



Agricultural Marketing Service

Commodity Specification

DELI-STYLE TURKEY BREASTS AND DELI-STYLE SMOKED TURKEY BREASTS

APRIL 2013

Table of Contents

I. GENERAL	1
A. Product Description	1
B. Food Defense Requirements	1
C. Commodity Complaints	2
D. Humane Handling.....	2
II. COMMODITY SPECIFICATIONS	2
A. Basic Requirements	2
1. Date Processed	2
2. Origin of Turkeys	2
3. Inspection	2
4. FSIS Requirements	3
5. USDA Sampling Option	3
6. Definition of a Lot	3
B. Meat and Skin.....	3
1. Sources of Meat.....	3
2. Turkey from Other Plants	3
3. Requirements for Meat and Skin	4
Table 1. Organoleptic Requirements and Defects for Meat and Skin	7
C. Processing.....	7
1. Processing and Size Reduction.....	7
2. Requirements for Size-Reduced Meat	8
Table 2. Organoleptic Requirements and Defects for Size-Reduced Meat	8
3. Processing Sequence.....	9
4. Formulation.....	9
5. Mixing	11
6. Stuffing into Casings.....	11
7. Smoking.....	11
8. Cooking.....	11
9. Cooling.....	11
10. Packaging and Packing Materials	11
11. Packaging and Packing.....	12
12. Freezing	12
D. Metal Detection.....	12
E. Finished Product Requirements	13
1. Fabrication.....	13
2. Weight Requirements.....	13
3. Defects.....	13
Table 3. Organoleptic Requirements and Defects for Finished Deli-Style Turkey Breast and Deli-Style Smoked Turkey Breast.....	14
4. Reworked Commodity	14
III. LABELING	15
A. Commercial Labeling Requirements for Deli-Style Turkey Breast and Deli-Style Smoked Turkey Breast.....	15
1. Commercial Labels.....	15
2. Traceable Product.....	15
3. Nutrition Facts, Ingredients, and Allergen Statements on Shipping Containers	15
B. USDA Labeling Requirements for Deli-Style Turkey Breast and Deli-Style Smoked Turkey Breast Individual 9- to 11-pound (4.08 to 4.99 kg) USDA Labeled Packages.....	16
C. USDA-Labeled Shipping Containers.....	16
1. Labeling and Marking Information.....	16
2. Recycle Symbol and Statement.....	17
3. Inventory Control Information.....	17
D. Use of Previously Printed USDA Labeling Materials	17
E. Additional Labeling Issues	18

F. Free Along Side (FAS) Vessel Deliveries.....	18
IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY	18
A. Material and Net Weight Compliance	18
1. Verification of Materials and Defects.....	18
2. Net Weight	19
B. Prerequisites for Loading and Shipping Frozen Commodity	20
1. Visual Inspection	20
2. Internal Product Temperature	20
C. Inspection and Checkloading.....	21
1. Requirements	21
2. Procedures	21
V. UNITIZATION	21
A. Pallets	21
B. Pallet Exchange	21
VI. SHIPMENT AND DELIVERY.....	21
A. Contract Compliance Stamp.....	22
B. Grading Certificate	22
1. Railcar or Piggyback	22
2. Trucks.....	22
C. Loading and Sealing of Vehicles	22
1. Railcar	23
2. Truck or Piggyback	23
D. Delivery Notification.....	23
1. In-Plant Deliveries	23
2. Delivery in Storage.....	23
E. Split Deliveries	23
VII. DESTINATION EXAMINATION.....	23
A. Commodity Requirements.....	23
B. Temperature	24
EXHIBIT 1 USDA-Labeled Shipping Containers.....	25
EXHIBIT 2 USDA Label Information for Deli-Style Turkey Breast	26
EXHIBIT 3 USDA Label Information for Deli-Style Smoked Turkey Breast	27
EXHIBIT 4 “Please Recycle” Symbol and Statement	28
USDA SYMBOL.....	29

I. GENERAL

A. Product Description

Frozen fully cooked deli-style turkey breast (deli turkey breast) and deli-style smoked turkey breast (smoked turkey breast) produced under this Specification will be packaged and packed in one of the following forms as specified in the contract:

Deli-Style Turkey Breast - Frozen fully cooked deli-style turkey breast, produced from non-basted, young ready-to-cook chunked and formed turkey breast meat. Each deli turkey breast must be vacuum packaged in a shrinkable oxygen and moisture proof bag or casing, and be packed eight 4- to 6-pound (1.18 to 2.72 kg), or four 9- to 11-pound (4.08 to 4.99 kg) deli turkey breasts per fiberboard shipping container.

(100884) - No less than 4 pounds (1.18 kg) and no more than 6 pounds (2.72 kg) vacuum packed deli-style turkey breast. A purchase unit will total 40,000 pounds (18,144 kg).

(100121) - No less than 9 pounds (4.08 kg) and no more than 11 pounds (4.99 kg) vacuum packed deli-style turkey breast. A purchase unit will total 40,000 pounds (18,144 kg).

Deli-Style Smoked Turkey Breast - Frozen fully cooked deli-style smoked turkey breast, produced from non-basted, young ready-to-cook chunked and formed turkey breast meat. Each smoked turkey breast must be vacuum packaged in a shrinkable oxygen and moisture-proof bag or casing, and be packed eight 4- to 6- pound (1.18 to 2.72 kg), or four 9- to 11-pound (4.08 to 4.99 kg) smoked turkey breasts per fiberboard shipping container.

(Inactive) - No less than 4 pounds (1.18 kg) and no more than 6 pounds (2.72 kg) vacuum packaged deli-style smoked turkey breast. A purchase unit will total 40,000 pounds (18,144 kg).

(100122) - No less than 9 pounds (4.08 kg) and no more than 11 pounds (4.99 kg) vacuum packaged deli-style smoked turkey breast. A purchase unit will total 40,000 pounds (18,144 kg).

B. Food Defense Requirements

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

Marketing Service (AMS) Auditor immediately upon request. Verification of the Food Defense Program at the processing, storage, and distribution facility will be conducted by the USDA, AMS Auditor.

C. Commodity Complaints

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

D. Humane Handling

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

II. COMMODITY SPECIFICATIONS

A. Basic Requirements

1. Date Processed. The deli turkey breast or smoked turkey breast (commodity) must not be processed more than 90 calendar days prior to the first date of the delivery period.

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

3. Inspection. Processing operations must comply with Poultry Products Inspection Regulations (9 CFR part 381) and be under the supervision of a representative of USDA, FSIS (Inspector). Inspection for Specification compliance will be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 CFR part 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*) under the supervision of a Grader. The Grader will be responsible for certification of compliance with the requirements of this Specification for ready-to-cook turkey carcasses and parts; preparation, formulation, and fabrication of turkey breast; cooking and cooling deli turkey breast; smoking, cooking, and cooling smoked deli turkey breast; packaging and packing; freezing; labeling and marking; sampling; net weight; and checkloading.

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

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

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

B. Meat and Skin

1. Sources of Meat.

a. Chilled meat. The commodity must be produced from boneless, skinless turkey breast meat from non-basted, ready-to-cook young turkeys in accordance with AMS part 70.202. The chilled deboned meat must be used in the commodity within 7 calendar days after the date of slaughter.

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

c. Frozen meat and skin. Frozen breast meat and skin may be used when: (1) produced from freshly slaughtered non-basted turkeys; (2) packaged to protect against quality deterioration during storage and identified so the time in storage and the class, kind, and specific deboned turkey product can be determined; and (3) held not more than 180 days in frozen storage. After tempering, the meat and skin must be processed within 48 hours. The temperature of the meat and skin must not exceed 40 °F (4.4 °C) during the tempering process.

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

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

b. The chilled and/or frozen turkey carcasses and parts must be maintained 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. Requirements. All skin must be removed from each part or meat portion.

b. White turkey meat and skin. The following kinds of boneless, skinless breast meat and skin, in the amounts specified, must be used to prepare the raw turkey portion (meat block) of the commodity:

(1) Breasts. Boneless, skinless, outer pectoral whole, half, or quartered breasts must be used in the commodity in accordance with II.B.3.b.(5).

(2) Optional - tenderloins. Whole or half tenderloins with tendons removed may be used in the commodity in accordance with II.B.3.b.(5).

(3) Optional - breast trim. Boneless breast meat that is trimmed or removed from the turkey breast or tenderloin during the boning and trimming process, otherwise known hereafter as breast trim, may be used in the commodity in accordance with II.B.3.b.(5). Skin must be removed from the breast trim prior to use in the formula.

(4) Optional - skin. Skin may be used in the commodity in accordance with II.B.3.b.(5). Skin covering the crop area and the neck skin up to the whisker may be included if the fatty blubber, spongy fat, and membranes have been removed from these areas.

(5) Meat block. The total amount of size-reduced breast meat and skin (meat block) must represent not less than 90 percent of the total weight of the formula (II.C.4.).

(a) The total size-reduced **meat block** (see II.B.3.b(5)(b)) must consist of the following:

Boneless skinless breasts (II.B.3.b.(1)) -	<i>no less than 81 percent;</i>
Tenderloins, tendons removed (II.B.3.b.(2)) -	<i>no more than 9 percent;</i>
Breast trim (II.B.3.b.(3)) -	<i>no more than 10 percent; and</i>
Skin (II.B.3.b.(4)) -	<i>no more than 5 percent.</i>

(b) If the amount of optional products (tenderloins, breast trim and/or skin) is decreased or eliminated from the specified **meat block** (II.B.3.b.(5)(a)), the minimum percentage (or maximum percentage, as applicable) of boneless, skinless breast meat and tenderloins must be increased proportionally to the decrease in percentage of the optional product.

c. Unacceptable meat. The following cannot be used in the commodity:

(1) mechanically separated turkey, or

(2) turkey wing meat

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

e. Cooling requirements. Meat and skin, which are not used in the commodity on a continuous basis, must be continuously lowered in temperature to ensure that the internal product temperature is not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C).

f. Cooling medium.

(1) Cooling methods and media (e.g., use of carbon dioxide (CO₂) or liquid nitrogen (N₂)) may be used to maintain the temperature of meat or skin.

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

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

h. Defects. Boneless skinless parts, breast meat, breast trim, and skin will be examined for defects on a sampling interval basis. Breast trim will be examined in accordance with one of the following: Breast trim that is size-reduced using equipment designed to extract and discharge bone, bone-like material, cartilage (gristle), cartilage-like material, or hard tendinous material, shall be examined for such material after size reduction only, in accordance with II.C.2.a.(2). Breast trim that is ground or desinewed using equipment that is designed to extract and discharge the material listed above shall be examined for the defects in Table 1 prior to size reduction only as stated below. Regardless of the size-reduction system used, breast trim will be examined for skin, blood clots, and discolorations prior to size reduction.

(1) A sample of 30 pieces of each boneless skinless meat component, 30 pieces of skin, and 2 pounds (0.91 kg) of breast trim (as applicable) will be drawn and examined for the defects, shown in Table 1, before it is used in the formula. The frequency of sampling and the number of defects allowed will be those outlined in the LPS Program's Sample Plan Level 1 (SPL-1) for boneless, skinless meat and skin; and Sample Plan Level 2 (SPL-2) for breast trim. Separate examinations will be made for (a) bone and (b) other defects.

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

(3) If the number of bone defects exceeds the maximum for the “target” level, or results in a rejection, the frequency of sampling for bone defects will be increased to 30 pieces of each boneless skinless meat component, 30 pieces of skin, and/or 2 pounds (0.91 kg) of breast trim (as applicable) drawn twice each sampling interval until the cumulative number of bone defects reverts back to a “target” level.

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

Table 1. Organoleptic Requirements and Defects for Meat and Skin

	Criteria
Organoleptic Requirements:	Meat must not: (a) be rancid; have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign or off-odors; contain foreign materials (e.g., glass, paper, rubber, plastic, metal); and have a bright color; and (b) show evidence of mishandling or deterioration; or dehydration or freezer burn or thawing and refreezing.
	Defects
Boneless, Skinless Meat and Trim:	Bone or bone-like material greater than 0.40 inch (1.02 cm) (see II.B.3.h.(2)).
Bone:	Bone or bone-like material less than or equal to 0.40 inch (1.02 cm).
Discoloration:	Any moderate discolorations.
Other:	Lightly shaded discolorations exceeding an area equivalent to the area of a circle having a diameter of 0.50 inch (1.27 cm). Slight discolorations are permitted, provided the discoloration does not detract from the overall appearance of the meat.
	Cartilage (gristle), hard tendons or tendinous material, or blood clots.
	Skin exceeding an aggregate area equivalent to the area of a circle with a diameter of 0.50 inch (1.27 cm).
Skin:	Any moderate discolorations.
Discoloration:	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.
Other:	Feathers and blemishes.
	Fatty blubber , spongy fat, and membranes from the crop area.
Breasts:	Whole breast with less than one-fourth of the meat.
Tenderloins:	Tenderloin with tendon or less than one-half of the meat.

C. Processing

1. Processing and Size Reduction.

a. Processing. The boneless, skinless breasts and tenderloins with tendons removed (optional ingredient) must be reduced in size through a plate with openings that are not less than 2 inches (5.08 cm) (50.8 mm) in one dimension.

b. Trim meat.

(1) Breast trim (see II.B.3.b.(3) and (5)) must be ground through a plate with holes no less than 0.125 inch (1/8 inch) (3.175 mm) in diameter; or reduced through a desinewer plate or screen with holes 0.0591 inch to 0.0787 inch (1.50 mm to 2 mm) in diameter.

(2) Additionally, provided the applicable dimension requirements are met, the plate, screen, or equipment may be designed to extract and discharge bone, bone-like material, cartilage, etc., simultaneously with size reduction. The system must provide a continuous flow of discharge material during size-reduction. The discharge material must not be used in the commodity produced under this Specification.

c. Skin. Skin (see II.B.3.b.(4) and (5)) must be emulsified or may be ground through a plate with holes that are no greater than 0.125 inch (1/8 inch) (3.175 mm) in diameter.

d. Size reduction equipment. Any bent, broken, or defective blades or plates must be replaced before the size reduction equipment can be used for reducing meat.

2. Requirements for Size-Reduced Meat.

a. Organoleptic requirements and defects for breast trim.

(1) The size-reduced breast trim will be examined in the fresh state on a continuous basis for the organoleptic requirements listed in Table 2 prior to formulation. If the product does not comply with the organoleptic requirements, it will be rejected for use under this Specification.

(2) When an extraction/collection system is used in conjunction with size-reduction (see II.C.1.b.(2)), a 2-pound (0.91-kg) sample of size-reduced breast trim will be drawn and examined in the fresh state for the defect requirements listed in Table 2 prior to formulation.

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

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

(3) If the sample of size-reduced meat contains bone or bone-like material, or has more meat defects (listed in Table 2) than the maximum tolerance for SPL-2, the product the sample represents will be rejected for use under this Specification.

b. Temperature requirements. Size-reduced meat and skin that is not used in the commodity on a continuous basis must be cooled by using cooling methods or media (e.g., use of CO₂ or N₂) that lower the internal product temperature to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C). Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat, trim, or skin must not be incorporated into the size-reduced product. Liquid associated with normal product purge is acceptable. No frozen or previously frozen size-reduced meat, trim, or skin may be used in the commodity.

3. Processing Sequence. Unless otherwise specified, the size reduction; formulation; mixing; stuffing into casings, smoking/cooking, cooling, and packaging or stuffing into packaging, smoking/cooking, and cooling; packing; and freezing of the commodity must be a continuous process that complies with the time and temperature requirements of this Specification.

4. Formulation.

a. Proportions of ingredients required in preparing the commodities are as follows:

DELI-STYLE TURKEY BREAST

	<u>Percent of Total by Weight</u>
Size-Reduced Meat Block (minimum) (See II.B.3.b.)	90.00
Other Ingredients:	total must not exceed 10 percent
Water/Ice (maximum)	6.75
Salt	1.50
Sugar	0.75 - 1.00
Binder	0.50 - 1.00
Sodium/Potassium Phosphate (maximum)	0.50
Sodium/Potassium Lactate or Diacetate (maximum)	<u>3.50</u>
	100.00

DELI-STYLE SMOKED TURKEY BREAST

	<u>Percent of Total by Weight</u>
Size-Reduced Meat Block (minimum) (See II.B.3.b.)	90.00
Other Ingredients:	total must not exceed 10 percent
Water/Ice (maximum)	7.60
Salt	1.25 - 1.40
Binder	0.50 - 1.00
Sugar	0.60 - 0.75
Sodium/Potassium Phosphate (maximum)	0.50
Approved cure accelerator, i.e., Sodium Erythorbate or Sodium Ascorbate	0.04
Sodium Nitrite	0.01
Sodium/Potassium Lactate or Diacetate (maximum)	<u>3.50</u>
	100.00

(1) The size-reduced meat block shall consist of breast meat, and as optional ingredients: tenderloins, breast trim, and skin in the amounts defined in II.B.3.b.(5). The total amount of other (added) ingredients must not exceed 10 percent.

(2) Binder must consist of carrageenan (up to 0.50 percent of the total formula), modified starch(s) (up to 1 percent of the total formula), or a combination of the carrageenan and modified starch(s) (up to 0.50 percent carrageenan, total of combined binders not to exceed 1 percent).

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

(4) If sodium/potassium lactate or diacetate are used in any combination thereof for either commodity, the water and/or ice range percentages shall be adjusted accordingly.

(5) Dry ingredients may be mixed with water to form a brine solution prior to the addition of meat. As an option to forming a brine solution, dry ingredients may be added directly to the meat portion and thoroughly mixed (also see II.C.5.).

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

b. Processing aids (e.g., anticaking agents, anti-dusting agents, or other manufacturing aids (as present in salt, sugar, etc.)) are allowed. If processing aids are used, the ingredients and amounts of ingredients listed in the formulation (II.C.4.a.) must remain the same.

c. Formulated batches of ingredients which do not comply with II.B.3.b. and II.C.4.a. will be rejected.

5. Mixing. The brine solution must be incorporated into the size-reduced meat block by mixing/blending, or tumbling or massaging with or without vacuum. If the option of adding dry ingredients directly with the meat and skin portion is used, batches of meat and skin, dry ingredients, and water/ice must be thoroughly mixed (by mixing/blending, or tumbling or massaging with or without vacuum) to ensure even distribution of ingredients throughout the batch.

6. Stuffing into Casings.

a. After blending, the formulated batches of ingredients must be stuffed into a cook-in film bag, pouch, plastic casing, moisture proof casing, standard fibrous casing, or smoke impregnated casing, as applicable for the commodity.

b. Formulated batches of ingredients must be stuffed into casings which conform to the finished commodity requirements of 4 to 6 pounds (1.18 to 2.72 kg) or 9 to 11 pounds (4.08 to 4.99 kg) net weight.

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

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

8. Cooking. The commodity must be smoked/cooked to an internal product temperature of 160 °F (71.1 °C) or higher for deli turkey breast, and 155 °F (68.3 °C) or higher for smoked turkey breast. Cooking methods and product temperature will be monitored by FSIS.

9. Cooling. After cooking, the commodity must be cooled to an internal product temperature of 40 °F (4.4 °C) or lower. Cooling methods and procedures must be in compliance with FSIS directives and guidelines for cooked products.

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

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

b. Shipping containers. Shipping containers must: (1) be good commercial fiberboard containers that are acceptable by common or other carrier for safe transport to point of destination, (2) be of such size to pack the commodity without slack filling or bulging; (3) withstand the stresses of handling, shipping, stacking, and storage, and (4) be closed by commercially accepted methods and materials. Steel or wire straps must not be used for final closure. Staples must not be used for final closure of shipping containers. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. Staples may be used to manufacture and to assemble the fiberboard shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.

11. Packaging and Packing.

a. Packaging. When fibrous casings are used, the casing must be removed from the commodity after the smoking (as applicable), cooking, and cooling processes, just prior to packaging.

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

(2) After the air is removed, the film bags or casings must be hermetically heat sealed to ensure a vacuum closure and to prevent product dehydration and quality deterioration. Metal wire ties, paper-coated wire ties, or staples must not be used for sealing films, bags, or casings. Metal clips may be used to seal/close bags or casings. Packaging must comply with the requirements of Section II.C.10 of this Specification.

b. Packing. Eight packages of finished commodity weighing 4 to 6 pounds (1.18 to 2.72 kg) or four packages of finished commodity weighing 9 to 11 pounds (4.08 to 4.99 kg) must be packed in each shipping container.

12. Freezing. Packaged commodity must be placed in a freezer within 48 hours of packing. The commodity must be frozen by lowering the internal product temperature to 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If the commodity is not placed in a freezer immediately after packing, the product must be held at a temperature not higher than 36 °F (2.2 °C) and not lower than 26 °F (-3.3 °C). When packaged product is held at a temperature below 26 °F (-3.3 °C), the commodity 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 commodity enters the 26 °F (-3.3 °C) or lower facility.

D. Metal Detection

Each fabricated, finished product must be examined by a metal detection device capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips,

metal fragments from processing equipment, and pieces of wire. The commodity must be examined prior to or after placing the commodity in the bag or casing in accordance with the procedures in AMS 910, Poultry Grader's Handbook.

As an alternate method, the formulated product may be examined by an in-line metal detection device installed in the mechanical stuffing or forming system before cooking and/or smoking. If the alternate metal detection method (in-line) is used and casings are later cut to meet the physical requirements in II.E.2., the product must also be examined by a metal detection device prior to or after it is placed in the bag or casing.

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

E. Finished Product Requirements

1. Fabrication. The commodity must be fabricated and packaged so it can be hand-sliced or sliced by a meat slicer with minimal separation.

2. Weight Requirements.

a. Packaged commodity must weigh 4 to 6 pounds (1.18 to 2.72 kg), or 9 to 11 pounds (4.08 to 4.99 kg) each.

b. Packages of finished commodity may be cut widthwise to meet the weight requirements.

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

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

b. If the sample has more interior and/or exterior defects than the maximum tolerance for sample plan, the product the sample represents will be rejected and may be reworked in accordance with II.E.4.

Table 3. Organoleptic Requirements and Defects for Finished Deli-Style Turkey Breast and Deli-Style Smoked Turkey Breast

Organoleptic Requirements:	Meat must: (a) not be rancid; not have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign or off-odors; not contain foreign materials (e.g., glass, paper, rubber, metal, plastic); and have a bright color; and (b) not show evidence of mishandling or deterioration; or dehydration or freezer burn or thawing and refreezing.
Exterior: (10 products examined)	Defects
	<p>Individual major surface voids (including air voids, fat pockets, and purge pockets) exceeding an aggregate area equivalent to the area of a circle with the diameter of 0.75 inch (1.91 cm). The depth of a void or pocket must be no greater than 0.50 inch (1.27 cm).</p> <p>Unobtrusive purge is allowed; however, pocket and voids holding purge, fat, or air must not exceed the aggregate diameter of 0.75 inch (1.91 cm).</p> <p>The deli breast shows evidence of excessive heating (burnt or scorched).</p> <p>Individual product that does not weigh 4 to 6 pounds (1.18 to 2.72 kg), or 9 to 11 pounds (4.08 to 4.99 kg) each.</p>
Interior: (2 products examined) Product will be cut (widthwise) in three approximately equal pieces.	Void, gelatin, or fat pockets on the sliced surfaces that exceed an aggregate area per surface equivalent to the area of a circle with the diameter of 0.75 inch (1.91 cm).

4. Reworked Commodity. Commodity which is fractured (separated into two or more pieces); has cuts; has more internal or external defects than the maximum tolerances allowed; or does not meet the weight requirements may be reworked (defects removed) and incorporated into formulated batches of the applicable product provided:

- a. The temperature of the product has not exceeded an internal product temperature of 40 °F (4.4 °C) and has been maintained at that temperature or lower;
- b. The product is reworked within 72 hours from the end of the shift it was packaged;
- c. The product is ground through a plate with holes 0.125 inch (1/8 inch) (3.175 mm) in diameter;

d. The product is incorporated at a maximum of 2 percent of the formulated batch, and

e. The product is added to formulated product that will undergo the same cooking/smoking method(s), as applicable.

III. LABELING

Commercial labeling (III.A.) or USDA labeling (III.B.) must be used. When commercial or USDA labeling is selected, both the packages and shipping containers within a purchase unit must be labeled in that format. The contractor must use the same label format (either commercial or USDA) within a purchase unit. However, 4-6 pound Deli-Style Turkey Breast (100884) and 4-6 pound Deli-Style Smoked Turkey Breast (inactive) must be labeled using commercial labeling for packages and shipping containers.

A. Commercial Labeling Requirements for Deli-Style Turkey Breast and Deli-Style Smoked Turkey Breast

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

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

2. Traceable Product. The processor must establish a product identification and record system that clearly links product by place and time of manufacture to specific USDA contracts and destinations. When the company uses the same commercial label for the product certified as complying with this Specification and commercial product, the identification system must differentiate between USDA and non-USDA products. An alpha numeric code may be used for information that is in addition to FSIS labeling requirements. The required product identification and record system, including codes, must be reviewed by USDA, AMS before production begins for the contract(s).

3. Nutrition Facts, Ingredients, and Allergen Statements on Shipping Containers. Nutrition Facts must be provided. The ingredient statement, even for single ingredient foods, must be included as a statement separate from the name of the product, e.g. Ingredients: _____. The allergen statement must be provided in the 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 _____.

B. USDA Labeling Requirements for Deli-Style Turkey Breast and Deli-Style Smoked Turkey Breast

When USDA labeling is used, any deviation from the labeling requirements in this Specification must be approved by the Contracting Officer, in writing, prior to start of production. Labeling and marking of the product must be in accordance with this Specification. Labeling and marking information must be water-fast, non-smearing, of a contrasting color, clear, and readable. The 4-6 pound Deli-Style Turkey Breast (100884) and 4-6 pound Deli-Style Smoked Turkey Breast (inactive) must be labeled using commercial labeling for packages and shipping containers.

Individual 9- to 11-pound (4.08 to 4.99 kg) USDA Labeled Packages

a. USDA Plant Number. The USDA-assigned plant number must be shown on each package in legible form.

b. Production Date. The date of production (month, day, and year) must be shown on the package of each commodity.

C. USDA-Labeled Shipping Containers

1. Labeling and Marking Information.

a. Requirements. Labeling and marking information must be preprinted, stamped, or stenciled on each shipping container; or printed on a self-adhesive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 1 - 3.

(1) All shipping containers must be labeled in accordance with EXHIBIT 1.

(2) Individual labels on shipping containers for fully cooked deli turkey breast (non-smoked) are shown in EXHIBIT 2; and labels for smoked turkey breast are shown in EXHIBIT 3.

b Nutrition Facts, Ingredients and Allergen statements on Shipping Containers. Nutrition Facts must be provided. The ingredient statement, even for single ingredient foods, must be included as a statement separate from the name of the product, e.g. Ingredients: _____. The allergen statement must be provided in the 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 _____.

c. UPC code.

(1) A Universal Product Code (UPC) symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on the principal display panel of each shipping container. (See additional information in III.C.2.)

(2) The 14-digit UPC code for deli-style turkey breast is:

(a) Shipping containers with 4-to 6-pound (1.18 to 2.72 kg) packages:
1 07 15001 00884 5

(b) Shipping containers with 9-to11-pound (4.08 to 4.99 kg) packages:
1 07 15001 00121 1

(3) The 14-digit UPC code for deli-style smoked turkey breast is:

(a) Shipping containers with 4 to 6-pound (1.18 to 2.72 kg) packages:
Inactive

(b) Shipping containers with 9 to 11 pound (4.08 to 4.99 kg) packages:
1 07 15001 00122 8

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

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

3. Inventory Control Information. The processor may include any additional information (including bar codes) for processor inventory control purposes. This information may be applied somewhere on the surface of the shipping container but must not cover or conflict with the labeling requirements of this Specification.

D. Use of Previously Printed USDA Labeling Materials

Carryover inventories of existing supplies of printed packing materials (USDA labeling) from the Commodity Specification for Deli-Style Turkey Breast and Smoked Turkey Breast dated March 2012 may be used. If the ingredients statement, smoke ingredients, labeling of smoke ingredients, or nutrition facts label changes from that printed on existing supplies, the contractor/processor must request temporary approval for use of carryover inventories from FSIS.

Shipping containers or labels with incorrect: (1) plant number, (2) net weight, (3) date packed, (4) name of product, (5) qualifying statement, (6) ingredients statement, or (7) nutrition facts information or label must be corrected before they are used. The incorrect information must be blocked out and the correct information legibly printed, stamped, or stenciled in permanent ink. Additionally, the name, address, and phone number of the processor must appear on each shipping container.

E. Additional Labeling Issues

The following are not acceptable for use under this Specification:

1. Commercial labels that do not have a processor traceability system and code.
2. Commercial labeling traceability coding and systems that have not been reviewed by a representative of LPS Program, Grading Division.
3. Distributor commercial labels.
4. Two or more different commercial labels in the same purchase unit.
5. Commercial labels and USDA labels in the same purchase unit.

F. Free Along Side (FAS) Vessel Deliveries

FAS vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Sales Order/Item Number. The address must be clearly printed on at least two sides of each pallet.

IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY

A. Material and Net Weight Compliance

1. Verification of Materials and Defects.

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

“(I)(We) certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under the terms of this Commodity Specification for Deli-Style Turkey Breasts and Deli-Style Smoked Turkey Breasts dated April 2013, comply or will comply with the terms of this Commodity Specification.

Name _____

Title _____”

One certification is adequate for all production under this Specification.

b. Packaging defects. Packages in a delivery unit will be examined for defects that affect protection, expose product, or permit dehydration or freezer burn, or quality deterioration during storage, such as tears, holes, or improperly sealed packages.

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

d. Tolerance for defects. If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable Poultry Programs’ sample plan, the delivery unit will be rejected.

2. Net Weight. Net weight for deli turkey breasts will be determined at origin.

a. Weight Requirements for 4- to 6- pound (1.18 to 2.72 kg) and 9- to 11- pound (4.08 to 4.99 kg). A purchase or delivery unit for 4- to 6- pound (1.18 to 2.72 kg) and 9- to 11- pound (4.08 to 4.99 kg) packages must total 40,000 pounds (18,144 kg) net, or multiples thereof.

b. 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 - 4	All
5 - 50	4
51 - 100	5
101 - 200	6
201 - 400	7
401 - 600	8

For each additional 100 cases, or fraction thereof, in excess of 600 cases, one additional case shall be included in the sample.

c. Weight variations for 4 to 6 pound (1.18 to 2.72 kg) and 9 to 11 pound (4.08 to 4.99 kg). A weight variation of minus 1 percent (39,600 pounds (17,962 kg)) is permitted on each delivery unit. USDA will pay the contractor only 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.

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

B. Prerequisites for Loading and Shipping Frozen Commodity

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

2. Internal Product Temperature.

a. Requirements. The internal product temperature of frozen commodity must be 2 °F (-16.7 °C) or lower at time of loading. Delivery units with internal product temperatures exceeding 2 °F (-16.7 °C) and up to 5 °F (-15 °C) will be tentatively rejected. Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2 °F (-16.7 °C) or lower and reoffered one time only. Delivery units exceeding 5 °F (-15 °C) or delivery units that have been tentatively rejected and exceed 2° F (-16.7° C) when reoffered will be rejected.

b. Optional temperature verification. As an option to verifying internal product temperature at time of loading, the contractor may request an alternate method utilizing product temperature-sensing devices. If this option is selected, a Federal-State supervisor will determine that the facilities, equipment, procedures, and the contractors' current level of freezing compliance are in accordance with the established guidelines outlined in the applicable LPS Program's instructions for this Specification.

C. Inspection and Checkloading

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

2. Procedures. The inspection and checkloading must be performed by the Grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest Grading Division field office or the Director of Grading Division, LPS Program, AMS, USDA, 1400 Independence Avenue, Room 3938-S, STOP 0258, Washington, DC 20250-0258, telephone (202) 720-3271. The quality, quantity, weight, packaging, packing, and checkloading of the commodity must be evidenced by certificates issued by the Grader. Contractor must not ship the commodity unless informed by the Grader that the designated commodity to be shipped meets contract specifications.

V. UNITIZATION

Each delivery unit of deli-style turkey breast must be unitized (palletized and stretch-wrapped) and comply with the following:

A. Pallets

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

B. Pallet Exchange

Contractors may arrange for pallet exchange with consignees; however, USDA is not responsible for such arrangements.

VI. SHIPMENT AND DELIVERY

Shipment and delivery must be made in accordance with the AMS Master Solicitation, the Solicitation, and this Specification. 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 Grader, or other authorized personnel under the supervision of the Grader, will stamp one end of each shipping container prior to shipment. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

B. Grading Certificate

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

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

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

C. Loading and Sealing of Vehicles

Loading must be in accordance with good commercial practices and the initial sealing must be done at origin under the supervision of a Grader. Thereafter, all delivery units--truck lot and less-than-truck lot (LTL) quantities--must be secured at all times prior to unloading with tamper proof, tamper resistant, serially numbered, high security seals. Suppliers of commodities, products and/or services shall be responsible for placing a seal(s) on all doors of each transportation conveyance upon completion of loading or servicing. Seals shall be serially numbered, barrier-type and meet the American Society for Testing and Materials (ASTM) standards (F-1157-04). Seals shall be 1/8th inch diameter cable, high security bolt, or equivalent. The Contractor must maintain a record of each seal number used for truck lot and LTL delivery units. Additionally, the contractor must ensure that the applicable seal identification number is on each bill of lading, shipment manifest, or other delivery documents for each delivery destination.

When LTL delivery units are transported on the same trailer or railcar and destined for multiple recipients, the trailer or railcar must be sealed after each delivery. The seal number must be recorded on the appropriate delivery documents and correspond with the applied seal at the time of arrival at the next destination. It will be the responsibility of the Contractor to provide a sufficient number of seals and ensure that the carrier service (truck or rail) secures the trailer or railcar after each delivery destination. Failure to seal the trailer or railcar after each stop may result in rejection of the shipment by the recipient agency at the next scheduled stop and rejection of any subsequent deliveries on the trailer or railcar.

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

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

D. Delivery Notification

The contractor must comply with the AMS Master Solicitation regarding Advance Shipping Notices (ASNs) and unloading appointments.

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

2. Delivery in Storage. Delivery may be made in store provided the destination in the Sales Order/Item Number and the place the contractor has the commodity in storage are the same. Inspection and certification by a Grader are also required for transfers in store.

E. Split Deliveries

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

VII. DESTINATION EXAMINATION

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

A. Commodity Requirements

Before acceptance by consignee, the commodity may be examined by a Grader on a spot-check basis for temperature, condition, identity, and when applicable, count. The commodity may be examined for conformance to contract provisions at any time required by the Contracting Officer.

B. Temperature

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



Director, Food Safety and Commodity Specification Division
Livestock, Poultry and Seed Program

Attachments

EXHIBIT 1 USDA-Labeled Shipping Containers

Marking Information: Shipping containers may be marked substantially as shown below. Detailed USDA labeling information is provided in Exhibits 4 and 5. Markings must be legibly preprinted, stamped, stenciled on containers, or printed on a self-adhesive label and applied to containers. The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or principal display panel. The processor’s name, address, and phone number must be printed on the “TOP PANEL” or principal display panel. The processor’s name and address must indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints. ***The Handling Information and Nutrition Facts Label (on the principal display panel) is required on shipping containers of commodity weighing 4 to 6 pounds (1.18 to 2.72 kg).***

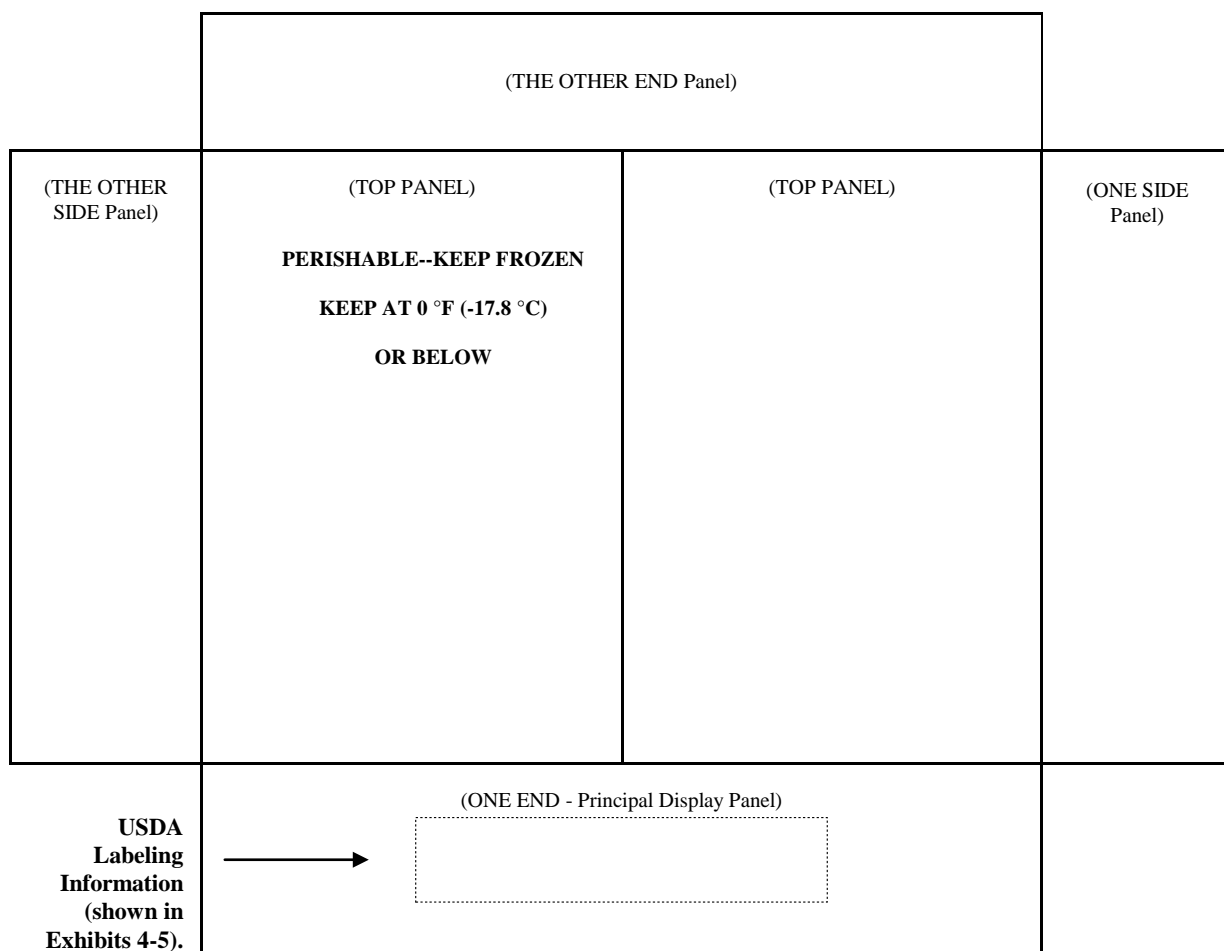


EXHIBIT 2
USDA Label Information for Deli-Style Turkey Breast

Marking Information: USDA labeling information must be printed on the principal display panel of each shipping container as provided in EXHIBIT 1. Markings must be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. The size and number of packages and net weight must be completed. The UPC 14-digit 12/5 code (see III.C.1.c. for appropriate code), symbol and code, must be shown in the lower right-hand corner of the principal display panel. The USDA symbol, copy on back of Specification, must be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or principal display panel. The processor’s name, address, and phone number must be printed on the “TOP PANEL” or principal display panel. The processor’s name and address must indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.



**FROZEN FULLY COOKED
DELI-STYLE
TURKEY BREAST**

Ingredients:

(Food Allergen Statement,
Must Be Placed Here)

Processor’s
Name, Address, and Phone

Required
Nutrition Facts Label
Must Be Placed Here

KEEP FROZEN

___ Pound Packages
___ Packages Net Weight
___ LBS. (___ KG)

DATE PACKED Month, Day, and Year

UPC Symbol and Code

EXHIBIT 3
USDA Label Information for Deli-Style Smoked Turkey Breast

Marking Information: USDA labeling information must be printed on the principal display panel of each shipping container as provided in EXHIBIT 1. Markings must be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. ¹The identification of *smoking method(s)* used below is provided only as an example. The processor must designate the applicable smoking method used on each label and the labeling must be approved by FSIS. The size and number of packages and net weight must be completed. The UPC 14-digit 12/5 code (see III.C.1.c. for appropriate code), symbol and code, must be shown in the lower right-hand corner of the principal display panel. The USDA symbol, copy on back of Specification, must be a minimum of 2.25 inches (5.72 cm) in height and must be printed on the “TOP PANEL” or principal display panel. The processor’s name, address, and phone number must be printed on the “TOP PANEL” or principal display panel. The processor’s name and address may indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.



**FROZEN FULLY COOKED
DELI-STYLE
SMOKED TURKEY BREAST**
Smoke Flavor Added (as applicable)¹

Ingredients:
(Food Allergen Statement,
Must Be Placed Here)

Processor’s
Name, Address, and Phone

Required
Nutrition Facts Label
Must Be Placed Here

KEEP FROZEN

___ Pound Packages
___ Packages Net Weight
___ LBS. (___ KG)

DATE PACKED Month, Day, and Year

UPC Symbol and Code

EXHIBIT 4
“Please Recycle” Symbol and Statement



**PLEASE
RECYCLE**

USDA SYMBOL

