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APPROVED

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ITEM DESCRIPTION AND CHECKLIST OF REQUIREMENTS (IDCR) PORK PATTIES, FOR FULLY COOKED

Effective: **September 2009**

I. ITEM DESCRIPTION

- Item – Pork Patties, Fully Cooked – This item consists of ground pork (shall be derived from suitable lean from any portion of the sow and/or hog carcass) that is seasoned, formed into round or oval patties, fully cooked, and then Individually Quick Frozen (IQF) for use as a sandwich component or a stand-alone item. Portion Weight – 2.0 ounces.
- Formula – Pork will comprise at least 90% of the raw formula.
- Non-Meat Component – Non-meat components will comprise no more than 10% of the raw formula.
- Fat – Fat content will not exceed 20 grams per 100 gram serving.
- Sodium – The sodium content will not exceed 700 milligrams per 100 gram serving.

II. CHECKLIST OF REQUIREMENTS

All items must be produced in accordance with Food Safety and Inspection Service (FSIS) regulations and the checklist of requirements. The contractor’s production plan, submitted to the Contracting Officer, must adhere to the following checklist of requirements.

A. MATERIALS

The contractor’s production plan must describe a documented quality control program that includes procedures, records, forms, pictures, etc., that demonstrate conformance with the following checklist of requirements.

1. MEAT COMPONENT

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

- a) Domestic Origin of Meat Component – All sows and/or hogs will originate from U.S. produced livestock as defined in the announcement.

- b) Harvesting (Slaughtering) – All sows and/or hogs will be harvested in facilities that comply with the following requirements:
 - (1) Humane Handling – All sows and/or hogs will be humanely handled in accordance with all applicable FSIS regulations, directives, notices and AMS requirements.
 - (2) Non-Ambulatory Disabled Animals – Meat from carcasses of non-ambulatory disabled animals will not be included in USDA Purchase Programs.
- c) Raw Material Type* – The type of boneless pork utilized shall be specified from the following options:
 - (1) Type I – Sow Trimmings Only
 - (2) Type II – Hog Trimmings Only
 - (3) Type III – Combination of Sow and Hog Trimmings**

The contracting officer will designate the raw material type permitted for each invitation.

*One, two, or all of these types may be represented in the contractor's production plan.

**The contractor shall specify the ratio of these two raw material types in their production plan.

- d) Boneless Pork – Boneless pork will comply with the following requirements:
 - (1) Traceability – Contractors are responsible for providing sufficient product traceability and must have records to verify the source of raw materials used in each lot of product.
 - (2) Handling – All boneless pork must be maintained in excellent condition. The contractor's production plan shall include detailed production scheduling that addresses time and temperature controls necessary to maintain excellent condition of the boneless pork. Frozen boneless pork may be used provided it is processed into the final product within 60 days from the date of pack and was not initially placed into the freezer prior to contract award.
 - (3) Production lots of boneless pork associated with positive pathogen test results will not be allowed.
 - (4) Objectionable Materials – Boneless pork shall be free of skin, bones, cartilages, organ tissue, heavy connective tissue, significant glandular tissue, spinal cord, and foreign materials.
- e) Mechanical Separation – Meat that is mechanically separated from bone with automatic deboning systems, advanced lean (meat) recovery (AMR) systems, or powered knives will not be allowed.

2. NON-MEAT COMPONENTS

- a) Domestic Origin of Non-Meat Component – Significant ingredients (more than 1 percent) will be derived from U.S. produced products.
- b) Seasonings and Other Ingredients – Seasonings and other ingredients will be included to produce product with a traditional breakfast flavor profile and texture suitable for family feeding programs.
- c) Caramel Coloring - Caramel coloring is allowed.
- d) If soy protein product (SPP) is used, it must be a concentrate or isolate and when hydrated yield no less than 18% protein (as is basis).

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e) MSG - Monosodium Glutamate (MSG) is not allowed.

B. PROCESSING

1. GRINDER PLATE

The size of the grinding plate for grinding boneless pork will be declared.

2. BONE COLLECTOR / EXTRUDER SYSTEM

A bone collector/extruder system must be in operation to effectively remove bone, cartilage, and heavy connective tissue during the final grind.

3. PATTIES

- a) Weight - Target packaged weight per cooked patty will be 2.0 ounces. All weights will be charted on control charts featuring average weight and range.
- b) IQF – Patties will be IQF so individual patties do not stick together after they are packaged.
- c) Appearance – Patties shall be of normal commercial fully cooked color without pink or burnt appearance after cooking. Patties shall have subtle “browned” highlights with minimal evidence of gray color.
- d) Flavor – Patties must not have a scorched flavor.
- e) Shape – Patties will be round or oval shape.

4. COOKING TEMPERATURE

All products will be fully cooked in accordance with FSIS regulations.

5. METAL DETECTION

All products will be free of metal contaminants. 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 shall be described.

C. FINISHED PRODUCT LIMITATIONS

The declared serving size, fat content, and sodium level will be stated on the nutrition facts panel on each label according to FSIS nutritional labeling regulations.

1. FAT

The fat content of the finished product will not exceed 20 percent.

(Percent Fat = (Total Fat ÷ Serving Size) x 100).

2. SODIUM

Sodium level, must not exceed 700 mg per 100 g serving ((Declared Sodium Level (mg) X 100) ÷ Declared Serving Size (grams - racc*) ≤ 700)).

3. MICROBIAL

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

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D. HEATING INSTRUCTIONS AND SERVING SIZE

1. HEATING INSTRUCTIONS

Heating instructions for the end-user will be provided by the offeror and must be included on the immediate packaging. These items will be processed so that the end-user may prepare them in a conventional or microwave type oven for serving.

2. SERVING SIZE

The serving size shall be declared on the nutritional facts panel in accordance with FSIS “referenced amounts customarily consumed*” (racc) regulations and requirements.

E. PREPARATION FOR DELIVERY

1. PACKAGING AND PACKING

- a) Packaging – Cooked patties will be either vacuum packaged or packed in a sealed (tamper proof) immediate package.
- b) Packing – Twenty (20) 2-pound immediate packages will be packed in a 40-pound (net weight) shipping container.

2. LABELING

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

- a) Immediate Container Labels – Immediate container labels will contain the following information:
 - (1) A “Best-If-Used-By” date that is 180 calendar days from the date of production.
 - (2) A nutrition facts panel based on actual nutritional analysis of the product.
 - (3) A traceability code that is traceable back to establishment number, production lot, and date.
 - (4) Heating instructions that describe the preparation of the cooked pork patties in both conventional and microwave type ovens for serving.
- b) Shipping Container Labels – Shipping container labels will contain the following information:
 - (1) USDA shield at least 2-inches high and appearing on the top of the container or on the principle display panel.
 - (2) Applicable contract number.
 - (3) A traceability code that is traced back to establishment number, production lot, and date.
 - (4) A nutrition facts panel based on actual nutritional analysis of the product.
 - (5) The appropriate product code: [A732](#).



3. 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 or taping method.

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4. PALLETIZED UNIT LOADS

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

F. DELIVERY UNIT

Each delivery unit will consist of 950 cases (38,000 pounds).

G. DELIVERED PRODUCT

1. SIZE AND STYLE OF CONTAINER

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

2. TEMPERATURE

All products will not exceed 0°F at the time of shipment and delivery.

3. SEALING

All products must be delivered to AMS assigned destinations under seal with tamper proof, tamper resistant, serially numbered, high security seals that meet the American Society for Testing and Materials Standard F 1157-04 as required under this [supplement](#).

H. PRODUCT ASSURANCE

1. WARRANTY AND COMPLAINT RESOLUTION

- a) Warranty – The contractor will warrant that the product complies with all specification requirements, production plan declarations, and provisions set forth in the program announcement.
- b) Complaint Resolution – Customer complaint resolution procedures will be included in the production plan. These procedures will include: a point of contact, investigation steps, and intent to cooperate with AMS, and product replacement or monetary compensation. The procedures will be used to resolve product complaints from recipient agencies or AMS.

2. NON-CONFORMING PRODUCT

The contractor must have documented procedures that assure nonconforming product identification, segregation, and disposition in order to prevent misuse and that nonconforming product is not delivered to USDA. The contractor will ensure that product which does not conform to product requirements is identified and controlled to prevent unintended use or delivery.

3. AMS MONITORING AND PRODUCTION ASSESSMENT

An AMS Meat Grading and Certification Branch agent must be present during the production of the finished product. The AMS agent will monitor and verify the processing steps, quality assurance activities, and corrective actions to assure that all requirements outlined in the approved production plan are complied with. The AMS agent will be conducting the monitoring and production verification in accordance with applicable MGC instructions. Any deviations to contractual requirements will be reported to the contractor and Contracting Officer.

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