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Program

Specialty
Crops
Inspection
Division

Condition of Food Container Manual

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Condition of Food Container Manual
Table of Contents

Introduction.....	1
Guide for Electronic Usage.....	1
General.....	2
Inspection Procedure.....	4
Application for Inspection Service	4
Applicant’s Responsibility	5
Inspection.....	6
Applying Procedures – Stationary Lot.....	12
Other than Origin Inspection AQL’S.....	15
Condition of Glass Containers - Guideline for Scoring Loose Caps	15
Clarification regarding Primary and Secondary Container Designation in the U.S. Standards for Condition of Food Containers.....	15
Recording Information and Results on Container Examination Worksheets	16
Attachments.....	19

INTRODUCTION

This manual is provided to Specialty Crops Inspection (SCI) Division inspection personnel to promote uniformity in the inspection of the condition of food containers. The procedures contained in this manual are an integral part of Division services. If needed, contact your immediate supervisor for any situation not addressed in this manual.

This manual contains links to various internal and external sources of information. For inspection personnel without internet or intranet access, please contact your immediate supervisor to obtain hard copies of documents as needed.

GUIDE FOR ELECTRONIC USAGE

The Administrative, Inspection, and Management (AIM) System of instructional manuals is available electronically in Adobe Acrobat Portable Document Format (PDF) at the following intranet address: <http://agnis/sites/FV/PPB/AIM/default.aspx>.

When accessed electronically, AIM materials have hyperlinks and hypertext (visible as underlined [blue text](#)) available to the PDF user. Clicking on a hyperlink takes the reader to a web site with information relating to the subject. Hypertext will link the reader to a different page within the current manual - or even a different manual - with information relating to the subject. For example, the hypertext in the Table of Contents allows a reader to go directly to the section of interest in the manual by clicking on the section title within the Table of Contents.

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GENERAL

The U.S. Standards for Condition of Food Containers cover procedures for stationary lot, skip lot, and on-line sampling and inspection. Note that internal container defects are now included as part of the Standards.

The U.S. Standards for Condition of Food Containers, as supplemented by these instructions and any specific instructions from the receiver, will be used when a government agency or private user of federal inspection service requests examination of the exterior of food containers for condition. The request may be verbal or in writing, and may be made using one of several forms. It may be a specific request in a U.S. Department of Agriculture purchase document, or a general request to verify that a food product was packaged in accordance with “good commercial practices.” The Standards apply to all types of food containers used as primary containers, secondary containers, or shipping cases. The U.S. Standards for Condition of Food Containers, which are located in the Code of Federal Regulations (CFR), at 7 CFR 42, may be found at the following internet address:

<http://www.gpo.gov/fdsys/browse/collectionCfr.action?collectionCode=CFR>.

The U.S. Standards for Condition of Food Containers include definitions of terms, sampling plans, defect classifications, and acceptance criteria. However, the Standards don't fully address the administrative details of application. This instruction provides additional details and guidelines to assure uniform application of the Standards. If needed, the respective inspection service may issue supplemental instructions for details that are not fully covered either by the Standards or this instruction.

To provide maximum assistance to inspectors, the procedures in these instructions follow a sequence appropriate for most situations, starting with the inspection request and continuing through to a decision on whether the lot meets or fails to meet the requirements of the Standards. These instructions contain some material not directly related to the Standards to provide more thorough coverage of the principles involved in determining the condition of food containers.

Formal condition of container inspection refers to examining the exterior of filled food containers as outlined in the U.S. Standards for Condition of Food Containers.

When a formal condition of container inspection has been made of a lot, any certification of this lot must include the result of the condition of container examination.

Informal condition of container inspection refers to examining the exterior and interior of the sample units drawn for quality for scoreable defects. It also includes the overall visual appearance of the sampled lot.

A. Governmental Procurement (Federal, State, County, City) Federal Agencies

Formal condition of container inspections will be made of all lots.

B. Commercial

An informal condition of container inspection will be made unless a formal condition of container is specifically requested by the applicant or the U.S. Standards for Food Container are referenced in purchase specifications.

Informal condition of container examination is made by removal of the labels from cans and overwraps from fiberboard cartons that have been drawn for quality sample units. Classify and record applicable defects on exterior of container.

Classify and record applicable interior defects. Refer to Table I for acceptance and rejection numbers. Advise the applicant that any scorable defects will be recorded on the certificate of quality and condition.

All lots case stamped must have a formal condition of container inspection.

Visual aids for use in determining the condition of food containers are available at the following internet address: <http://www.ams.usda.gov/AMSV1.0/processedinspection>. In the “Processed Inspection Services” section in the middle of the page, click on the “Grading and Inspection Resources” link, then, under the “Processed Products Division Resources” section click on the “Visual Aids” link, then go to the “Visual Aids for Condition of Containers” section and click on the “Visual Aids for the Inspection of Containers” link. There you will find links to visual aids for:

- Metal Containers,
- Glass Containers,
- Flexible Containers, and
- Rigid and Semi-Rigid Containers.

INSPECTION PROCEDURE

The U.S. Standards for condition of food containers, 7 CFR 42, may be found at the following internet address: <http://www.gpo.gov/fdsys/browse/collectionCfr.action?collectionCode=CFR>. See 7 CFR 42.103 of the Standards for stationary lot, 7 CFR 42.120 for skip lot, and 7 CFR 42.130 for on-line sampling and inspection procedures.

Application for Inspection Service

Requests for inspection are generally directed to the appropriate inspection office by telephone. In some instances the inspector may be at the plant or warehouse on a sampling job, and may be asked to check additional lots, or the inspection office may receive a copy of the contract from a food broker, and contact the vendor to arrange for inspection.

Details regarding inspection should be recorded on the following worksheet forms or a suitable application form. This information then becomes a part of the inspection records.

The following AD forms are available as fillable PDF's may be found on the USDA Office of the Chief Information Officer web site at the following address:

<http://www.ocio.usda.gov/policy-directives-records-forms/forms-management/approved-computer-generated-forms>

Form #	COC Table	Type of container
AD-3061	TABLE IV	METAL CONTAINERS
AD-3062	TABLE V	COMPOSITE CONTAINERS
AD-3063	TABLE VI	GLASS CONTAINERS (Bottles, Jars)
AD-3064	TABLE VII	PLASTIC CONTAINERS (Rigid and Semi-Rigid Bottles, Jars, Tubs, Trays, Pails, etc.)
AD-3065	TABLE VIII	RIGID and SEMI-RIGID CONTAINERS (Excluding Metal, Glass, and Plastic)
AD-3066	TABLE IX	FLEXIBLE CONTAINERS

Information generally requested and recorded is:

- A. Date and hour of application.
- B. Name and address of the applicant and the receiver.
- C. Name of person requesting the inspection.
- D. Name of the person to be informed of the results.
- E. Name of the packer.
- F. Name and address of the warehouse.
- G. Location of the lot(s), (i.e., aisle, bay, etc.) if known.
- H. Pertinent information concerning the lot(s) such as lot number, railroad car number, contract order numbers, length of storage, shipping deadlines, etc.
- I. The number, type, and size of containers, and label (if labeled).
- J. Codes and the approximate number of cases of each.
- K. Inspection status; i.e., initial; or if reoffered, has the lot been previously inspected? If so, by whom, what were the results, and has the lot been reconditioned?
- L. The basis of the inspection, i.e., Commercial Item Description, Federal specification, purchase contract, etc.
- M. Deviations from the Standards, such as origin inspection AQL's other than 0.25, 1.5, and 6.5, and special defects not covered by the Standards.
- N. Mutually agreed upon time to perform the inspection.

Applicant's Responsibility

It is the applicant's responsibility to make certain that full cooperation is given to inspectors performing the inspections. Cooperation includes, but is not limited to:

- A. Arranging all containers so they are readily accessible for sampling.
- B. Providing all necessary labor and equipment for handling the product.
- C. Supplying adequately lighted facilities.
- D. Re-casing of product involved in the inspection.

Inspection

A. Preparation

The supervisor should inform the inspector about any abnormal conditions likely to be encountered or of any unusual precautions that should be taken in handling the assignment. The supervisor should also notify the inspector if the lot is to be inspected under procedures for normal, tightened, or reduced inspection.

For the inspector, it's worthwhile to spend a few minutes assembling working tools, and studying the inspection request, the contract, and any other pertinent documents prior to leaving for the assignment. This can prevent delays and errors in handling the inspection. Timing can be an important consideration for packers, and as a courtesy, the inspector should arrive as scheduled, ready to get started. If a delay in is anticipated, the applicant should be notified as soon as possible.

Materials and Equipment

Prior to performing the condition inspection, the inspector should determine that applicable materials and equipment are available and in good working condition. Such material and equipment may include the following:

1. A copy of the U.S. Standards for Condition of Food Containers and a copy of these instructions.
2. Visual aids for the containers being inspected.
3. Worksheets for recording defects.
4. Flashlight or auxiliary lighting.
5. Tools for opening shipping containers (knife, wire cutters, etc.)
6. Clean hand towels or other similar material.
7. "Officially Sampled" roller stamp when required.
8. Marking pen or pencil.
9. Cold weather gear for freezer work.
10. Measuring device such as a ruler or tape measure.

B. Initial Contact

Upon arrival at the plant or warehouse, the inspector should identify him or herself, contact the appropriate responsible person, and review the purpose of the visit. Note any undue delay in performing the inspection on the application form.

C. Lot Identity

Inspection lots must be properly identified for the inspector to carry out inspection duties. Reasons for such identification:

1. Examined containers can be verified to be the same as reported by the applicant.
2. Lots inspected can be associated with related reports and certificates.
3. Subsequent inspections (if requested) of reconditioned or reworked lots can be differentiated from originally inspected lots.

Inspection lots shall be identified by commodity (type and style), number, size, and type of container, including:

1. Code or other identification marks.
2. Label or case marks.
3. Warehouse receipt or lot number.
4. Warehouse location, including room, stack or row, aisle number or letter, and proximity to a permanent object such as door, wall, window, or office.

D. Preliminary Inspection (Scanning)

After the lot has been properly identified, the inspector should perform an actual count in each lot to verify the reported count. While scanning the lot, determine if any segments or portions appear abnormal, as with sweating cans, wet cases, blown cans, top layer rust, leakers, critical abnormalities, etc. If such segments or portions are noted, the lot should be rejected for condition of container.

If the lot is rejected prior to sampling, it cannot be subsequently inspected until the lot has been reconditioned. If no abnormal portions are observed, samples may be drawn to determine condition.

E. Sample Procedure

1. Sample Size

From previous inspection records on worksheet (Form AD-749), determine inspection status, i.e., normal, tightened, or reduced. If no inspection records are available, use normal inspection. However, if the inspection is a re-inspection of a previously rejected lot that has been reconditioned, use tightened inspection.

Determine the number of primary containers in the lot. Locate in the Standards, 7 CFR 42.109 through 42.111, (which may be found at the following internet address:

<http://www.gpo.gov/fdsys/browse/collectionCfr.action?collectionCode=CFR>) the approximate lot size in Table I or IA for normal inspection, II or IIA for tightened inspection, or III or IIIA for reduced inspection. Select the proper sample size corresponding to the appropriate lot size. A larger sample size may be used when approved by the Administrator or when requested by the applicant and approved by the Administrator.

2. Drawing Samples

As indicated in the Standards, containers may be drawn either according to proportional random sampling or according to simple random sampling. If the number of containers per code mark is known, proportional sampling is preferred. Regardless of the procedure followed, samples must be representative of all portions of the lot. This will generally require a complete breakdown of the lot in order for all portions to be accessible for sampling. (See your supervisor on the use of random inspection numbers.)

Predetermine and identify the containers or cases from which containers will be drawn. All horizontal and vertical layers in a stack should have an equal chance of being represented. If the containers are cased, predetermine how many to draw from each case selected and which containers to select. Examine no more than the maximum number of samples permitted in § 42.105(e) of the Standards. These predetermined plans for selecting cases and containers will eliminate bias due to accessibility of containers and readily visible defects.

Sometimes a defective container is observed which falls outside the predetermined sampling pattern. This container must not be purposely selected just because it's defective, it should be drawn only if it falls in the predetermined pattern. However the inspector should recommend that obviously defective units be removed from the lot and be replaced. This recommendation should be made for any defective container appearing in the sample, even though the lot is found to be acceptable. There will also

be instances in which defective containers are localized. For example, the entire top layer of a stack may show water damage and contain rusted cans, or the front of a stack may show extensive fork lift damage. In these instances, identify the sample units with the respective portions of the lot to properly inform the applicant of the condition if reconditioning is in order.

The recommended sampling plans in Table IA, IIA, and IIIA of the Standards are double plans. Double sampling plans provide for the examination of two sets of samples, a first set and a second set. There are acceptance and rejection criteria indicated for the first set, and if needed, for the total (first plus second) sample sets. The first sample set is examined first and a decision made to accept, reject, or continue the inspection by drawing and examining the second sample set. Ordinarily, the second set is not be drawn unless the lot could not be accepted or rejected based on the results of examining the first sample set. However, there may be circumstances in which it would be desirable to draw both the first and second samples on the initial sampling of the lot. In such instances, the examination of the second sample should be held, pending the outcome of the examination of the first sample.

Occasionally lots offered for inspection have portion(s) with severely limited accessibility. Under these circumstances, examination is restricted to samples drawn from the accessible portion of the lot, and the sample size is based on the number of containers available for examination.

See [AIM Inspection Series Sampling and Certification Manuals](#) for further information on restricted sampling and related certification procedures.

F. Classifying and Recording Defects

Each sample container shall be examined carefully under adequate lighting to insure that all defects are noted. The inspector may refuse inspection for condition of containers until such lighting is provided. To assist in the proper classification of the defects, refer to the visual aid appropriate for the particular kind of containers. Be careful to distinguish between “related” and “unrelated” defects - only the more serious “related” defect is recorded.

Defects may be present that are not categorized within the Standards; or purchase specifications may require that containers be examined for defects not classified in the Standards. If present, these defects shall be classified according to their severity, and the results incorporated into the acceptance and rejection criteria. Such defects shall be specified on worksheets in the “other” or blank block.

Each defect shown in Tables IV, V, VI, VII, VIII and IX in Sections 42.112 and 42.113 of the Standards, 7 CFR 42 (which may be found at the following internet address:

<http://www.gpo.gov/fdsys/browse/collectionCfr.action?collectionCode=CFR>) is serially numbered according to the applicable defect category as follows: Critical 1, 2, 3, etc.; Major 101, 102, 103, etc.; and Minor 201, 202, 203, etc.

Record the number and type of defects on the worksheet (Form AD-3061, AD-3062, AD-3063, AD-3064, AD-3065, AD-3066, or other forms as approved by the Administrator), using the appropriate columns to identify each category of defect; i.e., critical, major, or minor. If a second sample must be examined to classify the lot, record each set of samples so they can be separately identified on the worksheet. Total the number of defects in each of the above categories.

G. Guidelines for Interior Defects

The U.S. Standards for Condition of Food Containers and certain sections of the Standard specify that formal examinations for condition will be restricted to the exterior portion of containers. However, interior defects inside the containers seen during the inspection process cannot be disregarded, even though the lot may be acceptable based on external defects, as outlined in the U.S. Standards.

Section 42.114 contains procedures for evaluating interior container defects. Interior defects are described in Table XII and Table XIII indicates the appropriate Acceptance (Ac) and Rejection (Re) numbers for interior defects found in quality samples. Inspectors need to completely remove the lids of containers in the samples to examine their interior. Containers should be rinsed with hot water and let air dry completely prior to making a final judgment on scorable defects.

Although acceptable by U.S. Standards for Condition of Food Containers (Exterior), Deliveries to Federal or State agencies will be failed if interior defects equal or exceed the rejection (Re) numbers in Table XIII.

At the request of the applicant, the lot may be re-inspected using the applicable sampling plan in the U.S. Standards for Food Containers, and all the sample units opened for interior examination.

Commercial lots for which a formal condition of container examination is performed and found acceptable by the U.S. Standards for Condition of Food Containers will not subsequently fail these U.S. Standards if the interiors of the quality sample units show defects. Interior defects will be reported separately in the "Remarks" section of the certificate. See the [AIM Inspection Series, Certification Manual](#) for additional instructions.

H. In-Plant Inspection

The procedure for condition of container inspections is the same under in-plant inspection as under lot inspections, so is the policy regarding its applicability and certification procedures.

Unofficial or informal examinations should be made daily based on in-line samples according to criteria in these U.S. Standards and AMS Instructions. Adverse conditions in packing, packaging and storage, and evidence of defects on in-line samples should be reported to the management and noted on DIR's. It is particularly important that packers be advised of apparently failing lots prior to offering these lots for delivery to Federal or State agencies so that the costs of reconditioning or segregation may be considered.

I. Appeal Inspections

The U.S. Standards for Condition of Food Containers do not permit reinspection of rejected lots prior to reconditioning or segregation of rejected portions. AMS Instructions similarly prohibit such reinspections. However, at the applicant's request, an appeal inspection may be made of the prior to segregation or reconditioning in accordance with Division policy.

In addition to granting an appeal inspection, the officer-in-charge or supervisor may review samples with the inspector and applicant in order to verify the interpretation of defects. If it is apparent that the inspector was unduly critical in classifying defects, the lot may be re-evaluated for acceptance.

J. Reinspections

Request for reinspections for condition of container are normally made by a receiving activity (USDA or DLA) for items at a destination location.

The following procedures will apply:

1. Sampling will be in accordance with sample plans for normal condition of container, Table I.
2. Type of plan - Single plans only.
3. Sample size - One size higher than the minimum required by the lot size being inspected.
4. AQL - Use AQL's for "Other than Origin Inspection" (Critical 0.25; major 2.5; total 10.0).

K. Lot Acceptance Criteria

1. Stationary Lot

The acceptability of stationary lots is determined by referring to the table of sampling plans used. For a given sample size, acceptance and rejection numbers are provided for critical, major, and total defects. Total defects include not only critical and major defects, but also any minor defects.

Unless otherwise specified, AQLs for origin inspection shall be 0.25, 1.5, and 6.5 for critical, major, and total defects, respectively.

Refer to the appropriate acceptance (Ac) and rejection (Re) numbers for the first sample set.

- a. If the sum of the critical, major, or total defects does not exceed “Ac,” the lot is considered acceptable. The acceptance number does not represent the number of defects that the sample should contain, but rather is the maximum number of defects permitted in a sample in order to consider a lot as meeting a specific requirement.
- b. If the sum of the critical, major, or total defects equals or exceeds “Re,” the lot fails.
- c. If the sum of the critical, major, or total defects exceeds “Ac,” but is less than “Re,” a second sample set is evaluated. The sum of each class of defects in the combined sample is compared with the acceptance and rejection numbers in the table for each AQL, and a positive decision is made to either accept or fail the lot.

2. On-line Lot

In many instances, food containers are loaded directly into carriers immediately after final packaging. This situation makes stationary lot sampling and inspection impractical. For such circumstances, the optional procedure for on-line sampling and inspection using cumulative sum sampling plans is provided.

For details on how to perform this type of inspection, see section 42.130 in the Standards, 7 CFR 42 (which may be found at the following internet address:

<http://www.gpo.gov/fdsys/browse/collectionCfr.action?collectionCode=CFR>). For any additional questions, contact your immediate supervisor.

Applying Procedures – Stationary Lot

Example: A lot contains 2,000 cases of 24 No. 2 pint jars, or 48,000 total containers. The lot is to be inspected under normal inspection procedures. The lot is over 36,000 containers, so sampling plan code CD in Table I-A of the Standards is applicable. The first sample set is 228 containers as indicated under “Sample Size” opposite code CD.

All 228 containers are examined and found to contain 15 minor, 4 major, and no critical defects, for a total of 19 defects. The lot can neither be accepted nor rejected on this sample for major or total defects because:

- 4 defects fall between $Ac = 3$ and $Re = 9$ for major defects (AQL = 1.5)
- 19 defects fall between $Ac = 15$ and $Re = 24$ for total defects (AQL = 6.5)

Therefore, a second sample set (288 containers) is examined, and the additional critical, major, and minor defects found are added to those found in the first sample. The defects found in the 516 containers total 33 minor, 9 major, and 1 critical, for a total of 43 defects.

The 1 critical, 9 major, and 43 total defects are all equal to or less than the acceptance (Ac) numbers of 3, 12, and 43 respectively; therefore the lot is accepted.

Had the number of defects for any of the classes exceeded the applicable acceptance number however (for example, had the defects totaled 44 or more), the lot would FAIL condition of container requirements.

See the next page for this example recorded on the Container Examination Worksheet.

U.S. DEPARTMENT OF AGRICULTURE CONTAINER EXAMINATION WORKSHEET TABLE VI – GLASS CONTAINERS (Bottles, Jars)	PRODUCT <i>Canned Green Beans</i>	TYPE AND SIZE OF CONTAINER <i>24/No. pint jars</i>
	LOT NO. 3	LOT SIZE* <i>48,000 jars</i>
	CONTRACT NO. <i>123456789</i>	
Name and Address of Applicant <i>Heartland Packers, Inc.</i> <i>Heartland, WI</i>	INSPECTION STATUS OF LOT* <input checked="" type="checkbox"/> ORIGINAL <input type="checkbox"/> RESUBMITTED	INSPECTION POINT <i>Plover, WI</i>
CODES AND APPROXIMATE NO. OF CONTAINERS PER CODE* See attached Certificate of Sampling.		
*As stated by applicant.		

SAMPLING PLAN USED	No. of Sample Units	CRITICAL		MAJOR		TOTAL <i>(Minor, Critical, and Major Defects)</i>		
		AQL: 0.25 <i>If other specify _____</i>		AQL: 1.5 <i>If other specify _____</i>		AQL: 6.5 <i>If other specify _____</i>		
		Ac	Re	Ac	Re	Ac	Re	
<input checked="" type="checkbox"/> Normal CODE <u>CD</u>								
<input type="checkbox"/> Tightened	First Sample	228	0	3	3	9	15	24
<input type="checkbox"/> Reduced	Second Sample	288						
	Total Sample	516	3	4	12	13	43	44

Defect No.	Type of Defect	1 st Sample	2 nd Sample	Defect No.	Type of Defect	1 st Sample	2 nd Sample
	Type or size of container or component parts not as specified	NONE PERMITTED		2	Bird swing (glass appendage inside container)		CRITICAL
1	Closure not sealed, crimped, or fitted properly (a) Heat processed	CRITICAL		3	Broken or leaking container		CRITICAL
101	(b) Non-heat processed	MAJOR		207	Cap (non-heat processed): (a) Cross-threaded		Minor
201	Dirty, stained, or smeared container	Minor		208	(b) Loose but not leaking		Minor
202	Chip in glass	Minor		106	(c) Pitted rust		MAJOR
203	Stone (unmelted material) in glass	Minor		4	Cap (heat processed); Cross-threaded or loose		CRITICAL
204	Pits in surface of glass	Minor		107	(b) Pitted rust		MAJOR
205	Sagging surface	Minor		209	Sealing tape or cell band (when required): (a) Improperly placed		Minor
206	Bead (bubble within glass): (a) 1/8 inch to 1/16 inch in diameter	Minor		108	(b) Not covering juncture of cap and glass		MAJOR
102	(b) Exceeding 1/8 inch in diameter	MAJOR		109	(c) Ends overlap by less than 1/2 inch		MAJOR
103	Checked	MAJOR		110	(d) Loose or deteriorating		MAJOR
104	Thin spot in glass	MAJOR		111	Missing or torn outer safety seal		MAJOR
105	Blister (structural defect)	MAJOR		112	Inner safety seal - missing, torn, poor seal		MAJOR

TABLE XI – LABEL, MARKING, OR CODE

101	Not specified method	MAJOR		202	Torn or mutilated	Minor	
102	Missing (when required)	MAJOR		203	Text illegible or incomplete	Minor	
103	Torn or scratched, obliterating any marking on the label	MAJOR		204	In wrong location	Minor	
104	Incorrect	MAJOR		OTHER (Specify)			
201	Loose or improperly applied	Minor					

	Minor	Major	Critical	Total	ACTION TAKEN BASED ON FIRST SAMPLE
First sample	15	4	0	19	<input type="checkbox"/> LOT ACCEPTED <input type="checkbox"/> LOT REJECTED <input checked="" type="checkbox"/> SECOND SAMPLE
Second sample	18	5	1	24	ACTION TAKEN ON SECOND SAMPLE (If required) <input checked="" type="checkbox"/> LOT ACCEPTED <input type="checkbox"/> LOT REJECTED
Grand total	33	9	1	43	

DATE INSPECTED <i>January 29, 2013</i>	SIGNATURE OF INSPECTOR (Print and Sign Name) Jared King <i>Jared King</i>
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EXAMPLE (passing lot)

OTHER THAN ORIGIN INSPECTION AQL'S

Other Than Origin Inspection AQL's are applicable when performing a re-inspection of a reconditioned lot, or when specifically requested by a financially-interested party.

When the inspector performs a re-inspection, the procedure for applying Other Than Origin Inspection AQL's is as follows.

The defective portion of the lot should be segregated before the remaining portion of the lot is offered for re-inspection. The defective portion may be reconditioned or reworked, and offered as a "new" lot for inspection. Whenever the inspector is requested to perform a re-inspection, the applicable sampling plan for tightened inspection is to be used.

Unless otherwise specified by the purchaser, the AQL's used for respective classes of defects shall be those contained in Lot Acceptance Criteria, 7 CFR 42.107(b), which are 0.25 for critical, 2.5 for major, and 10.0 for total.

CONDITION OF GLASS CONTAINERS - GUIDELINE FOR SCORING LOOSE CAPS

Table VI - Glass Containers, of the U.S. Standards for Condition of Food Containers lists "Loose but not leaking" caps as a minor defect, number 208.

If a cap or lid is obviously loose it shall be scored as a defect. Unless otherwise specified in a contract, purchase announcement, or specification, the following guideline may be used to determine tightness of closure on questionable containers:

Bring the container to between 65 - 75 degrees F. Place the container upright on top of a stable, level surface. Grasp the sides of the cap firmly with fingertips and turn cap gently-clockwise with a minimum of downward pressure for complete revolution. If cap turns and the container remains stationary, a defect shall be scored. This is only a guideline, if a cap or lid is obviously loose it shall be scored as a defect.

CLARIFICATION REGARDING PRIMARY AND SECONDARY CONTAINER DESIGNATION IN THE U.S. STANDARDS FOR CONDITION OF FOOD CONTAINERS

Primary containers are inspected visually for all recordable defects. The primary container is defined in the U.S. Standards for Condition of Food Containers as "The immediate container in which the product is packaged and which serves to protect, preserve, and maintain the condition of the product. The primary container may be metal, glass, fiber, textile, plastic, paper, or any other suitable type of material, and may be supplemented by liners, overwraps, or other protective material." Usually the primary container is in direct contact with the product. An exception to this would be a fiberboard case or metal drum which contains a poly liner. The liner is in contact with the product, but the case or drum is considered the primary container.

Examples of primary containers:

1. A plastic 2.5 lb. bag of frozen green beans;
2. A plastic vacuum sealed 30 lb. bag of frozen apricots;
3. A metal beaded bodied #10 can of pineapple;
4. A new 30 lb. plastic pail filled with frozen 5+1 red tart pitted cherries;
5. A 20 lb. fiber board case with poly liner of frozen lima beans; and
6. A poly lined 55 gallon drum of concentrated apple juice.

The secondary container is defined in the U.S. Standards for Condition of Food Containers as “The container in which one or more primary containers are packaged. For example, a shipping case containing canned product.” The secondary container is not in direct contact with the product, but rather is used to protect, preserve, and maintain the condition of the product or primary containers of the product during transit or storage. An example would be a shipping case (secondary container) containing canned peas (primary container).

When performing condition of container examinations, examine both the primary and secondary containers (as applicable) using the U.S. Standards for Condition of Food Containers and applicable visual inspection aids.

RECORDING INFORMATION AND RESULTS ON CONTAINER EXAMINATION WORKSHEETS

In the box titled *Type and Size of Container* describe the type and size of the actual primary containers or in the case of secondary container inspection the secondary containers examined.

PRODUCT		TYPE AND SIZE OF CONTAINER <i>6- # 10 cans</i>	
LOT NO.	LOT SIZE*	CONTRACT NO.	

In the box titled *Codes and Approximate No. of Containers per Code* list the primary container codes and approximate number of containers or specify the number of secondary containers. If there are multiple codes contained in the lot it is acceptable to reference an attached document for a complete list of codes. See the [example](#) shown on page 14 of this manual.

INSPECTION STATUS OF LOT *		INSPECTION POINT	
<input type="checkbox"/> ORIGINAL	<input type="checkbox"/> RESUBMITTED		
CODES AND APPROXIMATE NO. OF CONTAINERS PER CODE <i>M2431 (1008 cases) and M2441 (1008cases).</i>			

In the box titled *Sampling Plan Used* mark the inspection status used – Normal, Tightened or Reduced and record the sampling plan and its code as it appears in the Standards.

SAMPLING PLAN USED		No. of Sample Units
<input checked="" type="checkbox"/> Normal	CODE <u>CC</u>	
<input type="checkbox"/> Tightened	First Sample	168
	Second Sample	180
<input type="checkbox"/> Reduced	Total Sample	348

If other than origin AQL's are used, they must be specified.

CRITICAL	MAJOR	TOTAL <i>(Minor, Critical, and Major Defects)</i>
AQL: <u>0.25</u> <i>If other specify _____</i>	AQL: 1.5 <i>If other specify <u>2.5</u></i>	AQL: 6.5 <i>If other specify <u>10.0</u></i>

Results are recorded on condition of container worksheets. When the condition of container examination for a lot is accepted or rejected based on the first sample, the instructions state “List the number of defects found in all samples. If only the first sample is used, do not fill in the grand total.” It is Division policy to draw a line through any tally box not filled in during the inspection process. Draw lines through the empty tally rows entitled “Second Sample” and “Grand Total” at the bottom of the condition of container worksheet - see example below. This will maintain the integrity of the inspection, and reduce the potential for future alterations to the worksheet.

Example:

	MINOR	MAJOR	CRITICAL	TOTAL
First sample	<u>7</u>	<u>2</u>	<u>0</u>	<u>9</u>
Second sample	<u>_____</u>	<u>_____</u>	<u>_____</u>	<u>_____</u>
Grand total	<u>_____</u>	<u>_____</u>	<u>_____</u>	<u>_____</u>
DATE INSPECTED <u>5/19/10</u>				

If a second sample is needed, total all defects from the 1st and 2nd samples in the “Grand total” row.

An example of a lot FAILING Condition of Container examination is shown on the next page.

U.S. DEPARTMENT OF AGRICULTURE CONTAINER EXAMINATION WORKSHEET TABLE VI – GLASS CONTAINERS (Bottles, Jars)	PRODUCT <i>Canned Green Beans</i>	TYPE AND SIZE OF CONTAINER <i>24/No. pint jars</i>
	LOT NO. 3	LOT SIZE* <i>48,000 jars</i>
	CONTRACT NO. 123456789	
Name and Address of Applicant <i>Heartland Packers, Inc.</i> <i>Heartland, WI</i>	INSPECTION STATUS OF LOT* <input checked="" type="checkbox"/> ORIGINAL <input type="checkbox"/> RESUBMITTED	INSPECTION POINT <i>Plover, WI</i>
CODES AND APPROXIMATE NO. OF CONTAINERS PER CODE* See attached Certificate of Sampling.		
*As stated by applicant.		

SAMPLING PLAN USED	No. of Sample Units	CRITICAL		MAJOR		TOTAL <i>(Minor, Critical, and Major Defects)</i>		
		AQL: 0.25 <i>If other specify _____</i>		AQL: 1.5 <i>If other specify _____</i>		AQL: 6.5 <i>If other specify _____</i>		
		Ac	Re	Ac	Re	Ac	Re	
<input checked="" type="checkbox"/> Normal CODE <u>CD</u>								
<input type="checkbox"/> Tightened	First Sample	228	0	3	3	9	15	24
<input type="checkbox"/> Reduced	Second Sample	288						
	Total Sample	516	3	4	12	13	43	44

Defect No.	Type of Defect	1 st Sample	2 nd Sample	Defect No.	Type of Defect	1 st Sample	2 nd Sample
	Type or size of container or component parts not as specified	NONE PERMITTED		2	Bird swing (glass appendage inside container)	CRITICAL	
1	Closure not sealed, crimped, or fitted properly (a) Heat processed	CRITICAL		3	Broken or leaking container	CRITICAL	
101	(b) Non-heat processed	MAJOR		207	Cap (non-heat processed): (a) Cross-threaded	Minor	
201	Dirty, stained, or smeared container	Minor		208	(b) Loose but not leaking	Minor	
202	Chip in glass	Minor		106	(c) Pitted rust	MAJOR	
203	Stone (unmelted material) in glass	Minor		4	Cap (heat processed); Cross-threaded or loose	CRITICAL	
204	Pits in surface of glass	Minor		107	(b) Pitted rust	MAJOR	
205	Sagging surface	Minor		209	Sealing tape or cell band (when required): (a) Improperly placed	Minor	
206	Bead (bubble within glass): (a) 1/8 inch to 1/16 inch in diameter	Minor		108	(b) Not covering juncture of cap and glass	MAJOR	
102	(b) Exceeding 1/8 inch in diameter	MAJOR		109	(c) Ends overlap by less than 1/2 inch	MAJOR	
103	Checked	MAJOR		110	(d) Loose or deteriorating	MAJOR	
104	Thin spot in glass	MAJOR		111	Missing or torn outer safety seal	MAJOR	
105	Blister (structural defect)	MAJOR		112	Inner safety seal - missing, torn, poor seal	MAJOR	

TABLE XI – LABEL, MARKING, OR CODE

101	Not specified method	MAJOR		202	Torn or mutilated	Minor	
102	Missing (when required)	MAJOR		203	Text illegible or incomplete	Minor	
103	Torn or scratched, obliterating any marking on the label	MAJOR		204	In wrong location	Minor	
104	Incorrect	MAJOR		OTHER (Specify)			
201	Loose or improperly applied	Minor					

	Minor	Major	Critical	Total	ACTION TAKEN BASED ON FIRST SAMPLE
First sample	16	4	0	20	<input type="checkbox"/> LOT ACCEPTED <input type="checkbox"/> LOT REJECTED <input checked="" type="checkbox"/> SECOND SAMPLE
Second sample	20	5	1	24	ACTION TAKEN ON SECOND SAMPLE (If required) <input type="checkbox"/> LOT ACCEPTED <input checked="" type="checkbox"/> LOT REJECTED
Grand total	36	9	1	46	

DATE INSPECTED January 29, 2013	SIGNATURE OF INSPECTOR (Print and Sign Name) Jared King <i>Jared King</i>
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EXAMPLE (failing lot)

Attachments**Version Date**
(Printed for distribution)

- 7 CFR 42:** _____
<http://www.gpo.gov/fdsys/browse/collectionCfr.action?collectionCode=CFR>.
- Visual aids for use in determining the condition of metal food containers:** _____
<http://www.ams.usda.gov/AMSV1.0/processedinspection>.
- Visual aids for use in determining the condition of glass food containers:** _____
<http://www.ams.usda.gov/AMSV1.0/processedinspection>.
- Visual aids for use in determining the condition of flexible food containers:** _____
<http://www.ams.usda.gov/AMSV1.0/processedinspection>.
- Visual aids for use in determining the condition of rigid and semi rigid food containers:** _____
<http://www.ams.usda.gov/AMSV1.0/processedinspection>.

Checked Materials have been printed from the links in this Manual and included for reference.