name. The name of the commodity (see III.B.4.a.) must be printed on "the other end" designated panel of each shipping container.

b. USDA symbol. The USDA symbol (see III.B.5.b.) must be printed on the end opposite the panel designated "one end."

III.B.

7. THE OTHER SIDE Panel - Labeling and Marking. For each shipping container, the following information must appear on the side opposite the panel designated "one side:"

a. Type, name, and legend. The commodity type and name, and the legend (see III.B.5.a.) must be printed on the side opposite the panel designated "one side." **The ingredients statement is not required on this side of the shipping container for roasts.**

b. UPC code. The UPC code (see III.B.5.c.) must be printed on the lower right-hand corner of "the other side" designated panel of each shipping container.

8. 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 shipping container. The label must not: (a) contain the contractor or processor name and address, or (b) cover or conflict with the labeling requirements of this Specification.

C. 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 USDA 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 this Commodity Specification for Cooked and Sliced Turkey Roasts dated October 1999, comply or will comply with the terms of this Commodity Specification.

Name _____

Title _____"

One certification is adequate for all production under this Specification.

IV.A.2.

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 or closed packaging.

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 shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable Poultry Programs' sampling plan, the delivery unit will be rejected.

2. Net Weight. Net weight of each delivery unit will be determined by the test-weighting procedures of Poultry Programs.

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:

<u>Number of Shipping Containers in Lot</u>	<u>Number of Shipping Containers in a Sample</u>
1 - 3	All
4 - 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. Purchase or delivery unit. A purchase or delivery unit must total 40,000 pounds (18,144 kg) net. A weight variation of plus or minus 1 percent (39,600 to 40,400 pounds (17,962 to 18,325 kg)) is permitted on each delivery unit. USDA will pay the contractor for the amount of commodity delivered within the required weight range. Any delivery unit weighing less than 39,600 pounds (17,962 kg) net will be rejected.

c. Net weight determination. Net weight will be determined at origin.

d. Alternate net weight verification. As an alternative to test weighing at time of checkloading, the contractor may request on-line verification of net weights for the commodity. Upon receiving the request, a Federal-State supervisor, Grading Branch, Poultry Programs 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 Commodities

1. Visual Inspection. Frozen commodity showing evidence of weepage beyond the tolerance; or defrosting, refreezing, or freezer deterioration will be rejected for use under this Specification.

2. Internal Product Temperature.

a. Requirements. Internal product temperature of the 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 for use under this Specification.

b. Optional temperature verification. As an option to verifying internal product temperature of frozen commodities 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 C.F.R. Part 70, 9 C.F.R. Part 381, and this Specification, at the site of processing, both during and after processing and packaging. A USDA representative may select samples for laboratory analyses 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 required by Articles 54 and 55 of USDA-1 must be performed by a USDA 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 the 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

IV.C.2.

commodity must be evidenced by certificates issued by the USDA grader. The contractor must not ship the commodity unless informed by the USDA grader that the designated commodity to be shipped meets contract specifications.

V. UNITIZATION

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

A. Pallets

Pallets must be good quality, wood, 48 inches x 40 inches, nonreversible, flush stringer, and partial fourway 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.

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, the applicable Announcement and Invitation, and Articles 56, 57, and 64 of USDA-1, as amended by the Announcement. In addition, the contractor must adhere to the following provisions:

A. Contract Compliance Stamp

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

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

C. Loading and Sealing of Vehicles

Loading must be in accordance with good commercial practices and the sealing must be done at origin under the supervision of a USDA grader.

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 two destinations will not require separation by sealing each drop.

D. Delivery Notification

Notwithstanding the provisions of Article 56(c) of USDA-1, as amended by the applicable Announcement, 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 an in-plant delivery is made, the contractor must notify the appropriate resident USDA 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 USDA grader are also required for transfers in store.

3. Early Delivery. The contractor may deliver early upon approval of the KCCO. Approval may be obtained by telephoning (816) 926-6068. Approval is contingent on the recipient's concurrence to accept early delivery and upon the USDA grader being available to perform necessary checkloading and final acceptance duties.

VI.

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 USDA 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 Notices to Deliver (split deliveries) for two different destinations may be delivered on two 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 for frozen commodity, before or after delivery by a USDA grader on acceptable 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 USDA origin grader will make arrangements for destination examinations prior to delivery.

A. Commodity Requirements

Before acceptance by consignee, frozen commodity may be examined by a USDA 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

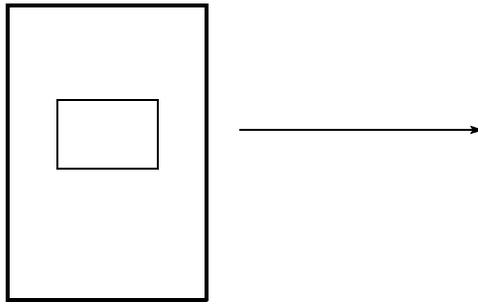
Frozen commodity must arrive at destination at an average internal product temperature not to exceed 10 °F (-12.2 °C), with no individual temperature exceeding 15 °F (-9.4 °C). Commodity not meeting these requirements will be rejected for use under this Specification.

D. Michael Holbrook
Deputy Administrator, Poultry Programs

Attachment

EXHIBIT 1
Label Information for Packaged Cooked and Sliced Turkey Roasts

Marking Information: Packages of frozen cooked and sliced turkey roasts must be marked as shown below. Markings must be legibly labeled as described in III.A. The UPC 12-digit code (7 15001 01547 1), bar and code, must be shown in the lower right hand corner of the package. The names of the ingredients must be shown.



Frozen Fully Cooked And Sliced Turkey Roast

Ingredients:

Prepared From

Turkey Roast



**Distributed by USDA in cooperation
with State and local or tribal governments
for food assistance programs.
Not To Be Sold Or Exchanged.**

Nutrition Facts Panel
To Be Placed
Here

Roasts are fully cooked, sliced, and ready-to-eat without further cooking.

Thaw Only Amount Needed For 1 Day's Use.
Do Not Thaw At Room Temperature Or In Water. Avoid Leftovers. DO NOT REFREEZE.

Reheating Directions: Reheat thawed or frozen at 325 °F (162.8 °C) to an internal product temperature of 165 °F (73.9 °C), in an uncovered pan. A sheet of foil may be placed over roast to prevent excessive browning.

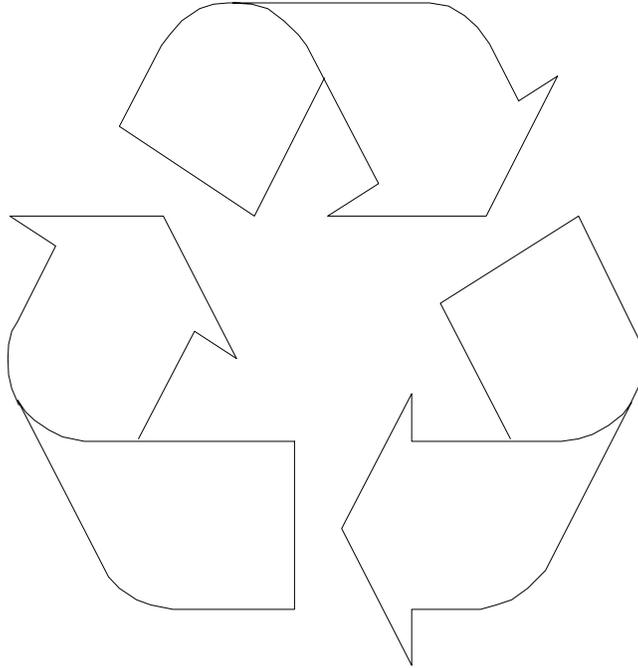
KEEP FROZEN

UPC Code

Contract No. _____
Date Packed Month, Day, Year

Net Weight: ___ LBS.

EXHIBIT 2
"Please Recycle" Symbol and Statement



**PLEASE
RECYCLE**

EXHIBIT 3

Label Information for Shipping Containers of Cooked and Sliced Turkey Roasts

Marking Information: Shipping containers shall be marked substantially as shown below. Markings must be preprinted, stamped, or stenciled on containers, water-fast, nonsmearing, of a contrasting color, clear, and readable. The words "COOKED AND SLICED TURKEY ROASTS," on each end, must be in letters at least 1 inch (2.54 cm) high. The USDA symbol is to be a minimum of 2.25 inches (5.72 cm) in height. The UPC 14-digit I 2/5 bar code (1 07 15001 01547 8) must be shown in the lower right-hand corner of both side panels. The recycle symbol and statement must be legibly printed somewhere on the surface of each recyclable shipping container.

<p>COOKED AND SLICED TURKEY ROASTS</p> 			
<p>FROZEN FULLY COOKED AND SLICED TURKEY ROASTS Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs. Not To Be Sold Or Exchanged. UPC Code</p>	<p>KEY POINTS FOR HANDLING COOKED AND SLICED TURKEY ROASTS</p> <p>Handle Properly To Avoid Spoilage Or Possible Food Poisoning.</p> <p>SORTING: Roasts are fully cooked, sliced, and ready-to-eat without further cooking. Roasts are marked with their own weight. Sort roasts by weight and diameter to facilitate thawing and reheating.</p> <p>THAWING: Leave roasts in original casings and place in single layer on sheet pans or trays. Thaw refrigerated at 36°F-45°F (2.2°C-7.2°C). Space pans on refrigerated shelves so air can circulate. Do not hold thawed roasts longer than 24 hours before reheating.</p> <p>Thaw Only Amount Needed For 1 Day's Use. Avoid Leftovers. Do Not Thaw At Room Temperature Or In Water. DO NOT REFREEZE.</p> <p>REHEATING: Remove from casings. Put roasts, thawed or frozen, in uncovered pan. (A sheet of foil may be placed over roasts to prevent excessive browning.) REHEAT COOKED ROASTS AT 325 °F (162.8 °C) TO AN INTERNAL TEMPERATURE OF 165 °F (73.9 °C).</p> <p>The Diameter Can Affect The Reheating Time More Than The Weight. The Greater The Diameter, The Longer The Reheating Time.</p>	<p>Frozen Cooked And Sliced TURKEY ROASTS</p> <p>Ingredients:</p> <p>SERVING: Serve hot or cold as an entree, in sandwiches or salads, or in any recipe specifying cooked turkey. Refrigerate any leftovers and use within 2 days. For recipes, see PA-1371, "Quantity Recipes for School Food Service."</p>	<p>FROZEN FULLY COOKED AND SLICED TURKEY ROASTS Ingredients: Distributed by USDA in cooperation with State and local or tribal governments for domestic food assistance programs. Not To Be Sold Or Exchanged. UPC Code</p> 
	<p>PERISHABLE--KEEP FROZEN</p> <p>KEEP AT ZERO DEGREE F (-17.8 °C)</p> <p>OR BELOW</p>		
<p>COOKED AND SLICED TURKEY ROASTS</p> <p>KEEP FROZEN</p> <p>4 Roasts Net Combined Weight ___ LBS.</p>		<p>Prepared From  Turkey Roast</p> <p></p> <p>CONTRACT NO. _____ DATE PACKED Month, Day, and Year</p>	

