

SECTION 8: ON-LINE SAMPLING OF SHELL EGGS

I. General

The effectiveness of on-line sampling of shell eggs in each plant is directly related to the plant's efforts, in cooperation with the grader, to maintain a sound quality control program. Essential to a successful program are clearly defined procedures with regard to line identity, product control, sampling frequency, recording and evaluating sampling results, retention action, and issuing certificates, all of which will be addressed separately in this section. The evaluation of shell egg quality by "on-line" sampling provides certain options not available when product is sampled on a stationary lot basis.

For a stationary lot grading, average product quality is determined by samples selected from a completed lot. There is no provision for improving the average quality of the lot since it was completed before the samples were taken. Consequently, if the samples show that individual case or average tolerance requirements are exceeded for any factor, the entire lot is unacceptable.

On-line sampling, however, provides for product quality evaluation at regular intervals during production, with a primary goal of maintaining quality within reasonable, specified limits. If marginal quality product is encountered, as evidenced by a sample which shows that tolerance requirements for any factor are approaching the non-compliance level, the plant has the opportunity to make adjustments. Should such adjustments prove ineffective and the tolerance is exceeded on a subsequent sample, the amount of product affected (retained) is limited to that which was produced since the last acceptable sample.

II. Line Identity

The basic principle of on-line sampling involves the separation of production into various "lines" for sampling purposes. A "line" is defined as product being packed to meet the same grade and size requirements. For example: All U.S. Grade A Large eggs being packed onto one or more packing lines may be sampled as one line without regard to brand, type of packaging material, etc. Each sample taken from the U.S. Grade A Large line throughout the shift represents a segment of the ongoing production from that line. This segment of production, in effect, becomes a separate "lot," and is accepted or retained based on the cumulative quality history of the line, as determined by the results of the particular sample.

- A. A "primary" line is one which is anticipated to pack 100 or more 30-dozen cases of the same grade and size during the shift.
- B. A "secondary" line is one which is anticipated to pack less than 100 / 30-dozen cases of the same grade and size during the shift.
- C. Each size must be sampled as a separate line.
- D. U.S. Grade A product cannot be combined with U.S. Grade AA product for sampling purposes, except when the plant agrees that all product must meet U.S. Grade AA requirements.

- E. Product being packed for an approved specification with more restrictive tolerances must be sampled as a separate line.
- F. Normally, product from each machine will be sampled separately by size category. However, a plant may request to combine production of the same size from more than one machine into a single line for sampling purposes. For example: The same brand of U.S. Grade A Large being packed on two or more machines can be sampled as a single line.

If production of the same size from two or more machines is combined, samples will normally be selected on an alternating basis between machines. However, the USDA grader has the option of varying the sampling sequence, depending on product quality and volume on each machine. In any case, each sample represents the accumulated production from all machines since the last sample.

- G. If the USDA grader's workload permits, a plant may request to designate individual brands, different types of packaging materials, or even individual packing "heads" or stations, as separate lines for sampling purposes.
- H. Under some situations it may be possible to merge 2 separate lines of the same grade and size into a single line. Two "in control" lines could be merged into the line having the lowest quality and the first sample after the merge would be from that line. If either line is "out of control" or in a retain status, it is not permissible to merge into a single line without first bringing the line(s) back into control.

III. Product Control

A. Designated Plant Employee

The plant shall designate one or more employees to work with the USDA grader while officially identified product is being packed. These employees shall be readily available at all times to:

1. Receive notification from the USDA grader when a non-compliance sample is encountered on any line, or when a line is approaching maximum tolerance levels.
2. Assist the USDA grader in locating and segregating product to be retained when a noncompliance sample is encountered.
3. Notify the USDA grader when new lines are started any time during the shift.

B. Sampling Intervals

When officially identified product is being packed, samples are to be examined from each line at regular intervals during the shift. A "sampling interval" is defined as:

1. The elapsed time between samples.
2. The amount of product packed between samples.

C. Measurement

When calculating elapsed time or the amount of product packed, measurement is from the point where the completed sample is returned to the line. Beginning with the first sample, and on each subsequent sample, all product packed up to the point where the completed sample is returned to the line may be released for shipment.

NOTE: Graders shall not “stockpile” samples in their candling booth. Only one sample shall be taken off of the conveyor/line for an official sample at any given time.

When a non-compliant sample is found, notify the designated plant employee as soon as possible. Do not return the sample to the line until after the plant employee has been notified. When returned, the sample becomes the "marker" and all product from that point back to the last acceptable sample is to be retained.

D. Identification System for Samples

The plant must have an approved identification system for each line which will permit segregation of product represented by unsatisfactory samples.

1. To assist in accomplishing this requirement, USDA will provide self-adhesive labels (Form PY-12) for identifying official samples. These will also serve as "markers" to identify sampling intervals.
 - a. USDA label markers will be affixed to each sample container, showing the date, sample number, and grader's initials. If desired, the time the sample is returned to the line may also be shown. When stacked, the sample container must be placed in proper sequence, with the USDA label marker plainly visible on the outside of the pallet, dolly, row, etc. Some pallets, dollies, racks, bossies, etc., filled between official samples will not have any containers identified with a USDA label marker. These pallets, etc., must be marked or segregated in some manner so they can be identified as part of the applicable sampling interval, should retention be necessary.
 - b. When a completed 100-egg sample is returned to a movable rack or "bossie," rather than to a case or basket, each primary unit in the sample (flat, carton, etc.) is to be identified in some way; i.e., small letters with the USDA grader's initials, etc. The entire sample unit (100 eggs) is to be identified with a USDA label marker clearly visible on the outside of the rack.
 - c. Some plants may, on occasion, pack more than one brand on the same grading machine with the different brands stacked on separate pallets. When the eggs on a grading machine are being sampled as a single day's production of an identified weight class (size) rather than each brand being sampled as a separate lot, the eggs packaged are recognized as a single lot. For control purposes, the grader must identify the next container of each brand when an examined sample is returned to the packaging line. For example: "Ace" brand and "Best" brand U.S. Grade A Large are being packed on the same grading machine with the USDA grader alternating samples between the two

brands. Since each sample represents a day's production of the large eggs packaged on the grading machine, the brand not sampled must also be marked each time an examined sample is returned to the packaging line.

Accordingly, a USDA label marker must be applied to the container last filled on the line of Ace brand when a Best brand sample is completed, and vice versa. The applicable sampling interval is to be shown on the label marker applied to the non-sample container. Mark a large "X" on the label marker to indicate the container was not sampled. Similarly, if more than two brands are being sampled as a single line, all brands must be identified with a USDA label marker to mark the intervals, each time a sample is returned to the line.

2. In lieu of using USDA label markers, the plant may request to use another equivalent system for identifying official samples and sampling intervals. Any system used must provide for positive control and be approved by the Federal-State supervisor. A description of the plant's current system is to be kept in the "Information for Relief Grader" file folder 2.
3. Label markers are used primarily to control or identify sample intervals in the plant and may be removed at time of shipment. Any container used as an official sample must have the sample number and grader's initials affixed elsewhere to the case, basket, bossie, etc.

E. Overlapping

Overlapping occurs when product from different sampling intervals is mixed on the same pallet. Unless a plant elects to start a new pallet, row, etc., for each sampling interval, overlapping of intervals is unavoidable. When a non-compliant sample is found, all pallets, rows, dollies, etc. (as applicable) which contain any product represented by the noncompliance sample, must be retained. When acceptable product is mixed on the same pallet with non-acceptable product, the plant may request to segregate the acceptable product (for release), provided plant employees always follow an established, uniform system of stacking product. Otherwise, the entire pallet must be retained in order to assure all noncompliant product is accounted for. The plant's stacking system(s) must be diagrammed by the USDA grader, and a copy kept in the "Information for Relief Grader" file folder 2. The USDA grader must also verify from time to time that the established stacking system is being followed.

F. Stacking Product

Stacking occurs when product from two or more machines is placed on the same pallet. For example: Ace brand A Large eggs are being packed on two machines and stacked onto the same pallet.

1. Containers not identified by machine - A non-compliant sample on any machine requires retention of the accumulated production from all machines since the last acceptable sample. This applies regardless of whether all machines are sampled as a single line, or each machine is sampled separately.
2. Containers are identified by machine - A non-compliant sample on any machine requires retention of the accumulated production from all machines since the last acceptable sample.

- a. If each machine is sampled as a separate line, the plant may elect to segregate and hold product from the "out of control" machine(s) for full-sampling. Product from the "in control" machine(s) may be released for shipment.
- b. If machines are combined and sampled as a single line, there is no provision for segregating acceptable product for immediate release. However, the plant may elect to segregate product by machine into separate sublots for a full representative sampling.

IV. Sampling Frequency

Sampling frequency is based primarily on the volume being packed on each line. However, product quality must also be considered. Generally, poor or marginal quality product will be sampled more frequently.

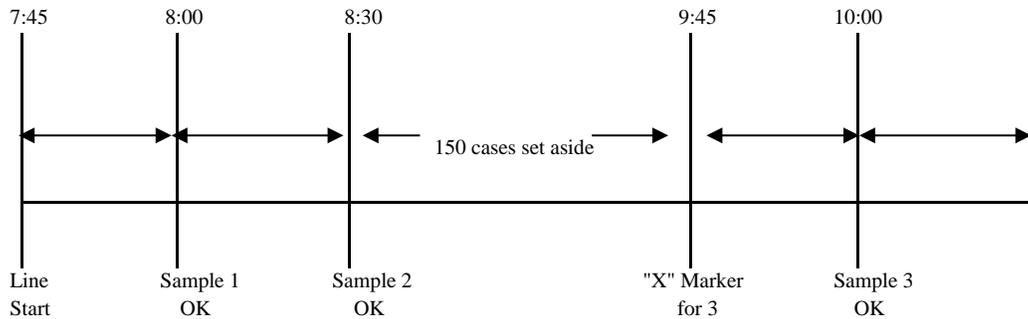
A. Determination Primarily by Volume

To meet minimum sampling requirements on primary lines, the USDA grader must average one sample for each 100 / 30-dozen cases produced on each line. Time permitting, graders should sample at a more frequent rate in order to promptly address fluctuations in quality, and to reduce the quantity of retained product. If plant management requests an increased frequency of sampling and time is not available, the grader's Federal-State supervisor will provide additional staffing.

For an "in control" line, any one sample can represent up to 125 / 30-dozen cases, provided the average sampling interval for that line is 100 cases or less at the completion of the shift. If more than 125 cases will have accumulated during any sampling interval, all product packed on that line since the last acceptable sample must be held for later evaluation as a separate stationary lot (not to be combined with retained product). To identify the cut-off point for the product being set aside, and to mark the beginning of the next sampling interval, place a USDA label marker on the container last filled on the line. Since this container is not a sample, place a large "X" through the marker and show the number of the next sample to be taken, which will represent product produced from the marker forward. That next sample should be selected as soon as possible in order to determine the current status of the line (Example #1).

The product to be set aside for later full sampling must be conspicuously identified in some manner, such as with USDA hold tape, to preclude it from being shipped. Show under "Comment Log" on the reverse of Form PY-75 the total number of cases set aside and the time frame involved. For example: 0830-0945: 150 / 30-dozen cases, Ace brand U.S. Grade A Large cartons not sampled - set aside for full sampling.

Example #1 – U.S. Grade A Large - (Line production - approximately 125 cases per hour)



In high volume plants, the grader may need to informally project an estimated volume for each primary line at the beginning of the shift. These estimates can be used to calculate the number of samples needed to meet the minimum requirement of 1 sample for each 100 cases produced. Recent ordering patterns by the plant's regular accounts, along with current information from the plant, should aid in estimating daily volume. Approximate spacing of samples (minutes between samples or cases produced between samples) can be projected using these estimates.

To avoid becoming predictable or setting a pattern, the spacing of samples throughout the day should be varied slightly; i.e., samples should be taken at different time intervals and occasionally taken "back-to-back" on the same line.

On slow volume (secondary) lines where a total of less than 100 / 30-dozen cases is expected to be packed during the shift, examine at least one sample for every 2 hours of production time. Alternatively, if production is not continuous, examine enough samples to equal the number required for a stationary lot.

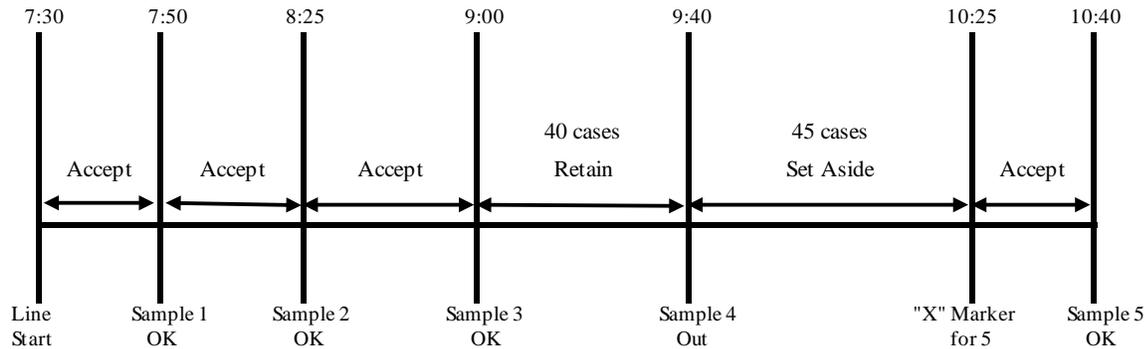
There may be occasions when a limited volume of product is produced in a short period of time. For example, the only U.S. Grade A Small packed on the shift is a special order for 40 cases, which is produced in 30 minutes. If the USDA grader takes one sample during production, and this sample meets the tightened start-up tolerances, product may be accepted based on the one sample. If the grader is not able to examine a sample during production, a full representative sample must be examined from the finished lot.

B. Sampling Following a Retention

When retention is necessary on any line, immediately notify the designated plant employee of the reason(s) for the retention and document on a Form PY-75 or 75A. **DO NOT RETURN THE NON-COMPLIANT SAMPLE TO THE LINE UNTIL THIS IS ACCOMPLISHED.** If the plant continues to pack officially identified product, select and examine another sample from that line as soon as possible (complete the sample within approximately 25 minutes) to determine if corrections have been made. If a sample cannot be taken and completed within approximately 25 minutes, all product packed since the last acceptable sample must be held for later evaluation as a separate stationary lot. If management advises the grader that corrections cannot be made immediately or elects not to correct the non-compliance within the prescribed time and waives the 25 minutes for sampling, then all officially identified product must be held until the line is back in control.

Graders are to follow the procedures outlined in IV.A, (pages 5 and 6) of this section for identifying the cutoff point, controlling the product set aside, and selecting the next online sample (Example #2).

Example #2 – U.S. Grade A Large (Line Production - Approximately 60 cases per hour)



C. Sampling Frequency Adjustments

During the shift, production from any line may vary from hour to hour. Accordingly, when necessary, adjust the sampling frequency to maintain the minimum ratio of 1 sample for each 100 cases produced.

Quality on a particular line may decline without requiring retention. For example: Accumulated checks may move above the average tolerance line, indicating a potential problem. In this situation, if time permits, select another sample as soon as possible to determine the status of the line.

When sampling poor quality product, recurring retentions on the same line or back to back retentions on two or three different lines may make it impossible for the USDA grader to keep up with minimum sampling requirements on all lines. In such situations, give priority to lines with the highest volume in an effort to minimize the amount of product which could be retained or set aside.

D. Assuring That Minimum Sampling Requirements Are Met

The USDA grader is to calculate average sampling intervals for each line as soon as practical after each shift is completed. This requires that production figures for the previous day's shift be available to the grader no later than the following workday. Instructions for calculating average sampling intervals are shown in V.F.1, of this section.

V. Recording and Evaluation of Sampling Results

A. Forms

The Shell Egg Online Candling Record (Forms PY-75 and 75A) will be used for recording sampling results (Exhibits I and II, respectively).

1. Use Form PY-75 to record samples of product being packed to meet U.S. Grade AA or U.S. Grade A requirements.

2. Use Form PY-75A to record samples of product being packed for an approved specification. Checks may not exceed 4 percent average tolerance, with a maximum of 8 percent as the individual case tolerance.
3. The front of both forms is divided, with space to record nine samples on the left half and eight on the right.
4. Normally, only two lines (sizes) will be recorded on one form. For example: U.S. Grade A Large on the left half and U.S. Grade A Medium on the right half.
 - a. If the grader anticipates that more than 8 or 9 samples will be examined from the same line during the shift, one form may be utilized by beginning on the left and continuing across the right half to record up to 17 samples.
 - b. For secondary lines from which only a few samples are anticipated, sampling results from more than one line may be entered on either the left or right half of Form PY-75 or 75A. Space for at least three samples should be reserved for each size (Example #3).

Example #3 - Recording Secondary Lines

DATE 08/29/16	CODE 242	GRADER Burt Dixon	PLANT ABC Egg Co.	NO. 1234	MACHINE (S) 2
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	U.S. GRADE & SIZE									
	AA SMALL					AA EXTRA LARGE				
Brand	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
Exp.										

	U.S. GRADE & SIZE									
	A SMALL					A JUMBO				
Brand	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
Exp.										

B. Tolerances

1. To assist the grader in quickly verifying compliance in sections II, III, and IV after each sample is completed, the average tolerance (shaded line) and individual case tolerance (top space) are "built-in" on Forms PY-75 and 75A. In these three sections, the "one egg over" allowance has been incorporated, which means that the top space becomes an action level indicator. Product is acceptable (one egg over) when the top space is filled, but not acceptable when the top space is exceeded.
2. Sections I and V do not have a built-in action level indicator since non-compliances for grade and weight factors are generally quite infrequent. However, the grader must verify that average and individual case tolerance requirements are met in these sections after each sample is completed.

a. Section I - Grade

The moving average for U.S. Grade AA or A, as applicable, must be 87 or better with no individual case below 77.

The moving average for B* cannot exceed 1 percent and no case can exceed 3 percent. The first sample may not exceed two B* eggs including the one egg over allowance.

b. Section V - Individual Underweight Eggs

The moving average for individual underweight eggs cannot exceed 3.3 percent, with no case exceeding 5 percent. The first sample may not exceed three individual underweight eggs. The one egg over allowance does not apply to underweight eggs.

c. Section VI - Container Weight

There is no tolerance for individual containers which weigh less than the minimum net weight for the size involved.

3. At the beginning of each shift, or when a new line is started during the same shift, individual case tolerances are tightened on both Form PY-75 and 75A for the first sample (second and third samples for some factors) in sections II, III, and IV (Example #4).

By providing product which meets the tightened "startup" tolerances, the plant may immediately ship all product represented by the first sample when it is completed. Product represented by each subsequent satisfactory sample will also be released for immediate shipment, provided individual case tolerances are not exceeded in any section.

When production or sampling on a previously started line stops and then later resumes on the same shift, it may continue as the same line, without reverting back to a first sample "startup" situation. Any retention of product would be back to the place where the line resumed.

4. The first sample tightened tolerances are to be marked off in sections II, III, and IV with diagonal lines through the spaces outlined with bold lines (Examples 4, 5, and 6).

Example #4 - Form PY-75 (all sizes except Jumbo)

Sample										GRADE									Sample	
AA											AA									
A											A									
I											I B									
I												E								
B																				
E																				
Percent																				
10											CHECKS									10
9												9								
8												8								
7	J	J	J	J	J	J	J	J	J			7								
I 6												6								
I 5												5								
4	/											4								
3	/											3								
2	/											2								
1	/											1								
3	M	A	R	K							LOSS	M	A	R	K					3
2 1/2												2 1/2								
I 2	E	A	C	H		E	G	G		2										
I 1 1/2	/									1 1/2										
1	/			T	W	I	C	E		1										
1/2	/									1/2										
2	M	A	R	K						LS	M	A	R	K					2	
1 2/3	E	A	C	H		E	G	G			1 2/3									
I 1 1/3											1 1/3									
V 1			T	H	R	E	E				1									
2/3	/										2/3									
1/3	/				T	I	M	E	S		1/3									

Example #5 - Form PY-75A (all sizes except Jumbo)

Percent

8								
7								
6								
5								
4								
3								
2								
1								

C
H
E
C
K
S

3
2 1/2
2
1 1/2
1
1/2

M	A	R	K					
E	A	C	H		E	G	G	
				T	W	I	C	E

D
-
L
-
L
-
O
-
S
S

M	A	R	K					
E	A	C	H		E	G	G	
				T	W	I	C	E

2
1 2/3
1 1/3
1
2/3
1/3

M	A	R	K					
E	A	C	H		E	G	G	
				T	H	R	E	E
				T	I	M	E	S

M	A	R	K					
E	A	C	H		E	G	G	
				T	H	R	E	E
				T	I	M	E	S

Example #6 - Jumbo Only (Form PY-75)

10																		
9																		
8																		
7		J	J	J	J	J	J	J	J	C	J	J	J	J	J	J	J	J
6										H								
5										E								
4										C								
3										K								
2										S								
1																		

For Jumbo, (Form PY-75), the only difference is in section II (checks), where two spaces instead of four are marked off on the first sample. The tolerances in sections III and IV are marked off the same as shown in examples 4 and 5.

NOTE: If the first sample is unsatisfactory (retained), the startup tolerances are applicable to the second sample, and the appropriate spaces are to be blocked off in sections II, III, and IV.

C. Carryover

When the results for any sample approach the individual tolerance (top space) in sections II, III, or IV, the designated plant employee is to be advised that improvement is needed to avoid a possible retention on the next sample. To emphasize the need for improvement, the results of the previous sample are used to determine the maximum allowable tolerance on the next sample.

This system, called "carryover," is designed to prevent acceptance of product represented by several consecutive samples which exceed average tolerance requirements.

When the average tolerance in sections II, III, or IV is exceeded on any sample, the number of spaces by which the line is exceeded in each section must be "carried over" to the next sample. In effect, this means that better quality product must be provided (at least meeting the average tolerance requirement) to avoid a retention situation. If corrective action is not initiated, or is not successful, and the next sample exceeds the individual case tolerance (with actual sample results added to the carryover), retention would be necessary.

NOTE: In Example #8 one dirty, leaker, or large spot loss egg in sample 3 would cause retention (individual case tolerance would be exceeded).

In sample 8, three dirty eggs were found causing retention because the individual case tolerance of two dirty eggs was exceeded.

In sample 10, three leaker eggs were found causing retention because the individual case tolerance of two leaker eggs was exceeded.

In sample 12, which is acceptable, two dirty eggs and one LS egg were found. Since there is no carryover, a total of three underage eggs are permitted in this section provided there are not more than two dirty eggs or two leaker eggs in the sample.

Example #9, Form PY-75 - Section IV

Sample	1	2	3	4	5	6							
2													
1 2/3	✓												
I 1 1/3	✓	✗											
V 1	✓	✗	✗										
2/3	✗	✗	✗	✗									
1/3	✗	✗	✗	✗	✗								

The LS recorded in section III on the first sample (Example #8) must also be recorded three times in section IV. This fills five spaces (including the two lined out spaces), which is four spaces above the tolerance line (.33 percent). Therefore, a carryover of 4 is required for the second sample.

NOTE: In Example #9, one “LS” in the second sample would cause retention (individual case tolerance of 2 eggs would be exceeded).

If no LS eggs are found in samples 2 through 5, the carryover is reduced by 1 on successive samples until, on sample 6, there is no carryover.

Example #10, Form PY-75 - Carryover When Retention Is Involved

U.S. Grade & Size										U.S. Grade & Size																			
					A Large																								
Brand																				Brand									
Exp																				Exp									
Mach																				Mach									
Time																				Time									
Log																				Log									
Conts. Retain/Size	/	/	/	/	40 30	/	/	/	/	/	/	/	/	/	/	/	/	/	/	Conts. Retain/Size	/	/	/	/	/	/	/	/	/
Sample	1	2	3	4	5	6													Sample										
AA																			AA										
A																			A										
I																			I										
B																			B										
E																			E										

Percent

				II					
10			✓	✓					
9		✓	✓	✓					
8	✓	✓	✓	✓	✓				
7	✓	✓	✓	✓	✓				
6	✓	✓	✓	✓	✓				
5	✓	✓	✓	✗	✓				
4	/	✓	✗	✗	✓				
3	/	✗	✗	✗	✗	✗			
2	/	✗	✗	✗	✗	✗			
1	/	✗	✗	✗	✗	✗			

The nine checks found in sample number 5 would cause retention.

IN A RETENTION SITUATION, THE SAMPLE WHICH CAUSED THE RETENTION IS DISREGARDED, AND THE CARRYOVER IS FROM THE LAST ACCEPTABLE SAMPLE BEFORE THE RETENTION.

In this example, the carryover is from sample 4, (three spaces blocked off on sample 6).

D. Example #11 Completing Forms - Recording Results

PAGE 1 OF 2

GRADER'S DUTY HOURS 0800 TO 1630

DATE <u>1</u> 08/29/16	CODE <u>1</u> 242	GRADER <u>1</u> Burt Dixon	PLANT <u>1</u> ABC Egg Co.	NO. <u>1</u> 1234	MACHINE(S) <u>1</u> 1 & 2
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		U.S. GRADE & SIZE								U.S. GRADE & SIZE									
<u>3</u>	<u>2</u>	AA Medium																	
Brand	<u>4</u>	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	↓	Brand	
Exp	<u>5</u>	WD																Exp	
Mach	<u>6</u>	2																Mach	
Time	<u>7</u>	0900																Time	
Log Ref #	<u>8</u>	0845 1130																Log Ref #	
	<u>9</u>	4																	
Cont. Retain Size	<u>10</u>	70 15																Cont Retain Size	
Sample	<u>11</u>	1																Sample	

For Example #11 note the following guidelines for the completion of Form PY-75:

- 1/ Show at the top of each form the date, code date, grader's name and duty hours, plant name and number, and machine number(s).
- 2/ Enter the U.S. Grade and Size being sampled on the appropriate half of the form.
- 3/ Each vertical column under "U.S. Grade and Size," beginning with "Brand" at the top and continuing through section VI (CWT, container weight) at the bottom of the form, is for recording results of each 100-egg sample.
- 4/ Show the brand name abbreviation, or show "Loose." (A record of the various brands of consumer containers packed in the plant, with an appropriate abbreviation for each, is to be maintained by the grader in the "Information for Relief Grader" file folder 2).
- 5/ Show the "EXP" (expiration) date, if applicable.
- 6/ Show the machine number (if more than one machine is being sampled).
- 7/ Show the time the sample was returned to the line. Samples should always be completed as soon as possible after selecting from the line.
- 8/ Show the start/stop time for the line, breaks in production, etc. This space may also be used to denote a "Ref #" for special or unusual situations which are to be

explained under "Comment Log" on the reverse of the form. The "Ref #" will be the applicable sample number.

- 9/ Show the acceptance or rejection of plant number, lot number and expiration date legibility. A checkmark should be used to indicate an acceptable sample, while an "X" is used to indicate that the sample was rejected.
- 10/ Show the number and size of containers retained; e.g., 70/15, when a noncompliance sample is found.
- 11/ Show the sample number. Record the sample number in sequence without regard for retentions.

a. Section I - "Grade" (Example #12)

In Section I, "Grade," record B interior eggs in the top half of the divided "B" space, and B exterior eggs in the bottom half (use slash marks). Record B* eggs individually in the top half, using "S" for small blood spots, "A" for over $\frac{3}{8}$ -inch air cells, and "Y" for serious yolk defects. B* eggs may not exceed 1 percent (average) at time of shipment. No individual case may have more than three B* eggs.

When sampling U.S. Grade AA product, use the "A" space to record (with slash marks) individual U.S. Grade A quality eggs found in the sample.

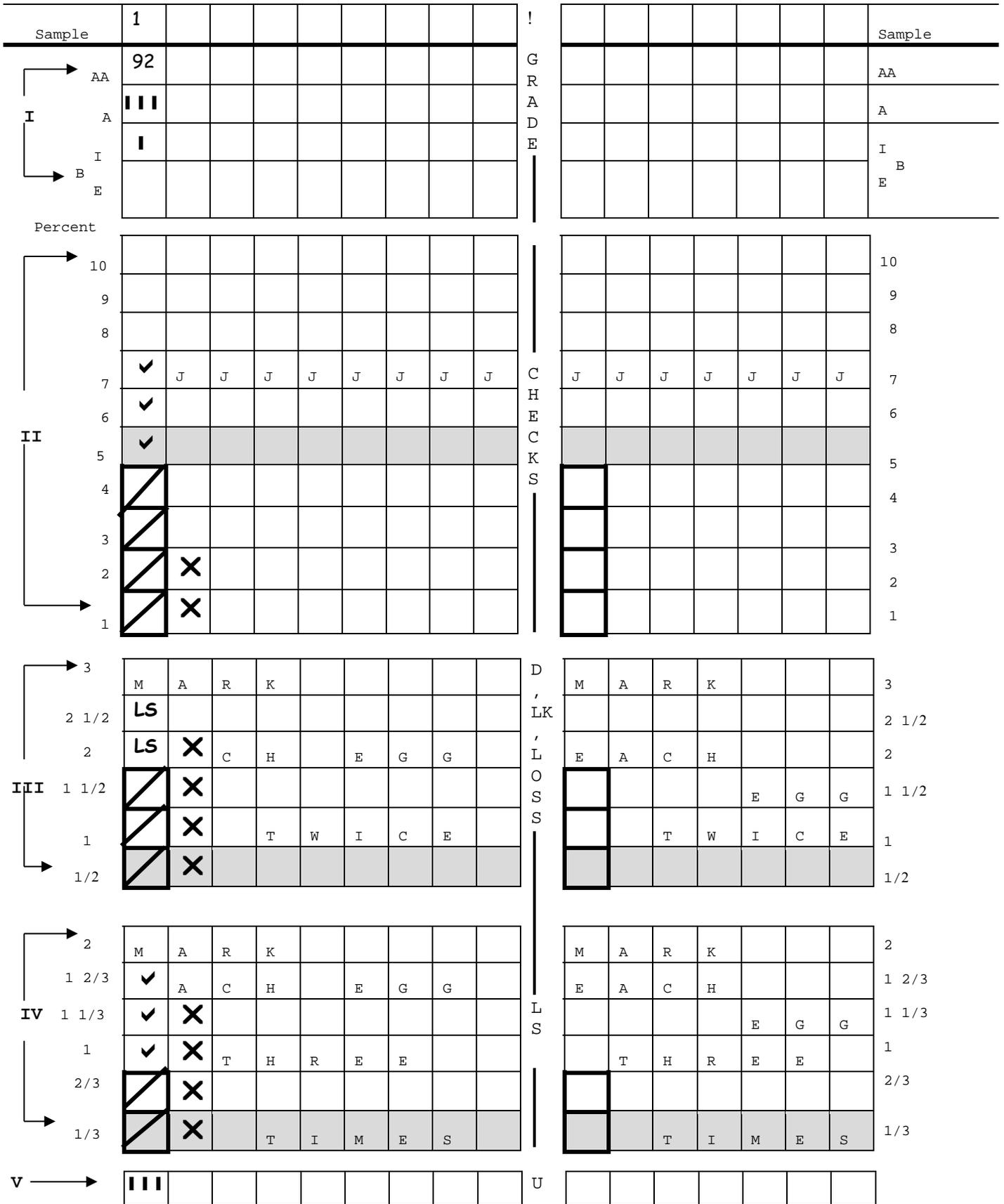
When sampling U.S. Grade A product which has a minimum AA requirement, such as for an approved specification, record individual AA eggs from each sample on a separate note pad using slash marks, or any other method approved by the supervisor. After the sample is completed, record the total number of AA eggs in the "AA" space.

b. Section II - "Checks"

On each sample, begin recording results in the first open space in section II, III, and IV (Example #12). First sample results: 3 checks, 1 LS, 1 BI, 3 A, 3 underweight eggs. Note the carryovers shown for sample 2.

The shaded area across the 5 percent space on Form PY-75, and the 4 percent space on Form PY-75A, is the average tolerance level for all sizes except Jumbo. When sampling Jumbo eggs on Form PY-75, disregard the shaded area and use the 7 percent line as the average tolerance ("J" shown across seventh space). Record each check found in a sample with a check mark (✓), beginning in the first open space at the bottom of the section.

Example #12



If a sample exceeds the individual case tolerance, record above the top space using a slash mark for each egg.

c. Section III - "D/LK/Loss" (Dirty/Leaker/Loss)

The average tolerance level is shown in the shaded space across the bottom (.50 percent) on both Form PY-75 and 75A. Each space represents .50 percent, rather than 1 percent, so each egg found must be recorded twice, beginning in the first open space at the bottom of the section (Example #13).

Example #13 - One Dirty and One Leaker Egg in Sample 3

Sample	1	2	3	4					
3	M	A	R	K					
2 1/2			LK						
2	E	A	LK	X	E	G	G		
1 1/2	/		D	X					
1	/	X	D	X	W	I	C	E	
1/2	/	X	X	X					

Sample	1	2	3	4					
3	M	A	R	K					
2 1/2									
2	E	A	C	H	E	G	G		
1 1/2									
1					T	W	I	C	E
1/2									

Record all dirty eggs with the letter "D." Alternatively, to further identify the type of dirty egg, use the following abbreviations; "DA" for dirty adhering, "DF" for dirty fecal, "DS" for dirty stain, and "DY" for dirty yolk. Record leaker eggs with an "LK", and other types of loss with the appropriate abbreviation.

If the individual case tolerance is exceeded on any sample, record any additional eggs above the top space, using the appropriate symbol. No individual case shall exceed two dirty eggs or two leaker eggs.

Any large meat or blood spots over a 1/8-inch diameter (LS) recorded in Section III will also be recorded in Section IV.

LOSS EGGS OTHER THAN "LS" OR "LK" ARE NOT PERMITTED.

IF FOUND IN AN OFFICIAL SAMPLE; IMMEDIATE RETENTION IS REQUIRED ON PRODUCT REPRESENTED BY THE PARTICULAR SAMPLE.

In this example, the carryover to sample number 4 is 4.

d. Section IV - "LS" (Large Spot)

The average tolerance level is shown in the shaded space across the bottom (.33 percent) on both, Form PY-75 and 75A. Each space represents .33 percent, rather than 1 percent, so each LS egg found must be recorded three times (use check marks), beginning in the first open space at the bottom of the section (see Example #14).

Example #14

	Sample 1	2	3	4	5	6	7	
2		A	✓	K	11 T T T T	T T T T		
1 2/3	E	A	✓	✗	✓	✓	G	G
1 1/3		✓	✓	✗	✗	✗	✗	
1		✓	✗	✗	✗	✗	✗	
2/3	IV	✓	✗	✗	✗	✗	✗	
1/3		✗	✗	✗	✗	✗	S	

2	M	A	R	K				
1 2/3	E	A	C	H		E	G	G
1 1/3								
1			T	H	R	E	E	
2/3								
1/3				T	I	M	E	S

Sample 2: 1 LS; Sample 3: 1 LS; Sample 5: 3 LS; Sample 6: 4 LS. In this example, the carryover to sample 7 is 4.

When an LS egg causes the individual case tolerance to be exceeded on any sample, continue with check marks above the top space to record that egg. Record any additional LS eggs found in the sample with a single slash mark for each egg above or to the right of the check marks (see samples 5 and 6, Example #14).

e. Section V - "Individual Underweight Eggs"

Record individual underweight eggs found in each sample, using slash marks. The individual case tolerance is 5 percent underweight eggs, and the average tolerance is 3.3 percent. These tolerances apply to eggs which are in the next lower weight class only. There is no tolerance for individual eggs which weigh more than 3 ounces below the marked weight for the size being packed. For example: If large eggs are being packed, no individual egg may weigh less than the minimum dozen-weight for medium, which is 21 ounces. If found, show actual weight of the noncompliance egg(s) in Section V and circle to show a retention.

f. Section VI - "Container Weight"

Weigh a minimum of two containers (one dozen cartons or other consumer sized containers) from each sample. Record in Section VI the actual net weight of each container. If either of the containers are within .25 ounce of the stated weight of the consumer container involved, at least two more containers are to be weighed and recorded (above or below the two spaces in Section VI).

THERE IS NO TOLERANCE FOR INDIVIDUAL CONTAINERS WHICH WEIGH LESS THAN THE MINIMUM NET WEIGHT FOR THE SIZE INVOLVED.

g. Small Ends Up

Small ends up may be recorded, if desired, between Sections IV and V, using slash marks.

h. Internal Egg Temperatures

For each shift, record on the reverse of Form PY-75 a minimum of two internal egg temperatures taken before the eggs enter the washer. This is to assure that the wash water temperature is at least 20° Fahrenheit warmer than the temperature of the eggs.

E. Totaling Results

1. For U.S. Grade AA Product: When finished with each sample, determine the number of AA quality eggs by totaling the number of eggs recorded in sections I through III, and subtracting from 100. Record the resultant number in the "AA" space (top of Section I) for the applicable sample.
2. For U.S. Grade A Product: When finished with each sample, determine the number of A quality eggs by totaling the number of eggs recorded in Sections I through III (including AA's if applicable), and subtracting from 100. Record the resultant number in the "A" space (Section I) for the applicable sample.
3. For U.S. Grade B Product: A minimal number of plants pack U.S. Grade B Product. In U.S. Grade B product, the lot average for checks is 10 percent with an individual case tolerance of 20 percent. In the first sample, mark off 9 spaces allowing for 11 checks incorporating the one egg over rule. Each space in section II of the Form PY-75 could also be divided in half so that two eggs could be recorded in each space. The carryover would be calculated using the number of eggs recorded above the 5 percent line. The startup tolerance for dirties, leakers, and loss in U.S. Grade B is identical to U.S. Grade A.

F. Completing the Reverse of Form PY-75

1. Calculation of Average Sampling Intervals

Example #15

GRADE SIZE AA MEDIUM ←		MACHINE(S) 2 ↑		GRADE SIZE A EXTRA LARGE ←		MACHINE(S) 2 ↑	
BRAND(S) STATION LUCKY LADY →				BRAND(S) STATION BETTER BUY →			
↓ P				↓ P			
CASES PACKED 421 °		# SAMPLES 10 ±		CASES PACKED 305 °		# SAMPLES 8 ±	
ONE SAMPLE PER (42) CASES				ONE SAMPLE PER (38) CASES			

Complete the reverse upper portion of Form PY-75 by recording the information from each line marked on the front of Form PY-75 or 75A and showing:

- ← The applicable grade and size.
- ↑ The machine(s) on which packed.
- The brand(s) involved, and if applicable, the packing station or other information to identify the line.
- ↓ Circle P or S to indicate Primary or Secondary line.
- ° The total cases (converted to 30 dozen) packed on this line for the shift involved, including product retained based on unsatisfactory samples. Do not include product which has not been sampled (set aside for stationary lot sampling).
- ± The total number of samples examined from this line including unsatisfactory samples.
- " Divide the cases packed by the number of samples to determine the average interval. Round to the nearest whole number and show in the bracketed space. This figure must be 100 cases or less for each primary line.

If, on any line, the average interval exceeds the minimum requirement of 1 sample for each 100 cases produced, the grader must increase the number of samples taken on that line the next day (assuming the volume produced on that line is approximately the same), to assure that the 1 sample per 100 case average interval is met. Product will not be held for additional sampling.

When the average sampling interval exceeds 1 sample for each 100 cases produced, on any line on more than two occasions during any week, the USDA grader must notify the Federal-State supervisor.

If necessary, the supervisor will arrange for additional staffing on a temporary basis, and will review the need for increased staffing on a permanent basis.

2. Cooler Temperatures - Humidity; Wash Water Temperatures, Sanitizer Strength.

Example #16

COOLER	# 1	#
TEMP ←	45 °F 43	°F
HUMIDITY	76 % 72	%
TIME	8:15 3:00	

MACHINE	# 1	# 2	#
EGG TEMP ↑	78 °F 80	75 °F 79	°F
WASH WATER →	105 °F 107	109 °F 110	°F
SANITIZER ↓	120 P 140 M	135 P 140 M	P P M
TIME	8:30 2:45	8:35 2:50	

As applicable, show for each shift on the reverse of Form PY-75:

- ← Cooler temperature and humidity - record twice per shift, showing time readings were made.
- ↑ Internal egg temperatures, taken before eggs enter washer. Record twice per shift for each washer. Times should coincide with wash water temperature readings.
- Wash water temperatures - record twice per shift for each washer, and indicate time readings were made.
- ↓ Strength of sanitizer in final rinse water - record twice per shift for each unit, and indicate time tested.

3. Comment Log

Example #17

REF #	TIME	(BREAK TIMES, SAFETY HAZARDS, SANITATION, ETC.)
← 2	9:15	BROKEN EGGS ON FLOOR, UNDER #2 MACHINE - CORRECTED 9:30.
----- -	10:05	GRADER'S POCKET THERMOMETER TESTED AND CERTIFIED AS ACCURATE.
↑ 5	1:05	FIRE EXIT BLOCKED WITH EMPTY CASES - CORRECTED 1:15.
→ 7	2:15	#2 MACHINE BROKE DOWN - REPAIRED 3:00.
----- -	4:15	INSUFFICIENT DENATURANT IN INEDIBLE BARRELS - MORE ADDED 4:30.

↓ Are restricted eggs properly labeled and denatured as applicable?

YES NO

As applicable for each shift, record on the reverse of Form PY-75:

← Equipment or facility sanitation deficiencies observed during processing.

↑ Observed or potential safety hazards.

→ Any references regarding breaks in production, or other online sampling problems (from Ref# - front of form).

↓ Indicate whether labeling and denaturing of restricted eggs is satisfactory (checkbox).

VI. Retention Action

A. Cumulative Sampling Results

After each sample is completed, product packed to that point is either accepted or retained, based on that sample's cumulative results.

Explanation of Example #18

- Sample #1: 6 checks, 1 dirty - acceptable.
- Sample #2: 5 checks, 1 LS -not acceptable, top space filled in 2 sections (II and III).
- Sample #3: (Carryover is from sample #1) 4 checks, 1 LS - acceptable.
- Sample #4: 4 checks - acceptable.
- Sample #5 3 checks - acceptable.
- Sample #6 9 checks, 1 LS - acceptable.
- Sample #7 4 checks, 1 LS - acceptable (Top space filled in section III and IV by same egg).
- Sample #8 7 checks - not acceptable, individual case tolerance exceeded in section II.
- Sample #9: (Carryover is from sample 7) 6 checks, 1 LS - not acceptable, individual case tolerance exceeded in sections III and IV (caused by same egg).
- Sample #10: (Carryover is from sample 7) 5 checks - acceptable.
- Sample #11: (Carryover shown from sample 10.)

The one egg over allowance has been incorporated as part of the individual case tolerance in sections II, III, and IV. When the top space has been exceeded in any of these sections, retention is required. Retention is also required when the top space is filled in two sections, except when caused by the same egg, (LS), in sections III and IV, (see Example #18, sample 7).

If the top space has not been filled in sections II, III, or IV, the one egg over allowance has not been used and may be applied, if needed, to the moving averages for AA, A, B, or B*, as applicable, in section I. Retention is required if the moving average or individual case tolerance for any quality (AA, A, B, or B*) is not in compliance.

In section V, individual underweight eggs, retention is required if the moving average exceeds 3.3 percent or the individual case tolerance exceeds 5 percent. Retention, when required, will always be from the point where the non-compliance sample is returned to the line, back to where the last acceptable sample was returned to the line.

When retention action is required, circle the non-compliance in the applicable section(s). Use of a "highlight" marking pen to line out the entire sample from top to bottom will help assure that the carryover for each section is correctly shown from the previous acceptable sample and that moving averages are correctly computed for Sections I and V.

All quality and weight data of any non-compliance sample is eliminated from the cumulative totals.

NOTE: Some plants may have a policy which is stricter than the USDA tolerance regarding the maximum number of checks in an individual sample. For example: The USDA individual case tolerance for checks is 10 percent, but a plant may wish to retain product when an individual sample exceeds 7 percent checks.

If the plant provides the USDA grader with a letter specifically stating their policy on individual case tolerances (sizes, brands, etc.), and requests that USDA follow the more restrictive tolerances, the grader will officially retain any product which exceeds the plant's tolerances. Appropriate carryovers would be shown accordingly on the online sampling form. If the plant chooses not to formalize their policy by providing the grader with a letter, USDA tolerances will apply regardless of what retention action the plant may take.

If a plant is packing a line of U.S. consumer grade product and the number of checks or other non-compliance factors is approaching retention levels, the plant may voluntarily ask that product from the last sample interval be set aside for sampling as a stationary lot. This is permissible, and appropriate carryovers would be shown accordingly on the Form PY-75 or 75A.

Show the number and size of containers retained in the space marked "containers retained/size" immediately above "Sample." Additionally, document each retention on the Form PY-516 "Product Retention Log" (Exhibit III). Continue to consecutively number subsequent samples without regard to retention action. (Example: If sample 2 is out of compliance, the next sample would be 3.)

Reminder: When the first sample is out of compliance, the tightened tolerances are applicable to the second sample, and the appropriate spaces are to be blocked off accordingly.

B. Use of Rejected or Retained Tag – Form PY-36

1. Tags Applied For Product Identification and Control

Each grader is required to have a supply of tags. They are to be used only when necessary and never indiscriminately to resolve small problems within the plant. It is mandatory to retain product with an official tag that does not meet the grade assigned or mislabeled product before the grader leaves the plant at the end of the shift. There are many large plants that operate more than one shift and pack several brands and grades of product. It is extremely difficult for management, the shipping supervisor, or the loading crew to know the location of a rejected lot of packaged product or for the processing supervisor to know the exact pieces of unsatisfactory equipment involved without some form of identification. Proper use of "Rejected" or "Retained" portion of the tags can be advantageous to plant management as well as the grading service. Each grader is to advise the designated company contact each time these tags are used so as to prevent any misunderstanding between management and grading personnel.

2. How Tags Are to Be Used

The "U.S. Retained" block is to be marked and the tag placed on product which has been found to be unacceptable for shipping. Keep it attached to the product until it is regraded, the official identification is removed, or the product is otherwise made acceptable.

The "U.S. Rejected" block is to be marked when equipment is found to be in poor repair or in an unsanitary condition. The tag is to remain attached until the equipment is made acceptable. Never place this tag onto an electrical control switch to prevent the use of equipment. Damage to equipment has been experienced by the accidental starting of such equipment.

3. Use of Tags

- a. Graded product that does not meet the marked grade or weight class.
- b. Incorrectly labeled graded product.
- c. Equipment which have not been properly cleaned.
- d. Incorrectly labeled or denatured inedible.
- e. Incorrectly labeled restricted eggs.
- f. Any packaging material bearing unauthorized grade labeling.

4. Completing information required on a Tag

The date and appropriate remarks such as "Hold for regrading" or "Hold for recleaning and further inspection" are to be written on the upper and lower portions of the tag each time one is used. Attach the upper portion of the tag to the product or equipment and retain the lower portion in the grader's file until the corrections have been made. Then both portions of the tag are to be destroyed. Tags used to move product under retention between shell egg facilities are to be returned to the grader issuing them after the product has been satisfactorily handled.

5. USDA Hold Tape

Each grader is required to have a supply of "Product under USDA Hold" tape. It is to be used in conjunction with retained tags to identify and control retained product. After product is released from retention, make sure that all tags and hold tape are removed from the lot.

6. Product Retention Log (Form PY-516)

To assure proper control and disposition of retained lots, graders are required to document product retentions on Form PY-516, Product Retention Log. The log includes the date, grade and size, number and size of containers retained, reason for retention, applicable brand/code date, retain tag number (if used), and final product disposition and date. The USDA grader who retains the product must initial the log. Additionally, the grader who makes the final disposition must initial the log. The Form, PY-516 must be retained in the grader's file for 1 year after the close of the fiscal year in which it was completed.

7. Disappearance of Retained Tags or Product

In the event that a retained tag is lost or removed without authorization, it must first be determined if all retained product is accounted for. If any amount of product is missing, contact the Federal-State supervisor for further guidance. If all product is accounted for, gather all pertinent information about

the product and the incident (i.e., amount of product, location of product, retention procedures, how/why tag was lost, etc.) and contact the Federal-State supervisor for further guidance. Additionally, a new retained tag is to be affixed to the product to replace those that were lost.

The unauthorized shipment of any retained product or the disappearance of any product under hold is a violation of the Agricultural Marketing Act (AMA) and must be reported immediately, by phone, to your supervisor.

C. Handling Retained Product

Product that is retained must be reworked and re-graded or otherwise handled to assure that it is brought into compliance. The rework, re-regrading, and release of retained product shall be accomplished by one of the following methods:

1. Reworked, Re-graded, and Released –During on-line sampling, product that is retained due to a combination of individual sample results and the running lot average (shaded line), must be completely re-worked prior to re-grading. For example, if a carryover mark (X) is recorded in the shaded line, or above, in sections II, III, or IV, this indicates the lot average is **at or above** the running lot average prior to taking a sample. In this case, if the sample results cause the top space to be exceeded, or the top space is reached in two sections, the product is not eligible for re-grading until the sub-lot is reworked. Note the following exceptions:
 - a. Since non-compliances in sections I and V are generally infrequent, product retained on the basis of grade and weight factors may be re-graded without reworking the lot.
 - b. Product that is retained due to sample results exceeding the top space in sections II, III, or IV, where the carryover for the sample is **below** the shaded line, may be regraded without reworking the lot. This indicates a spike in poor quality rather than a recurring problem over several samples.
 - c. If the first sample exceeds the top space, the product may be re-graded without re-working the lot. This exception is applicable until the first sample passes.

NOTE: If product fails a re-grade for any reason, the entire lot must be re-worked prior to subsequent re-grading requests.

Re-grading of retained product shall be on a lot or subplot basis with a full representative sample graded prior to release. If management desires to keep the lot intact and have it regraded as such, the lot may be reworked by removing all eggs that were not properly graded or by re-processing the entire lot as an intact unit. Reworking must include all packages within the lot if the entire lot is offered for re-grading. However, if the grader determines that the cause of the retention can be isolated to a portion of the lot, (i.e. damage due to a specific

packing head) then only that portion of the lot must undergo reworking prior to re-grading the entire lot. Additionally, retained eggs may be blended with eggs currently being processed and sampled online accordingly.

2. Removed Eggs From Original Packaging Material and Labeled as "Restricted Eggs" - The eggs can only be labeled as restricted if they meet restricted egg tolerances for loss and re-grading is limited to verifying these tolerances. Loose packed product may be relabeled as “restricted eggs” and released provided official identification on the original packaging material is obliterated.
3. Transport to another Location for Reworking- In most instances, the movement will be to another packer or an egg products plant. The following steps are to be taken when transporting retained product: Retained product sent to official egg breaking plants will be considered released once loaded and sealed.
 - a. Determine the name and address of the handler where the product will be shipped. Verify that plant management has contacted the applicable destination Federal-State supervisor or FSIS representative to arrange for the supervision of reworking, relabeling, processing or other final disposition of the product. For expediency, the grader should offer to make this call (at management's expense).
 - b. Prepare a Retained Product Transfer/Release Memorandum (Exhibit IV) to accompany the shipment to the destination location. To facilitate the return of the transfer/release memorandum and retained tags, the origin plant's mailing address is to be placed on the memorandum.

Additionally, the memorandum is to include the packer’s name, number of cases involved, the retain tag numbers, and date of retention. The original copy of the memorandum is to accompany the retained product. One copy is to be placed in the grader's file (file folder 4b).
 - c. Once the product has been reworked and the tags removed, the destination grader or inspector will return the completed transfer/release memorandum as well as the upper portion(s) of the Form, PY-36 retained tag(s) advising that the product was received, and indicating its disposition.

D. Sampling Retained Product

1. When the plant requests a full representative sampling of product retained on the basis of an online sample(s), the USDA grader will select the required number of samples using stationary lot sampling procedures. If, during the course of the re-grading process, and prior to completion of the required number of samples for a full representative sample, the sample results exceed the lot average or an individual case tolerance for the stated grade, the re-grading may be discontinued and the product will remain under retention. Product that fails a re-grade must be completely re-worked again before another re-grading is permitted. For each lot, show information regarding product identity, how the lot is stacked, location where samples are to be taken, etc., on

a sample selection worksheet. Grading data is to be recorded on the Form PY-211, Poultry Products Grading Memorandum. The retention period for Form PY-211's which are used to record samples of retained product only (no certificate issued) will be the same as the retention period for Form PY-75 & 75A; i.e., 1 year after the close of the fiscal year.

2. STATIONARY LOT GRADINGS CANNOT TAKE PRIORITY OVER ONLINE SAMPLING. Depending on the USDA grader's workload, requests for stationary lot grading of retained online product may involve overtime and/or additional staffing. If overtime is incurred on a regular basis due to re-grading of retained product causing excessive overtime hours, the grader is to contact the Federal-State supervisor to determine whether additional staffing is warranted.

4. Sizes May Not Be Combined Under Any Circumstances.
 - a. Different grades may not be combined, unless the plant agrees that all product must meet the requirements of the highest grade.

 - b. All product of the same grade and size retained for the same factor may be combined into one stationary lot for sampling. For example: During the same shift, 4 separate samples of U.S. Grade A Large exceed the check tolerance, resulting in retentions of 50, 40, 45, and 55 / 30-dozen cases. The plant may combine the 4 sublots into one lot of 190 cases for a full representative sample by the USDA grader.

4. Product retained for two or more noncompliance factors in the same sample (for example, checks and dirties) generally cannot be combined with other product for sampling. However, at the plant's option, product retained for different factors may be combined into one stationary lot for sampling. For purposes of combining online sampled, retained product into a stationary lot for regrading, dirties, leakers, and loss are considered to be one factor with a combined tolerance of 0.5 percent. B quality and B* are separate factors because each has specific tolerances completely different from the other.

5. Any prior sample containers which exceed individual case tolerances (not counting carryover) must be removed before initial representative sampling or any subsequent re-sampling is permitted. These samples must be held under retention and released only when action as described under items 8.a, b, c, or d, which are listed below, have been accomplished. Other samples may be left in the lot. However, if the stationary lot sample selection plan identifies a previously examined sample, use the next container. Do not examine any sample more than one time.

6. Each lot of retained product will be examined for and must meet requirements for all factors, not just the factor(s) for which the retention occurred. For example: A lot retained for excess checks could be found acceptable for checks, but out-of-compliance for another factor when fully sampled.

- a. Exception - Product which is retained solely on the basis of a failure to meet minimum net weight requirements for individual containers, incorrect carton dates, or shell stamping, but meet all other requirements, may be fully sampled for individual container net weights, carton dates, or shell stamping requirements only.

For example, 50 / 30-dozen cases of U.S. Grade A Large packed in one-dozen cartons are retained for one carton which weighs 23 1/2 ounces. If the plant requests full-sampling, four samples are to be selected, using stationary lot sampling procedures. Nine-dozen cartons are to be weighed from each of the four sample cases. If each of the 36 / 1-dozen cartons weighs 24-ounces or more, the lot would be acceptable. Product would not be graded for quality or for weight of individual eggs.

Product retained for failing to meet individual underweight egg requirements (lot average or individual case), must be fully sampled for all quality factors including weight.

7. If the initial representative sample shows the product to be out-of-compliance, the plant may request that the lot be resampled. Prior to resampling, the plant may elect to take no action, change the character of the lot by partially reworking the lot, removing some containers, etc. The number of containers in the new lot may be less than the original lot size.
8. If The Lot Fails, The Plant Has The Following Options:
 - a. Rework the entire lot under the supervision of the USDA grader by removing the eggs from the original containers, reprocessing over mass scanning equipment, and resampling according to the online sampling plan, or as a stationary lot, as applicable; or rework the entire lot under the supervision of the USDA grader by visually examining each egg in the lot by hand candling or other means so that the lot is essentially reworked. The reworked product is to be fully sampled as a stationary lot.
 - b. Remove the eggs from the original containers, or otherwise rework the product without supervision, but save the containers, restricted eggs, etc., so the USDA grader can verify that this has been accomplished. The exact verification procedures are to be approved by the Federal-State supervisor. The resultant reworked product is to be fully sampled and graded by the USDA grader as a stationary lot.
 - c. If the plant feels that there are extenuating circumstances or justifiable reasons for allowing another stationary lot examination, it may be granted with the concurrence of the Federal-State supervisor.
 - d. The USDA grader verifies that the U.S. grademark or other official stamp is completely obliterated from all containers and/or cases.

9. All retained product must remain under the USDA grader's control (U.S. retained tag) until one of the above conditions are met.

Note: Any product exceeding the restricted egg tolerances for U.S. Grade B, as determined by a full-sample, may not be released until brought into compliance.

VII. Certificate Issuance for On-line Sampled Shell Eggs (Form PY-210S)

A. Option 1 - Certification with No Quality Percentages or Net Weight

An official Poultry Products Grading Certificate (Form PY-210S), without quality percentages or net weight information, may be issued up to 21 days after the product was packed and graded including the date of pack on any shell eggs which have met online sampling requirements. Show the following statement in the remarks section of the Form PY-210S certificate:

"Product represented on this certificate meets the requirements for the stated grade and size as determined by online sampling on (date product was packed)."

All grading data and net weight information are to be recorded on the Form PY-75 or 75A. The completed Form PY-75 or 75A are to be filed together for the required retention period of 1 year after the close of the fiscal year.

B. Option 2 - Certification with Quality Percentages and/or Net Weight

When a Form PY-210S certificate with quality percentages and net weight is requested, a full size representative sample [based on 56.4(b) of the regulations] must be examined from the product to be certified. When plant management knows in advance that such certification is needed, the USDA grader is to be advised, so that the required number of samples may be examined from the lot to be certified during processing. All grading data and net weight information are to be recorded on the Form PY-75 or 75A. The completed Form PY-75 or 75A are to be filed together for the required retention period of 1 year after the close of the fiscal year.

1. Procedures When Sufficient Online Samples Are Examined During Processing
 - a. Certification of All Product Produced During a Specific Period

Up to 5 consecutive days' production of the same grade and size may be combined and averaged as one lot on a certificate. A certificate may be issued on product up to 21 days after the product was packed and graded including the date of pack. Enter the following statement in the remarks section of the Form PY-210S certificate:

"The results shown on this certificate are an average of samples graded during processing on (show dates)."

- b. Certification of a Portion of Production

The average quality percentages and net weight of all samples graded may be shown on a Form PY-210S certificate covering any portion of production from a line. In this situation, the results of all online samples

from a particular line would be averaged to determine quality percentages and net weight. Enter the following statement in the remarks section of the Form PY-210S certificate issued to cover any portion of production from the applicable line:

"The product represented on this certificate was part of a lot of eggs graded during processing on (show date). The quality percentages and net weight shown are an average of all samples graded from the entire lot."

2. Procedures When Insufficient On-line Samples Are Examined During Processing

If the USDA grader is unable to examine sufficient samples from the line during processing, the additional samples needed (to equal the minimum number required to certify percentages) may be selected from the cooler, provided that: the product is identified with an official U.S. grade stamp, U.S. lot number stamp, or other official identification; not more than 21 days have passed since the product was packed; all the product to be certified is in the plant and available for additional samples to be taken.

The additional samples will be identified using a calculator, according to stationary lot sampling procedures. The results of the grading are to be averaged with online sample results on a Form PY-211. Alternatively, if it is anticipated that additional samples may be needed to later certify quality percentages, the USDA grader may randomly select and set aside such additional samples from the line, during processing, as may be needed. These "potential" samples must be sealed, marked with the grader's initials, and officially identified. The potential samples should be placed together in a readily accessible location in the cooler. The additional samples, if needed, will be averaged with the online samples examined during processing. The Form PY-211 will be attached to the Form PY-75 or 75A and disposed of 1 year after the close of fiscal year.

a. Certification of All Product Produced During a Specific Period

If the entire lot(s) is certified, enter the following statement in the remarks section of the Form PY-210S certificate:

"The results shown on this certificate are an average of samples graded during processing on (show date/dates) and (show number). Additional samples were graded on (show date)."

b. Certification of a Portion of Production

(1) If the entire lot is available, and a portion of the production lot is certified, enter the following statement in the remarks section of the Form PY-210S certificate:

"The product represented on this certificate was part of a lot of eggs graded during processing on (show date). (Number)

additional samples were graded on (show date). The quality percentages and net weight shown are an average of all samples graded from the entire lot."

- (2) If the entire production lot is not available for sampling, but the portion of the lot to be certified is available and can be positively identified with individual samples selected and graded during processing, enter the following statement in the remarks section of the Form PY-210S certificate.

"The results shown on this certificate are an average of samples graded during processing on (show date/dates) and (show number). Additional samples were graded on (show date)."

NOTE: In the event that additional cooler samples show the product to be out-of-compliance, the grader may not issue a certificate listing the individual quality percentages or net weight. A certificate may be issued showing that the product met the requirements for the stated grade and size as determined by online sampling. If the results of the cooler samples reveal that the product exceeds the restricted egg tolerances, the product must be retained.

VIII. Official Identification of On-line Product

If a U.S. grade stamp is used to identify shipping containers, each day's production must bear the actual date of grading (processing), or the certificate number.

Product identified with a USDA lot stamp which is eligible for official identification, must be restamped with the applicable consumer grade stamp bearing the date that coincides with the date shown in the lot stamp. Alternatively, the product may be fully sampled as a stationary lot, and stamped with the U.S. grade stamp showing the actual date of grading or the certificate number. When the certificate number is used, a Form PY-210S certificate must be prepared and provided to plant management.

U.S. DEPARTMENT OF AGRICULTURE
 AGRICULTURAL MARKETING SERVICE
SHELL EGG ONLINE CANDLING RECORD (10% CHECKS)

Exhibit I

PAGE DATE	OF CODE	GRADER
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GRADER'S DUTY HOURS PLANT	NO.	TO MACHINE(S)
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U.S. GRADE & SIZE:

Brand			
Exp			
Mach			
Time			
Log (Ref #)			
Containers Retained/Size			
Sample			

Brand			
Exp			
Mach			
Time			
Log (Ref #)			
Containers Retained/Size			
Sample			

I	AA			
	A			
	i			
	B			
	e			

	AA			
	A			
	i			
	B			
	e			

I	Percent			
	10			
	9			
	8			
	7	J	J	J
	6			
	5			
	4			
	3			
	2			
1				

	Percent			
	10			
	9			
	8			
	7	J	J	J
	6			
	5			
	4			
	3			
	2			
1				

I	3	M	A	R	K		
	2 1/2						
	2	E	A	C	H		E
	1 1/2						
	1				T	W	I
	1/2						

	3	M	A	R	K		
	2 1/2						
	2	E	A	C	H		E
	1 1/2						
	1				T	W	I
	1/2						

I	2	M	A	R	K		
	1 2/3	E	A	C	H		E
	1 1/3						
	1			T	H	R	E
	2/3						
1/3				T	I	M	

	2	M	A	R	K		
	1 2/3	E	A	C	H		E
	1 1/3						
	1			T	H	R	E
	2/3						
1/3				T	I	M	

V				
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VI				

GRADE CHECKS DILL LOSS L S U C W T

PY-75 (12-96) (Use previous edition dated 02-94.)

U.S. DEPARTMENT OF AGRICULTURE
 AGRICULTURAL MARKETING SERVICE
SHELL EGG ONLINE CANDLING RECORD (8% CHECKS)

PAGE	OF	
DATE	CODE	GRADER

GRADER'S DUTY HOURS		TO
PLANT	NO.	MACHINE(S)

U.S. GRADE & SIZE:

↓	↓	↓	↓	↓	↓	↓	↓	↓	↓
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Brand											
Exp											
Mach											
Time											
Log (Ref #)											
Containers Retained/Size											
Sample											

U.S. GRADE & SIZE:

↓	↓	↓	↓	↓	↓	↓	↓
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											Brand
											Exp
											Mach
											Time
											Log (Ref #)
											Containers Retained/Size
											Sample

I	AA											AA
	A											A
	i											i
	e											e

											AA
											A
											i
											e

I	Percent											Percent
	8											8
	7											7
	6											6
	5											5
	4											4
	3											3
	2											2
1											1	

											Percent
											8
											7
											6
											5
											4
											3
											2
											1

I	3	M	A	R	K						3	
	2 1/2										2 1/2	
	2	E	A	C	H	E	G	G				2
	1 1/2											1 1/2
	1				T	W	I	C	E			1
	1/2											1/2

				M	A	R	K					3
												2 1/2
				E	A	C	H	E	G	G		2
											1 1/2	
							T	W	I	C	E	1
											1/2	

I	2	M	A	R	K						2	
	1 2/3	E	A	C	H	E	G	G				1 2/3
	1 1/3											1 1/3
	1			T	H	R	E	E				1
	2/3											2/3
	1/3				T	I	M	E	S			1/3

				M	A	R	K					2
				E	A	C	H	E	G	G		1 2/3
											1 1/3	
						T	H	R	E	E	1	
											2/3	
							T	I	M	E	S	1/3

V											
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VI											

GRADE CHECKS D, L, LOSS U CWT

RETAINED PRODUCT TRANSFER / RELEASE MEMORANDUM

DATE:

TO: _____ (Grader / Inspector at Destination Location)

FROM: _____ Origin Grader / Inspector (Print Name)

SUBJECT: Retained Eggs

Company Name & Address
of Retention Location:

Company Name & Address
of Destination Location:

Registration
Number
(if applicable)

Date	Total 30-Dozen	Brand	Carton / Loose	Grade	Size	Tag Number
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Product was: Broken, Retagged, Relabeled, Regraded, Re-inspected & Released
on _____ (circle as applicable). Type of violation: () EPIA () AMA

Date	Total 30-Dozen	Brand	Carton / Loose	Grade	Size	Tag Number
------	----------------	-------	----------------	-------	------	------------

Product was: Broken, Retagged, Relabeled, Regraded, Re-inspected & Released
on _____ (circle as applicable). Type of violation: () EPIA () AMA

REMARKS

Name, Address, and Signature
of Destination Grader / Inspector

Return this memo and retained tags to:
(Completed by Origin Grader / Inspector)

