

**FEDERAL PURCHASE
PROGRAM SPECIFICATION
(FPPS) FOR HAM PRODUCTS,
CURED, BONELESS,
FULLY COOKED, FROZEN
OR CHILLED**

Agricultural Marketing Service (AMS)
Livestock, Poultry and Seed (LPS) Program
Food Safety and Commodity Specification (FSCS) Division
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Supersedes: FPPS for Ham Products, Cured, Boneless, Fully
Cooked, Frozen or Chilled February 2014 – changes from
previous requirements in [blue](#)

Effective: March 2015

100 ITEM DESCRIPTION

- 110 Bulk Ham, Cured, Boneless, Fully-Cooked, Water Added, Frozen or Chilled – For material numbers 100184 and 100186, four 10-pound hams will be snugly packed into shipping containers to a net weight of 40 pounds. For material number 100182, twelve 3-pound hams will be snugly packed into a shipping container to a net weight of 36 pounds. The bulk packaged hams will be round or oval shaped and have a diameter of 4.0 to 4.5 inches.
- 120 Sliced Ham, Cured, Boneless, Fully-Cooked, Water Added, Frozen –Thinly sliced (not shaved) ham (material numbers 100187 and 100891) shall be shingle layered and packaged. For material number 100187, eight 5-pound packages will be snugly packed into shipping containers to a net weight of 40 pounds. For material number 100891, twenty 2-pound packages will be snugly packed into shipping containers to a net weight of 40 pounds. The full intact slices shall be round or oval shaped with a diameter of 4.0 to 4.5 inches, or square shaped with dimensions of 4X4 or 4X6 inches.
- 130 Items described in **Sections 110** and **120** shall be 97 percent fat free (3 percent fat), minimum Protein Fat Free (PFF) value of 17.0 percent, and have a whole muscle appearance (not ground or chopped), uniform color (slightly two tone color is permissible), no spongy (porous texture) appearance (after thawing of frozen ham).
- 140 Diced Ham, Cured, Boneless, Fully-Cooked, Frozen – The product shall be 97 percent fat-free and have a minimum PFF value of 15.0 percent. This item (material number 100188) is recommended for use as a topping for pizza, salads, omelets and as a component for soups, stews, and casseroles. Eight 5-pound packages will be snugly packed into shipping containers to a net weight of 40 pounds. The dices shall be ¼-inch cubes and may be made from ground or chopped and formed ham.

200 CHECKLIST OF REQUIREMENTS

210 All items must be produced in accordance with Food Safety and Inspection Service (FSIS) regulations and the AMS Checklist of Requirements listed below.

300 MATERIALS

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

320 MEAT COMPONENT

321 Pork (shall be derived from suitable lean from any portion of the sow and/or hog carcass) will be the only meat component allowed. Pork derived from boars is not permissible.

322 Domestic Origin of Meat Component – All sows and/or hogs will originate from U.S. produced livestock as defined in the [Master Solicitation](#) and Supplement.

323 Harvesting (Slaughtering) – All sows and/or hogs will be harvested in facilities that comply with the following requirements:

323.1 Humane Handling – All sows and/or hogs will be humanely handled in accordance with all applicable FSIS regulations and AMS requirements.

323.2 Non-Ambulatory Disabled Animals – Meat from carcasses of non-ambulatory disabled livestock will not be included in USDA Purchase Programs.

324 Boneless Pork Legs – Hams will be derived from boneless pork legs that comply with the following requirements:

324.1 Traceability – Contractors are responsible for providing sufficient product traceability and must have records to verify the source of raw materials used in each lot of product.

324.2 Handling – All boneless pork legs must be maintained in excellent condition. The contractor's technical proposal shall include detailed production scheduling with time and temperature controls necessary to maintain excellent condition of the boneless pork legs.

324.3 Fresh Chilled Only – Meat will be derived from fresh chilled boneless pork legs. Previously frozen boneless pork legs cannot be used.

324.4 Uniform Color – To the extent possible, pork leg muscles should be sorted for color uniformity.

324.5 Lean Quality – The pork leg muscles must not exhibit any evidence of pale, soft, and/or exudative conditions.

- 324.6 Shanks and Inner Shanks – If used, shanks and inner shanks must be ground, emulsified, or otherwise reduced in size.
- 324.7 Objectionable Materials – Pork legs will be free of bones, cartilages, skins, spinal cord, and foreign materials.
- 324.8 Ground Meat – Pork leg trimmings (including shank meat and rework) that are ground, emulsified, or otherwise reduced in size cannot exceed 7 percent of the meat component.
- 324.9 Rework - If used, rework must be derived from finished ham product intended for delivery to USDA, not be associated with any positive pathogen test and be included as a component of the ground meat (see **Section 324.8**) while not exceeding a level of 2 percent based on finished product weight.
- 325 Mechanical Separation – Meat that is mechanically separated from bone with automatic deboning systems, advanced lean (meat) recovery (AMR) systems, or powered knives will not be allowed.

330 NON-MEAT COMPONENTS

- 331 All non-meat components will be listed in the ingredient statements.
- 332 Domestic Origin – Significant ingredients (more than 1 percent) shall be derived from U.S. produced products.
- 333 Product Formula – The production formula must include water, dextrose, salt, sodium phosphate, antimicrobial agent(s) and sodium nitrite. Sodium erythorbate, and/or sodium ascorbate, may be used.
- 334 Ingredient Limitations – The ingredients in the product formula must comply with the amounts as listed:
 - 334.1 Material Number 100182:
 - 334.1.1 Dextrose – No more than 3%
 - 334.1.2 Salt – No more than 2.5%
 - 334.1.3 Sodium Phosphate – No more than 0.5%
 - 334.2 Material Numbers 100184, 100186, 100187, 100188 and 100891
 - 334.2.1 The product formulation(s) shall be developed such that the prescribed finished product limitations (see **Sections 500 - 561**) are met.
- 335 Binder Agent – Binder agents such as carrageenan, modified food starch, and isolated soy protein may be used.

400 PROCESSING

410 PROCESSING DATE

411 Ham products, as delivered to AMS destinations, will be processed no more than 60 days prior to shipment.

420 CASING DIAMETER / DIMENSION

421 Bulk Packaged Ham - All bulk packaged hams will be stuffed and processed within high oxygen and high moisture barrier poly "cook-n-ship" casings with a diameter of 4.0 to 4.5 inches. Ham then may be pressed.

422 Sliced and Diced Packaged Ham - All sliced and diced packaged hams will be stuffed and processed within high oxygen and high moisture barrier poly "cook-n-ship" casings with a diameter of 4.0 to 4.5 inches or square shaped with dimensions of 4X4 or 4X6 inches. Ham then may be sliced or diced and repackaged (see **Section 712.2**).

430 PRODUCT COOKING

431 Ham will be fully cooked in accordance with FSIS regulations.

440 METAL DETECTION

441 All hams must be free of metal contamination. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required. The equipment, location, detection procedure, sensitivity levels, frequency of equipment validation, and corrective action procedures will be identified and described.

500 FINISHED PRODUCT LIMITATIONS

510 Fat and protein-fat-free label declarations shall comply with FSIS labeling regulations.

520 FAT

521 The contractor will target production to maintain a process average for fat content to be 3.0 percent or less. The contractor will use a Statistical Process Control (SPC) program to analyze fat test results. The SPC Upper Specification Limit (USL) is 3.6 percent fat. The average test results of each production lot exceeding the USL will not be allowed delivery to USDA. For the purpose of this section, a lot cannot exceed one day's production.

530 PROTEIN FAT FREE (PFF)

531 The contractor will target their production to maintain the PFF values as specified with the item description.

540 SODIUM

541 Material Number 100182:

541.1 The product formulation shall be developed such that the prescribed ingredient limitations (see **Section 334.1**) are met.

542 Material Numbers 100184, 100186, 100187, 100188 and 100891:

542.1 The sodium level shall not exceed 700 mg per 100 g serving.

542.2 $((\text{Declared Sodium Level (mg)} \times 100) \div \text{Declared Serving Size (g; racc)} \leq 700)$

550 MICROBIAL

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

560 PHYSICAL CHARACTERISTICS

561 Since one or more freeze/thaw cycles will cause moisture loss and affect quality, hams shall not appear spongy or porous in texture after freezing and thawing. Diced hams will be processed to minimize 'clumping' so that it is easily removed from bags by the end user without completely thawing.

600 STATE OF REFRIGERATION

610 Hams must comply with the following holding time and temperature requirements:

620 HOLDING TIME

621 Frozen Ham Products – After processing, ham destined for freezing will be refrigerated for a minimum of 24 hours. The diced ham will be frozen in a manner to minimize 'clumping' after freezing.

630 HOLDING TEMPERATURE

631 Frozen Hams (material numbers 100184, 100182, 100187, 100188, 100891) – Hams destined for freezing will have an internal temperature not to exceed 40°F prior to placement in the freezer.

632 Chilled Hams (material number 100186) – Chilled hams will be maintained at a temperature of not less than 28°F (2.2°C) or higher than 40°F (4.4°C).

640 72 HOURS TEMPERATURE

641 Frozen hams must be 0°F or below within 72 hours after placement into the freezer.

700 PREPARATION FOR DELIVERY

710 PACKAGING

711 Package – All bulk packaged hams will be stuffed and processed within poly "cook-n-ship" high oxygen and high moisture barrier casings. Sliced, shingle layered hams and diced hams will be packaged into bags or thermoformed packaging and vacuum sealed. All packages will be closed by heat seal or metal clips.

712 Package Net Weight

712.1 Bulk Ham – For material number 100182, ham will be packaged into casings to a net weight of 3 pounds. For material numbers 100184 and 100186, ham will be packaged into casings to a net weight of 10 pounds.

712.2 Sliced and Diced Hams – For material numbers 100187 and 100188, ham product will be vacuum packaged or thermoformed vacuum packaged to a net weight of 5 pounds. For material number 100891, ham product will be vacuum packaged or thermoformed vacuum packaged to a net weight of 2 pounds.

720 PACKING

721 Bulk Ham – For material number 100182, twelve, 3-pound hams will be snugly packed into a new shipping container to a net weight of 36 pounds. For material numbers 100184 and 100186, four 10-pound hams will be snugly packed into a new shipping container to a net weight of 40 pounds.

722 Sliced or Diced Hams – For material numbers 100187 and 100188, eight 5-pound packages will be snugly packed into a new shipping container to a net weight of 40 pounds. For material number 100891, twenty 2-pound packages will be snugly packed into a new shipping container to a net weight of 40 pounds.

730 LABELING^{1/}

731 The shipping containers will be in compliance with the National Motor Freight Classification, or the Uniform Freight Classification, as applicable. Both immediate (packaging material) and shipping containers will be labeled to include all information required by FSIS regulations.

^{1/}All labeling illustrations must be provided in the contractors' technical proposal.

- 732 10-Pound Ham, 5-Pound Sliced and Diced Hams Immediate Container Labels (casings or package) – Each immediate container is required to have a traceability code that is traced back to establishment number, production lot, and date.
- 733 3-Pound Ham and 2-Pound Sliced Immediate Container Label (casings or package) – Each immediate container will contain the following information:
- 733.1 A traceability code that is traced back to establishment number, production lot, and date.
- 733.2 A “Best-If-Used-By” date that is 180 calendar days from the date of production.
- 733.3 Nutrition facts panel based on actual nutritional analysis of the product.
- 734 Shipping Container Label – Shipping containers will contain the following information:
- 734.1 USDA shield at least 2 inches high and appearing on the top of the container or on the principal display panel.



- 734.2 Appropriate purchase order number.
- 734.3 A traceability code that is traced back to establishment number, production lot, and date.
- 734.4 Ingredient declaration.
- 734.5 A nutrition facts panel based on actual nutritional analysis of the product.
- 734.6 10-Pound Ham, 5-Pound Sliced and Diced Hams shipping containers shall have the statement “for institutional use only”.

734.7 The appropriate product name and material number listed in the table below for each of the items.

<u>Item</u>	<u>Material Number</u>
10 lb. Bulk Ham, Cured, Boneless, Fully Cooked, Water Added, Frozen	100184
10 lb. Bulk Ham, Cured, Boneless, Fully Cooked, Water Added, Chilled	100186
3 lb. Bulk Ham, Cured, Boneless, Fully Cooked, Water Added, Frozen	100182
5 lb. Sliced Ham, Cured, Boneless, Fully Cooked, Water Added, Frozen	100187
5 lb. Diced Ham, Cured, Boneless, Fully Cooked, Frozen	100188
2 lb. Sliced Ham, Cured, Boneless, Fully Cooked, Water Added, Frozen	100891

734.8 An allergen statement in a format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains _____.

740 CLOSURE

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

750 PALLETIZED UNIT LOADS

751 All product shall be stacked on new or well-maintained pallets and palletized with shrink wrap plastic, unless otherwise specified in the solicitation. Pallet loads shall be stacked in a manner that minimizes the overhang of the shipping containers over the edges of the pallets and exposes each shipping container's principal display panel to facilitate certification examinations.

800 DELIVERY UNIT

810 The delivery units for each of the following respective material numbers are as follows:

820 MATERIAL NUMBERS 100184, 100186, 100187, 100188, 100891

821 Each delivery will consist of 1,000 shipping containers with a net weight of 40,000 pounds.

830 MATERIAL NUMBER 100182

831 Each delivery will consist of 1,000 shipping containers with a net weight of 35,940 - 36,000 pounds.

900 DELIVERED PRODUCT

910 SIZE AND STYLE OF CONTAINER

911 Only one size and style of immediate (casings) and shipping containers may be offered in an individual shipping unit.

920 TEMPERATURE

921 Chilled Ham Temperature – Chilled ham will be delivered at a temperature of not less than 28°F (2.2°C) or greater than 40°F (4.4°C).

922 Frozen Ham Temperature – All products will be frozen and will not exceed 0°F at the time of shipment and delivery.

930 SEALING

931 All products must be delivered to AMS destinations under seal. Seals shall be serially numbered, barrier-type and meet the American Society for Testing and Materials (ASTM) standards (F-1157-04) and/or the International Organization for Standards (ISO) 17712-2010. Seals shall be 1/8th-inch diameter cable, high-security bolt, or equivalent.

1000 PRODUCT ASSURANCE

1010 WARRANTY AND COMPLAINT RESOLUTION

1011 Warranty – The contractor will guarantee that the product complies with all contractual requirements required under this Supplement.

1012 Complaint Resolution – The contractor’s technical proposal must provide steps taken to resolve complaints received on the product (i.e. point of contact, cause and effect analysis, corrective and preventative actions taken, and product replacement).

1020 NON-CONFORMING PRODUCT

1021 The contractor must have documented procedures that assure nonconforming product identification, segregation, and disposition in order to prevent misuse and that nonconforming product is not delivered to USDA. The plan must address 1) control and segregation of non-conforming product, 2) removal of any USDA markings, and 3) disposition of non-conforming product, including vendor notification in writing to the FSCS Division of final disposition (e.g., diverted to commercial production, cooked or destroyed).

1030 CONTRACTOR CHECKLOADING

- 1031 Contractor will perform checkloading examinations at the time of shipment and issue a contractor's certificate to accompany each shipment that includes all of the following information:
- 1031.1 Purchase Order Number/Purchase Order Line Item Number;
 - 1031.2 Sales Order Number/Sales Order Line Item Number;
 - 1031.3 Destination of shipment;
 - 1031.4 Name of Product and applicable Material Number;
 - 1031.5 Shipping Date;
 - 1301.6 Production lot number(s) and date each lot was produced along with shipping container and immediate container code(s) and the code used that provides traceability to establishment number, production lot and date;
 - 1301.7 Count of shipping containers and total projected net weight in each production lot;
 - 1031.8 Identity of car or truck (car numbers and letters, seals, truck license, etc.) as applicable;
 - 1301.9 Contractor certification that product conforms with the applicable specification (FPPS-HP-2015);
 - 1031.10 Count and projected net weight verified and;
 - 1301.11 Signature of company official responsible for checkloading.