



Federal Purchase Program Specification

Whole Muscle Turkey Breast, Fully Cooked, Frozen: September 2022

I. Purpose

This document provides the procedures USDA, AMS graders (graders) will utilize with the certification of whole muscle turkey breast to the [September 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 should not proceed until their supervisor has reviewed the: [QAD 620: USDA FPPS – Poultry General Requirements](#) and this procedure with them.

Whole Muscle Turkey Breast, Fully Cooked, Frozen (111222) must be processed and packed as outlined in the specification and contractor's 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. The chilled commodity must be processed, cooked, packaged, packed, and placed in a freezer within 7 calendar days after the date of harvest.

Under the [Supplement for Turkey 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 young turkeys. Grade A turkey breast meat must be non-basted but, may be skin-on or skinless. Skin that is not attached to turkey breast meat must not be used in the commodity.

2. Grading Requirement

Prior to marinating, a sample of 30 pieces of boneless turkey breast meat, with or without skin, must be drawn and examined for defects to determine compliance with U.S. Grade A requirements using the sampling frequency and acceptance criteria found in SPL-1. Results must be recorded on LP-232L1.



3. Product Formulation Verification

Graders must personally observe the formulation 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 FPPS requirements will not be acceptable and will necessitate additional formulation verification checks. Ingredients must be used to produce a finished product and incorporated through vacuum tumbling or injection.

Turkey Breast Meat	82.00 percent
Water (up to)	16.00 percent
Seasoning	1.50 percent
Phosphate (sodium or potassium) (up to)	0.50 percent

The sodium content of the cooked commodity will be no more than 550 mg per 100 gram basis.

B. Fully Cooked Product Checks

1. Styling

Turkey Breasts must be fully cooked in accordance with USDA, Food Safety and Inspection Service (FSIS) regulations. Single whole muscle breast lobe may be size reduced to meet the weight requirement provided at least one-half of the breast remains intact, and the normal symmetrical shape and appearance of the whole muscle breast is retained.

2. Weight Requirements

Each cooked turkey breast must weigh between 3.0-6.0 pounds which will be certified using procedures found in [QAD 607: Portion Control and Weight Range Certification](#). A sample of 10 turkey breasts must be weighed each sampling interval. Results must be recorded on LP-232L2.

3. Temperature Requirements

Cooking and cooling must be performed in accordance with approved USDA, FSIS method(s) directives and guidelines.

4. Organoleptic

The fully cooked turkey breasts will be examined for organoleptic defects to determine compliance with FPPS requirements. Online sampling will be performed by randomly selecting product after the cooking operation and prior to freezing. Cooked turkey breasts will be examined for organoleptic defects by visual examination and smelling for each sampling interval product is produced. Results (Satisfactory “S” or Unsatisfactory “U”) must be recorded on the LP-232L2 reverse side.



C. Finished Product Checks

1. 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.

2. Net Weight

Each delivery unit must consist of 950 shipping containers, ranging from 34 to 42 pounds, and must not exceed 39,900 pounds net weight (with a minimum of 34,000 pounds). Net weight examination procedures are outlined in [QAD 611: Net Weight Examination](#). Results from online test weighing should be recorded on LP-232L2 reverse side.

3. Packaging and Packing/Tamper Evident

To meet the requirements of the FPPS, 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](#).

4. Labeling

Contractors must use commercial labels. Labeling must meet all requirements in Section 700 of the FPPS. 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 National Poultry Supervisor is required before using this alternative method.

5. Freezing Requirements

All cooked product must be placed in a freezer within 48 hours of packing and 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 the product enters the freezer. Specific guidelines on freezing and holding temperature requirements are outlined in [QAD 613: Frozen Product Examination](#). In lieu of



drilling into the RTE product, temperatures may be obtained by sandwiching the temperature probe between two packages of product.

NOTE: If the contractor chooses to utilize Contractor Checkloading, the grader will not be required to perform any further certification activities once the 0°F in 72 hour freezing requirement is met.

D. Certification and Delivery

1. Temperature Requirement

At time of shipment, product must be 2°F or below. Product with internal temperatures exceeding 2°F and up to 5°F will be tentatively rejected. Tentatively rejected product may be returned to the freezer and 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. Sampling levels will be according to the processors 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: Frozen Product Examination](#).

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 on the LP-210P. See attached LP-210P certificate example.

3. Contractor Checkloading

Contractors have the option to utilize Contractor Checkloading as described in Section R of [QAD 620: USDA FPPS – Poultry General Requirements](#).

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