

APPROVED



**Agricultural
Marketing
Service**

**Livestock and Seed Program
Washington, DC 20250 - 0254**

**Item
Description and
Checklist of
Requirements**



**FOR
USDA PURCHASES
OF
FROZEN, VALUE-ADDED
PINK SALMON PRODUCTS**

Effective: November 2005

I. ITEM DESCRIPTIONS

- Items –
- (1) Pink Salmon Burgers – This is a raw item made from deep skinned boneless Pink Salmon blocks of whole fillets for use as sandwiches or a stand-alone item. Additional ingredients include water, salt, and seasoning. The salmon is cut into 3.2 ounce portions that are round or oval in shape and individually quick frozen (IQF).
 - (2) Pink Salmon Burgers, Breaded and Par-Fried – This item is made from deep skinned boneless Pink Salmon blocks of whole fillets for use as sandwiches or a stand-alone item. Additional ingredients include water, salt, breading materials, and seasoning. The salmon is cut into portions that are round or oval in shape, breaded, par-fried and IQF. The breaded salmon burgers will weigh 3.2 ounces.
 - (3) Pink Salmon Nuggets, Breaded and Par-Fried – This item is made from deep skinned boneless Pink Salmon blocks of minced or whole fillets for use as a stand alone item. Additional ingredients include water, salt, breading materials, and seasoning. The salmon shall be made into nugget portions, breaded, par-fried and IQF. The breaded salmon nuggets will weigh 1.0 ounce.
- Formulation – Pink Salmon burgers shall be comprised of at least 85 percent by weight of fish flesh. The breaded Pink Salmon burgers and nuggets shall be comprised of at least 80 percent by weight of fish flesh.
- Packing – Four (4) 10-pound, five (5) 8-pound, or eight (8) 5-pound immediate containers (packages) will be packed in a 40-pound (net weight) shipping container.
- Delivery Unit – Each delivery unit shall consist of 1,000 cases and 40,000 pounds net weight.

II. CHECKLIST OF REQUIREMENTS

Products shall be produced under the Food and Drug Administration regulations and all applicable Federal acts and regulatory references cited therein which are in effect on the date of production.

A. MATERIALS

Contractors must describe in detail the necessary processing steps with pictures to comply with the requirements below.

1. FISH COMPONENT

Boneless and skinless Pink Salmon (*Oncorhynchus gorbuscha*) shall be the only fish component allowed. The Pink Salmon blocks shall meet the following requirements:

- a. Domestic Origin – Only current season Pink Salmon landed by American flagged vessels is allowed.
- b. Processing Location – Pink Salmon must be completely processed within the U.S. and its Territories.

- c. Quality – The salmon blocks consisting of whole fillets shall have characteristics of good quality Pink Salmon, including but not limited to flavor, odor, and wholesomeness. The salmon blocks consisting of minced salmon shall not be derived from backbone frames, napes, tails, and fins.
- d. Objectionable Materials – The Contractor must identify and develop a strategy and have a written quality plan that will effectively remove of all bones, skin, organs, tails, fins, and foreign materials.
- e. Fish Flesh Composition – Pink Salmon burgers shall be comprised of at least 85 percent by weight of fish flesh. The breaded Pink Salmon burgers and nuggets shall be comprised of at least 80 percent by weight of fish flesh. All fish flesh shall be traceable to sources that comply with the above domestic origin and processing location requirements.

2. NON-FISH COMPONENT

- a. Domestic Origin – Significant ingredients (more than 1 percent) shall be derived from U.S. produced products when U.S. produced products are available from ingredient suppliers.
- b. Batter/Breading – The batter/breading mixture shall be similar to normal commercial marketed breaded salmon burgers and nuggets. The additional ingredients that include spices, seasonings, and other ingredients may be used as needed to produce the desired flavor, color, texture, and crispness. If used, flour must be enriched.
- c. Salt – Ingredients shall include salt added at a level not to exceed 5 percent by weight of the dry batter and breading combined.
- d. Monosodium Glutamate (MSG) – Use of MSG is not allowed.

3. SHAPE AND PORTION WEIGHT

All products shall have a uniform shape and size to meet the portion weight requirement.

- a. Burgers – The individual burgers shall be in round or oval shape and have a portion weight of 3.2 ounces.
- b. Nuggets – The individual nuggets shall be cut or formed into any shape and have a portion weight of 1.0 ounces. The shape must be declared.

All production portion weights shall be measured and charted on control charts featuring average weight and range.

4. INDIVIDUALLY QUICK FROZEN (IQF)

All products shall be IQF to 10°F or below prior to packaging and then frozen to 0°F or lower within 24 hours after they are packaged and packed so the individual burgers and nuggets do not stick together.

5. PAR-FRYING OIL

The breaded Pink Salmon burgers and nuggets shall be par-fried in vegetable oil in order to set the coating so the end-user may bake them in a conventional or convection type oven.

6. COOKING AND HEATING INSTRUCTIONS

Cooking instructions must be declared and appear in the shipping and immediate containers.

7. METAL DETECTION

All Pink Salmon products must be free of metal contamination. Testing must be conducted after formulation, but may take place before and/or after packaging. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required. The equipment, location, detection procedure, sensitivity levels, frequency of equipment validation, and corrective action procedures will be identified and described.

8. FINISHED PRODUCT EVALUATION

The finished products shall be evaluated for cooked flavor, odor, color, and texture in accordance with established sampling and cooking procedures developed by the Contractor.

B. PREPARATION FOR DELIVERY

The delivered Pink Salmon products shall comply with all applicable Federal, State, and local mandatory requirements and regulations relating to the preparation, packaging, labeling, storage, distribution, and sale of fishery products within the commercial marketplace.

1. PACKAGING

The salmon burgers and nuggets shall be packaged in four (4) 10-pound, five (5) 8-pound, or eight (8) 5-pound immediate containers (packages). All packages shall be closed and sealed so that they are tamper-proof.

2. PACKING

The shipping containers shall be in compliance with the National Motor Freight Classification or Uniform Freight Classification, as applicable.

- a. Net Weight – The four (4) 10-pound, five (5) 8-pound, or eight (8) 5-pound immediate containers (packages) shall be packed in a 40-pound shipping container of a size to accommodate the product without slack filling or overfilling.
- b. Style and Size of Container – Only one size and style of immediate (bags) and shipping containers may be offered in an individual shipping unit.
- c. Closure – Shipping containers will be closed by strapping, taping, or gluing. When strapping is used, the initial closure (usually the bottom of container) shall be secured by the gluing method.

3. LABELING

Both immediate and shipping containers will be labeled to include all information required by FDA regulations. These labels must be applied in a manner that prevents their removal in an intact form.

- a. Immediate Container – Immediate containers (packages) must have a traceability code that includes information regarding production establishment, production lot, and date.
- b. Shipping Container – Shipping containers must have the following information:
 - (1) The USDA Shield shall be at least 2 inches high and appearing on top of the container or on the principle display panel.
 - (2) The applicable contract number.
 - (3) A traceability code that includes information regarding production establishment, production lot, and date.
 - (4) Nutrition facts based on actual nutritional analysis of the product.
 - (5) Cooking instructions.
 - (6) The Processed Under Federal Inspection (“PUFI”) mark.
 - (7) The appropriate Item Name and Product Code listed in the table below for each of the items.



Item Name and Product Code	
Item Name	Product Code
Salmon Burgers	A809
Breaded Salmon Burgers	A807
Salmon Nuggets	A806

4. PALLETIZED UNIT LOADS

All products shall be stacked on new or well-maintained pallets and palletized with shrink wrap plastic.

C. PRODUCT ASSURANCE

All Pink Salmon finished products shall be produced under the National Marine Fisheries Service (NMFS) Type I inspection, which may include Integrated Quality Assurance (IQA) or HACCP Quality Management Program (HACCP-QMP). The contractors must declare the type of NMFS inspection program they are operating under.

D. DELIVERY UNIT

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

E. DELIVERED PRODUCT

1. TEMPERATURE

The product temperature at the time of shipment and delivery shall not exceed 0°F.

2. SEALING

All products must be delivered to AMS destinations under seal.

F. WARRANTY AND COMPLAINT RESOLUTION

1. WARRANTY

The contractor shall guarantee that the product complies with all contractual requirements.

2. COMPLAINT RESOLUTION

The Contractor's technical proposal shall provide the steps taken to resolve complaints received on the product i.e, point of contact, cause and effect analysis, corrective and preventative actions taken, and product replacement.

G. NON-CONFORMING PRODUCT

The Contractor must include a plan to assure that non-conforming product is not delivered under USDA contracts. The plan must address 1) control and segregation of non-conforming product, 2) removal of any USDA markings, and 3) disposition of non-conforming product.