



NET WEIGHT EXAMINATION

Purpose

This instruction defines procedures for evaluating net weight of lots certified by employees of the Meat Grading and Certification (MGC) Branch. These procedures may also be applied to quality management systems approved under the Quality Systems Certification Program (QSCP).

Procedures

Further processors shall:

1. Develop and maintain a scale calibration program that is certified by State or local government officials or an equivalently registered or licensed technician.
2. Ensure that scales are calibrated in accordance with the National Institute of Standards and Technology, Handbook 44.
3. Ensure that scales are calibrated daily prior to the start of production.
4. Ensure that a licensed technician has calibrated, initialed, and dated scales within the last 30 days.
5. Maintain copies of licenses or certificates of all in-house technicians and a scale calibration log for review by Agricultural Marketing Service (AMS) agents.

Determine box tare weight.

On a certified digital scale, weigh ten empty containers and associated packaging materials of the same quantity and type to be used in the production lot. Boxes must be weighed daily.

Packaging materials may be weighed once and the weight recorded as long as the type and quantity of material does not change. Divide the total weight by ten to determine the per unit tare weight. Calculate all values to the second decimal point. Record the box tare weight on the sample plan (Sample Plan Box or Sample Plan Combo).

Select samples.

Randomly select ten filled and closed containers from each production lot. Containers may be selected during normal production or upon completion of the lot, as determined by local procedures.

Weigh samples.

Weigh containers on a certified digital scale as they are selected. Withhold sample information until all samples have been selected, weighed, and recorded.

Record sample information.

1. Subtract the tare weight from the gross sample weight to determine the net sample weight. Record the net weight of each sample on the sample plan.
2. Calculate the average of the marked net weights and the average and range of the sample net weights.
3. Record the average of the net weights on the sample plan.

Determine acceptability of lot.

Accept lots if the average weight of the samples is greater than or equal to the average marked net weights on the container.

Return sample containers to lot.

Sample containers may be returned to the normal flow of production immediately after sampling and recording information. Box numbers on sample plan forms are used to provide sample traceability.

Evaluating rejected and reworked lots

Lots rejected for net weight may be reworked and resubmitted for reexamination one time only. When examining resubmitted lots, a sample of four shipping containers per lot shall be selected and weighed. The finding of any shipping container in the reassembled lot which is less than the marked net weight shall cause rejection of the lot.

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Exhibit A	Exhibit B

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EXHIBIT B

COMBO SAMPLE PLAN WORKSHEET				
LOT SIZE:	COMBOS	SAMPLE SIZE:	GRADER:	DATE:

COMBO	1
1	2
3	4
5	6
7	8

COMBO	2
9	10
11	12
13	14
15	16

COMBO	3
17	18
19	20
21	22
23	24

COMBO	4
25	26
27	28
29	30
31	32

COMBO	5
33	34
35	36
37	38
39	40

COMBO	6
41	42
43	44
45	46
47	48

COMBO	7
49	50
51	52
53	54
55	56

COMBO	8
57	58
59	60
61	62
63	64

COMBO	9
65	66
67	68
69	70
71	72

COMBO	10
73	74
75	76
77	78
79	80

COMBO	11
81	82
83	84
85	86
87	88

COMBO	12
89	90
91	92
93	94
95	96

COMBO	13
97	98
99	100
101	102
103	104

COMBO	14
105	106
107	108
109	110
111	112

COMBO	15
113	114
115	116
117	118
119	120

COMBO	16
121	122
123	124
125	126
127	128

COMBO	17
129	130
131	132
133	134
135	136

COMBO	18
137	138
139	140
141	142
143	144

COMBO	19
145	146
147	148
149	150
151	152

COMBO	20
153	154
155	156
157	158
159	160

XX- Two samples from the same position

DEFECTS	
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ACCEPT	
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REJECT	
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1	
2	
3	
4	
5	

6	
7	
8	
9	
10	

11	
12	
13	
14	
15	

16	
17	
18	
19	
20	

SS 6.5 25
 8 ACC/REJ
 13 1-2 5-6
 2-3 7-8

SS 6.5 25
 20 ACC/REJ
 32 3-4 10-11
 5-6 14-15

Note: Federal Purchase will usually only use one level of defects (25)