



Federal Purchase Program Specification Canned/Pouch Boned Chicken White Meat: August 2022

I. Purpose

This document provides the procedures USDA, AMS graders (graders) will utilize with the certification of canned/pouched chicken to the [August 2022 Federal Purchase Program Specification \(FPPS\)](#). The grader must read this procedure carefully and note what items must be observed during formulation, sampling, packaging and packing, labeling, loading and shipping, and the preparation of worksheets and certificates. The grader will not proceed until their supervisor has reviewed the: [QAD 620: USDA FPPS – Poultry General Requirements](#) and this procedure with them.

Canned Boned White Chicken (110940 and 100887) or Pouch Boned White Chicken (110477) must be processed and packed as outlined in the FPPS and vendors approved technical proposals. The commodity must not be processed or packaged more than 90 days prior to the first day of the delivery period for each sales order.

Under the [Supplement for Chicken Products Distributed for Federal Nutrition Assistance Programs](#) the contractor is able to select Option A: Grading-Based Monitoring and Certification or Option B: Audit Based Verification for contract compliance and certification of the commodity. Regardless of which option is chosen, all raw material must be graded or certified by the USDA, AMS grader. For all processing steps following raw material collection, the contractor may request the use of either option. These procedures apply for contractors selecting Option A.

II. Procedures

A. Processing & Fabrication

1. Raw Meat Requirements

The commodity must be prepared from freshly harvested ready-to-cook chickens: broilers/fryers without neck and giblets or ready-to-cook hens (mature female chicken) 4.0 pounds or over without neck and giblets. If meat from mature hens is used, a Certificate of Compliance (COC) must be provided from the supplier ensuring that the breast meat came from mature hens that weighed at least 4.0 pounds each. A purchase unit must contain one class of chicken (broiler/fryer or mature hen). Chilled chicken and chicken parts may be transferred or obtained from other processing plants and frozen meat may also be utilized. Mechanically separated (comminuted), finely ground, flaked, finely chopped, or size reduced chicken white meat must not be used.

Prior to production, management must select online sampling prior to thermal processing (Option I) or lot sampling after thermal processing (Option II) to examine product for organoleptic and quality defects. Acceptable Quality Level (AQL) checks will be conducted for organoleptic defects, bone or



hard bone-like material, and other (skin, veins, bruises, blood clots and moderate discolorations). No dark meat or skin is allowed.

For Option I, the grader must randomly select online samples prior to thermal processing and evaluate the product. A 30-piece (prior to size reduction) or 5-pound sample (after size reduction) must be examined and certified for bone and other defects to determine compliance with the FPPS requirements (see FPPS Table 3) on an hourly basis using the sampling frequency and acceptance criteria found in SPL-1. Results must be recorded on LP-232L1. Alternatively, other methods of sampling may be used when approved by the supervisor. If retention occurs, record the reasons for the retention on the applicable worksheet. Because this product is unable to be reworked in finished form, retentions will be limited to the raw product represented by the sample. Graders must do an organoleptic check for each combo bin before they begin processing the raw product. Additional examinations and checks to monitor the processing operation may be necessary as determined by the supervisor. Examination for drained weight must be performed after thermal processing according to section B *Finished Product Checks* of this procedure and the FPPS.

For Option II, the grader must further examine the product samples used for drained weight checks and additional cans/pouches (see FPPS Table 6) to determine compliance with FPPS raw meat requirements (see FPPS Table 4). Results of these examinations will be documented on the reverse side of form LP-232L2 in the remarks per the tolerances.

2. Size Reduction

Breast meat must be reduced in size to a minimum of 0.75-inch cubes. The blades must be checked for proper sizing by checking a sample of cut chicken at the beginning of the shift and recorded (Satisfactory “S” or Unsatisfactory “U”) on the LP-232L2 reverse side.

3. Broth or Water

Broth or potable water with added salt must be used in the commodity. Broth used must be a flavorful broth from the un-pressurized cooking of not less than two or more than four batches of poultry in the same broth. A continuous cooking method may be used, provided water is added during the cooking operation and the process results in a broth equivalent to that described in the preceding sentence. Broth from one batch of pressure-cooked poultry may be used. Broth produced by cooking only fat and bones cannot be used.

Broth must be maintained at a temperature of 160 °F (71.1 °C) or higher or must be chilled to and maintained at a temperature of 40 °F (4.4 °C) or lower within 4 hours of preparation. Broth may not be held for more than 48 hours unless the broth is frozen or dried. The temperature of broth must be checked on an hourly basis and recorded (Satisfactory “S” or Unsatisfactory “U”) on the LP-232L2 reverse side. Product found not meeting temperature requirements must be retained and is not eligible for use in the FPPS.



B. Finished Product Checks

1. Weight Requirements

| | 10.0 oz. Pouch | 12.5 oz. Can | 50.0 oz. Can |
|---------------------------------|----------------|--------------|--------------|
| Min Sample Average Weight | 9.665 oz. | 12.165 oz. | 49.33 oz. |
| Min Individual Container Weight | 9.25 oz. | 11.75 oz. | 48.5 oz. |

- a) Select sample subgroups of five consecutive containers at an average rate of at least one subgroup per hour. Record the net weight of each of the five containers in the subgroup on LP-232L2 reverse side. Total and average each subgroup.
- b) Accept the portion of production represented by a subgroup if the average net weight of the five containers in the subgroup is equal to or greater than the minimum sample average weight. Shift average must meet or exceed weight labeled on the package*.
- c) Retain the portion of production represented by any subgroup if one or both of the following conditions are met:
 - 1) Net weight of one or more containers is less than the minimum individual container weight.
 - 2) The average net weight of the five containers is less than the minimum average container weight.

* To minimize the amount of product subject to retention for being out of compliance, it is permissible for the processor to remove AQL sampling periods that caused the shift average to not comply with the requirements. Product removed to achieve shift average compliance is not eligible for certification.

2. Metal Detection

All finished product must be examined by a metal detection device. Procedures and sensitivity levels are outlined in [QAD 609: Metal Detection](#). Record (*Satisfactory "S" or Unsatisfactory "U"*) on LP-232L2 reverse side.

3. Drained Weight

The grader must conduct drained weight examinations on each lot or subplot of product within 24 to 72 hours following thermal processing. Procedures for determining drained weight listed below must be followed. Results of these examinations will be recorded on the LP-232L2 reverse side.



| | 10.0 oz. Pouch or 12.5 oz. Can | 50.0 oz. Can |
|---|--------------------------------|--------------|
| Min Sample Average Drained Weight | 7.5 oz. | 30 oz. |
| Min Individual Container Drained Weight | 6.5 oz. | 28.5 oz. |

The number of samples is determined according to the FPPS on whether a lot or sub-lot basis is chosen (see Tables 5 and 6 of the FPPS). Individual drain weights are taken while product is at 75°F (+/- 5°F) using a #8 sieve, waiting 2 minutes (10/12.5 oz.) or 3 minutes (50 oz.) and then weighing the chicken.

4. Packaging and Packing

Product packaging must be in accordance with the FPPS. Shipping containers must be closed by commercially accepted methods and materials. Staples or metal straps must not be used for final closure of shipping containers. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. Staples may be used to manufacture and to assemble the fiberboard shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers. Online inspection of the primary containers and shipping containers must be documented on the LP-232 reverse side.

5. Labeling

Commercially labeled packages and shipping containers must be labeled in accordance with USDA Food Safety and Inspection Service (FSIS) requirements. Labeling must be approved by FSIS prior to acceptance for use under this FPPS. The commercial labels must be the processor's own commercial label. Distributors' labels are not allowed. The finished product must contain no more than 300 mg sodium per 100g as evidenced by the nutritional labeling.

C. Certification and Delivery

1. Certification

Any product not meeting the outlined criteria or any other specified requirement must be retained. An LP-210P: *USDA Poultry Products Grading Certificate* must accompany each shipment. The Purchase Order number, Sales Order number, Sales Order Item number, and Seal number must be stated on the LP-210P.

2. Contractor Checkloading

Contractors may use Contractor Checkloading as described in Section R of [QAD 620: USDA FPPS – Poultry General Requirements](#).



Exhibits:

- Exhibit 1 LP-232L1: *Poultry Grading Record* (front side)
- Exhibit 2 LP-232L2: *Poultry Grading Record* (reverse side)

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