



Federal Purchase Program Specification Smoked Turkey Ham: March 2025

I. Purpose

This document provides the procedures USDA, AMS graders (graders) will utilize with the certification of smoked turkey ham products to the [March 2025 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.

Smoked Turkey Hams (100126, 111892) and Sliced Smoked Turkey Hams (111893, 111894) must be processed and packed as outlined in the specification. 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. The chilled commodity must be processed, packaged, packed, and placed in a freezer within 7 calendar days after the date of harvest for. When product is sliced, this requirement is extended to 10 days.

Under the [Supplement for Turkey Products Distributed for Federal Food and 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.

FPPS Item #	Product Name	Pack Size	Cases Per Load	Purchase Unit Size
100126	Turkey Hams	Four approximately 10-pound hams	variable	40,000 lbs.
111892	Turkey Hams	Twenty 2-pound hams	960 cases	38,400 lbs.
111893	Turkey Ham (Sliced)	Eight 5-pound packages	960 cases	38,400 lbs.
111894	Turkey Ham (Sliced)	Twenty 2-pound packages	960 cases	38,400 lbs.

II. Procedures

A. Processing & Fabrication



1. Raw Meat Requirements

The commodity must be prepared from non-basted young turkeys. Boneless skinless turkey thighs used to produce the product must be in complete portions with no more than one half of the meat missing. Turkey thigh meat trimmings may be used if they represent no more than 15% of the total meat block. Frozen meat may also be utilized if in accordance with section 532 of the FPPS. Turkey obtained from other plants may be utilized if it complies with section 534 of the FPPS.

2. Certification Requirements

Prior to size reduction, graders must check 30 pieces of thigh meat for defects to determine compliance with the FPPS requirements (see Table 1 of the FPPS) using the sampling frequency and acceptance criteria found in SPL-1. Results must be recorded on the LP-232L1. All skin must be removed from each part or meat portion. Skin is not allowed to be used in turkey ham and must be recorded as a defect. In addition, a 2-pound sample of thigh trim (as applicable) must be drawn prior to size reduction and examined for defects to determine compliance with FPPS requirements (see Table 1 of the FPPS) using the sampling frequency and acceptance criteria found in SPL-2. Results must be recorded on the LP-232L2. If any sample has more defects than the maximum tolerance for the sample plan, the meat the sample represents must be rejected.

After size reduction, but prior to ham formulation, graders must check a 5-pound sample of size-reduced thigh meat and a 2-pound sample of size-reduced trim meat for defects to determine compliance with the FPPS requirements (see Table 2 of the FPPS) using the sampling frequency and acceptance criteria found in SPL-2. Results must be recorded on the LP-232L2. Mechanically separated turkey (comminuted), finely ground, flaked, or finely chopped turkey meat are unacceptable for use.

3. Product Formulation Verification

Graders must personally observe the formulation of the marinating solution ingredients to certify compliance with the requirements at the frequency stated in [QAD 604: Formulation Certification](#). Results (Satisfactory “S” or Unsatisfactory “U”) of the formulation verification must be documented on the LP-232L2 reverse side. Formulations found that do not meet requirements in section 560 of the FPPS cannot be used and will necessitate additional verification checks. The contractor has the option available to provide the grader with a statement from the spice manufacturer certifying that the spices and seasonings formulation is in compliance with the FPPS requirements.

Size-Reduced Meat Block (minimum)	80.00%
Other Ingredients below (total shall not exceed):	20.00%
-Water (up to)	14.40%
-Added Processing Aids including Curing Agents (up to)	7.60%



B. Stuffing into Casings

After blending, the formulated material must be stuffed into cook-in-bag, pouch, plastic casing, moisture proof casing, standard fibrous casing or smoke impregnated casings for the cooking process. The formulated batches must be stuffed into cases within 48 hours after formulation and must be held at an ambient temperature of less than 40°F.

C. Smoking

Stuffed casing of formulated products may be smoked. Alternatively, liquid smoke flavoring or smoke impregnated fibrous casings may be used. The producer must inform the grader of the smoking method used and the commercial label should match their stated method.

D. Finished Product Checks

1. Cooked Temperatures

Graders must follow the procedures for temperature verification in [QAD 608: Cooking Temperature Certification](#). The temperature must be checked on a sampling interval basis or more frequently if conditions warrant. All products must be fully cooked in accordance with USDA, FSIS Regulations.

2. Color Defects

The cooked turkey hams will be sampled and examined for color defects per [QAD 641: Poultry Products Color Defects](#). Online sampling will be performed on randomly selected product after the cooking operation and prior to freezing. Results must be recorded on the LP-232L2. Compliance with the color uniformity requirements for turkey hams will be determined by checking 10 random turkey hams. Smoked turkey hams must have a mahogany color that is commonly associated with smoked meats and not be within the light and dark tolerances shown on the chart “Color Control on Smoked Turkey Hams” prepared by Poultry Programs and dated July 1994. A copy of this document can be made available by request sent to the National Poultry Office.

3. Dimension Requirements

Ten turkey hams must be checked for diameter requirements (see FPPS Table 3) according to procedures established [QAD 607: Portion Control and Weight Range Certification](#). When checking for the 4-5” diameter requirement, units found exceeding allowable tolerance of +/- 0.25 inch will be recorded as a defect. Based on this tolerance, the minimum and maximum acceptable diameter size range is 3.75” and 5.25”. Sample intervals exceeding defect tolerances require retention of product represented by the sample. Results must be recorded on the LP-232L2.



4. Physical Characteristics

Cooked turkey hams must be sampled and examined for interior and exterior defects after final packaging and prior to freezing. During each sampling interval that turkey hams are produced, the grader must randomly select 2 hams from different segments of the production period and examine the product for defects outlined in the FPPS (see Table 3 of the FPPS). For products not already sliced, each sample ham must be sliced widthwise into three approximately equal portions and two interior surfaces will be examined (excluding mirrored surfaces) for defects using SPL-2. Results (*Satisfactory* “S” or *Unsatisfactory* “U”) must be recorded on the LP-232L2 reverse side.

5. Organoleptic Examination

The fully cooked product must be examined on a continuous basis in accordance with [QAD 614: Organoleptic Examination](#) and FPPS requirements stated in section 550. The fully cooked product will be sampled and examined for organoleptic defects to determine compliance with FPPS requirements (see FPPS Table 2). Online sampling will be performed on randomly selected product after the cooking operation and prior to freezing. Results (*Satisfactory* “S” or *Unsatisfactory* “U”) must be recorded on the LP-232L2 reverse side.

The fully cooked product will be examined for organoleptic defects by visual examination and smelling for each sampling interval product is produced. This examination must include checking for defects such as overcooked, scorched, undercooked, and areas of dehydration. If such defects are found in the sample, the lot or product the sample represents must be retained. Sample size will be 10 for the above criteria.

6. Freezing Requirement

The chilled commodity must be processed, packaged, packed, and placed in a freezer within 7 calendar days after the date of harvest for. When product is sliced, this requirement is extended to 10 days. All cooked product must be frozen in a manner to bring the internal temperature of the product at the center of the package to 10°F, or below within 72 hours from the time of entering the freezer. Specific guidelines on freezing and holding temperature requirements are outlined in [QAD 613: Frozen Product Examination](#).

7. Metal Detection

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

8. Net Weight

Online sampling procedures found in [QAD 611: Net Weight Examination](#) can be used to ensure each finished shipping container weighs at least 40 pounds. For 100126 each delivery unit must consist of



1000 shipping containers weighing 40 pounds each with a total net weight of 40,000 pounds. For 111892, 111893, & 111894 each delivery unit must consist of 960 containers weighing 40 pounds each with a total net weight of 38,400 pounds. Four approximately 10-pound, eight 5-pound, or twenty 2-pound packages will be packed in each shipping container in accordance with the FPPS and material code.

9. Packaging and Packing/Tamper Evident

The packaging and packing material must be “tamper-evident.” Tamper-evident is defined as packaging or packing materials with one or more indicators or barriers to entry, which, if breached or missing, can reasonably be expected to provide visible evidence that tampering has occurred. Examples include damage to the box from tape being removed, or a hole in the plastic bag from it being torn or cut open, that would be obvious to a person inspecting the product. Determination of whether the material meets these requirements may be made by the supervisor. At time of shipment, each lot will undergo an examination for packaging and packing defects per [QAD 617: Packaging and Packing](#).

10. Labeling

Contractors have the option to use commercial or USDA labeling. All 2-pound and 5-pound packages destined for households as noted on the purchase order must be individually labeled. Labeling must meet all requirements in section 700 of the FPPS. Child Nutrition (CN) labeling information or a Product Formulation Statement demonstrating product contribution to the National School Lunch Program meal pattern requirements is required. When CN labeling is used it should contain a crediting statement within the CN box stating that there is a 2 ounce equivalent meat/meat alternate per 2.90-ounce to 3.25-ounce serving.

Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number or production date. An AMS grader or other authorized personnel under the supervision of the AMS grader must stamp one end of each shipping container at the origin facility. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container. As an alternative to stamping, the contractor may preprint the stamp on the shipping container or label. Prior approval by the Poultry National Office is required before using this alternative method.

The sodium content of the cooked commodity should be no more than 600 mg per 100 gram basis as evidenced by nutritional labeling.

E. Certification and Delivery

1. Temperature Requirement

At time of shipment, product must be 2°F, or below. Product with internal temperatures of 3°F to 5°F will be tentatively rejected. Tentatively rejected product may be returned to the freezer and may be re-



offered for shipment one time only. Product exceeding 5°F, or product that was tentatively rejected and exceeds 2°F when reoffered, must be rejected. Procedures for checking product temperatures are outlined in [QAD 613: Frozen Product Examination](#). Sampling levels will be according to the processor's current freezing history. As an option to checking product at time of shipment, and upon review and approval by the supervisor, plants may use the alternate verification procedures as described in QAD 613, as well.

2. 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. See attached certificate example.

3. Contractor Checkloading

Contractors have the option to utilize Contractor Checkloading as described in [QAD 620: General Donated Commodity Instructions](#).

Exhibits:

Exhibit I - LP-210P Smoked Turkey Ham Certificate Example

Exhibit II – LP210P Smoked Turkey Ham Split Delivery Certificate Example

In accordance with Federal civil rights law and U.S. Department of Agriculture (USDA) civil rights regulations and policies, the USDA, its Agencies, offices, and employees, and institutions participating in or administering USDA programs are prohibited from discriminating based on race, color, national origin, religion, sex, disability, age, marital status, family/parental status, income derived from a public assistance program, political beliefs, or reprisal or retaliation for prior civil rights activity, in any program or activity conducted or funded by USDA (not all bases apply to all programs). Remedies and complaint filing deadlines vary by program or incident.

Persons with disabilities who require alternative means of communication for program information (e.g., Braille, large print, audiotape, American Sign Language, etc.) should contact the State or local Agency that administers the program or contact USDA through the Telecommunications Relay Service at 711 (voice and TTY). Additionally, program information may be made available in languages other than English.

To file a program discrimination complaint, complete the USDA Program Discrimination Complaint Form, AD-3027, found online at [How to File a Program Discrimination Complaint](#) and at any USDA office or write a letter addressed to USDA and provide in the letter all of the information requested in the form. To request a copy of the complaint form, call (866) 632-9992. Submit your completed form or letter to USDA by: (1) mail: U.S. Department of Agriculture, Office of the Assistant Secretary for Civil Rights, 1400 Independence Avenue, SW, Mail Stop 9410, Washington, D.C. 20250-9410; (2) fax: (202) 690-7442; or (3) email: program.intake@usda.gov.

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United States
Department of
Agriculture

Agricultural
Marketing
Service


Quality Assessment Division
1400 Independence Avenue SW, Stop 0258
Washington, DC 20250

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April 25, 2025
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EXHIBIT I

(See reverse side of form for OMB and EEO Statement)

OMB APPROVED: NO. 0581-0128

	U.S. DEPARTMENT OF AGRICULTURE AGRICULTURAL MARKETING SERVICE Livestock and Poultry Program	This certificate is receivable in all courts of the United States as prima facie evidence of the truth of the statements therein contained. This certificate does not excuse failure to comply with any of the laws and regulations enforced by the United States Department of Agriculture.	CERTIFICATE NO. PPA- 1767530
	POULTRY PRODUCTS GRADING CERTIFICATE		PLACE EXAMINED Zeeland, MI
			PLANT NUMBER P- 261

APPLICANT (Name and address, including ZIP) Cluck Poultry Company 2468 Wheat St Corn Belt, IA 56789	NAME AND ADDRESS OF SHIPPER OR SELLER <u>1/</u> Same As Applicant	NAME AND ADDRESS OF RECEIVER OR BUYER <u>1/</u> State of New Jersey 345 Jersey Road Newark, NJ 23899
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LOT NO.	NO. CONTAINERS PER LOT <u>1/</u>	NO. CONTAINERS EXAMINED	PRODUCT (KIND, CLASS, TYPE, STYLE, SUBSTYLE)	MARKED WEIGHT OF LOT <u>1/</u>	TEST <input type="checkbox"/> Shortage <input type="checkbox"/> Overage	TOTAL NET	OFFICIAL U.S. GRADE
1	960	All	Frozen, Cooked, Smoked Turkey Ham Sliced, Eight 5-pound	-----	-----	38,400	-----

LOT NO.	TYPE AND CONDITION OF CONTAINERS	WHERE HELD AND TEMPERATURE	CONTAINERS WERE STAMPED WITH
1	New Fiber Boxes	Trailer -10° F	USDA Contract Compliance with date mm/dd/yy
		Seal # 12345	

ADDITIONAL CERTIFICATION

Product represented by this certificate meets specification requirements for: FPPS for Smoked Turkey Ham (111893) DATED March 2025			<input checked="" type="checkbox"/> Product derived from poultry of domestic origin. <input checked="" type="checkbox"/> Certification determined by online sampling. <input checked="" type="checkbox"/> The number of containers shown above was counted by the official grader. <input type="checkbox"/> Destination weight and temperature certification.
PURCHASE ORDER # 4100002093	SALES ORDER # 5000123854	ITEM # 100	Test weighing performed on _____ at _____ am/pm.

REMARKS:

Total net weight of product represented on this certificate was determined using the QAD 611 online test weighing procedures.

CERTIFICATION STATEMENT

In compliance with the Regulations of the Secretary of Agriculture Governing the Grading of Poultry issued pursuant to the Agricultural Marketing Act of 1946, as amended, and any other Act of Congress conferring like authority, it is certified that the product(s) listed hereon were examined and that the class, quality, quantity, and/or condition of the product(s) at the time and on the date shown, were as stated above.

Printed Grader's Name

Grader's Signature

mm/dd/yyyy

OFFICIAL GRADER (Printed Name & Signature)

DATE

1/ As stated by applicant or contractor.



United States
Department of
Agriculture

Agricultural
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Service


Quality Assessment Division
1400 Independence Avenue SW, Stop 0258
Washington, DC 20250

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EXHIBIT II - Split Delivery

(See reverse side of form for OMB and FEO Statement)

OMB APPROVED: NO. 0581-0128

	U.S. DEPARTMENT OF AGRICULTURE AGRICULTURAL MARKETING SERVICE Livestock and Poultry Program POULTRY PRODUCTS GRADING CERTIFICATE	This certificate is receivable in all courts of the United States as prima facie evidence of the truth of the statements therein contained. This certificate does not excuse failure to comply with any of the laws and regulations enforced by the United States Department of Agriculture.	CERTIFICATE NO.
			PPA- 1093348
			PLACE EXAMINED Springfield, IL
			PLANT NUMBER P-7734

APPLICANT (Name and address, including ZIP)	NAME AND ADDRESS OF SHIPPER OR SELLER <u>1/</u>	NAME AND ADDRESS OF RECEIVER OR BUYER <u>1/</u>
Deer Valley Poultry Co. 270 Winchester Lane Deer Valley, Pa 17110	Same as Applicant	See Remarks

LOT NO.	NO. CONTAINERS PER LOT <u>1/</u>	NO. CONTAINERS EXAMINED	PRODUCT (KIND, CLASS, TYPE, STYLE, SUBSTYLE)	MARKED WEIGHT OF LOT <u>1/</u>	TEST <input type="checkbox"/> Shortage <input type="checkbox"/> Overage	TOTAL NET	OFFICIAL U.S. GRADE
1	960	-----	Frozen, Cooked, Smoked Turkey Ham, Twenty 2-pound	-----	-----	38,400	-----

LOT NO.	TYPE AND CONDITION OF CONTAINERS	WHERE HELD AND TEMPERATURE	CONTAINERS WERE STAMPED WITH
1	New Fiber Boxes	Trailer -10° F	USDA Contract Compliance with date mm/dd/yy

ADDITIONAL CERTIFICATION

Product represented by this certificate meets specification requirements for: FPPS for Smoked Turkey Ham (111892) DATED March 2025		<input checked="" type="checkbox"/> Product derived from poultry of domestic origin. <input checked="" type="checkbox"/> Certification determined by online sampling. <input checked="" type="checkbox"/> The number of containers shown above was counted by the official grader. <input type="checkbox"/> Destination weight and temperature certification.
PURCHASE ORDER # 410002055	SALES ORDER # 5000026781	ITEM # See Remarks
Test weighing performed on _____ at _____ am/pm.		

REMARKS:

Stop 1 Item: 100 Number of containers = 480 Total Net Weight = 19,200 LBS
Department of Education - New York State
555 Albany Ave
Albany, NY 12048

Stop 2 Item: 200 Number of Containers = 480 Total Net Weight = 19,200 LBS
Department of Education - New York State
888 Main St.
Bronx, NY 10474

Total net weight of product represented on this certificate was determined using the QAD 611 online test weighing procedures.

Stop 1 Seal: 12345
Stop 2 Seal: 23456 given to driver

CERTIFICATION STATEMENT

In compliance with the Regulations of the Secretary of Agriculture Governing the Grading of Poultry issued pursuant to the Agricultural Marketing Act of 1946, as amended, and any other Act of Congress conferring like authority, it is certified that the product(s) listed hereon were examined and that the class, quality, quantity, and/or condition of the product(s) at the time and on the date shown, were as stated above.

Printed Grader's Name

Grader's Signature

mm/dd/yyyy

OFFICIAL GRADER (Printed Name & Signature)

DATE

1/ As stated by applicant or contractor.