



Federal Purchase Program Specification Turkey Taco Filling: November 2021

I. Purpose

This document provides the procedures USDA, AMS graders (graders) will utilize with the certification of turkey taco filling to the [November 2021 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.

Turkey Taco Filling, Frozen, Fully Cooked (100119) must be processed and packed as outlined in the specification and the contractor's approved technical proposal. 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.

II. Procedures

A. Processing & Fabrication

1. Meat and Skin Requirements

Turkey taco filling must be prepared from ground turkey meat (with skin attached or without skin) or ready-to-cook non-basted young turkey carcasses and parts (no solution or ingredients added). Frozen meat may be utilized if it meets criteria in Section 532 of the FPPS. Neck skin, crop skin, and any skin that is not attached to meat must not be used. When using drumstick meat, the tibiotarsus must be removed prior to processing through a desinewer to remove tendons.

2. Certification Requirements

Prior to formulation graders must check 30 pieces of each meat component (boneless parts, deboned drumsticks, and bone in parts) for defects to determine compliance with the FPPS requirements (see FPPS Table 1) using the sampling frequency and acceptance criteria found in SPL-1. Results must be recorded on the LP-232L1. If the sample has more defects than the maximum tolerance for the sample plan, the meat the sample represents must be rejected.

The meat must be processed and blended to produce a uniform blend of meat and skin having the functional properties of ground turkey. Meat must be sized reduced by being ground through a plate with 0.125 inch (3.175 mm) diameter holes or desinewed through a plate with 0.0591 inch to 0.0787 inch (1.5 mm to 2.0 mm) diameter holes to ensure removal of tendons. Ground meat that is comminuted, emulsified, of pasty consistency, discolored, or contains skin detached from meat is



unacceptable. A 5-pound sample of ground turkey must be examined for defects (see FPPS Table 2) using sampling frequency and acceptance criteria found in Sampling Plan Level 2 (SPL-2). Regardless of the kind and number of defects found, any sample with bone or hard bone-like material must be cause for the rejection of the meat the sample represents.

3. White/Dark Meat Ratio

Formulation or raw product may contain a maximum of 30 percent white meat which may consist of wing meat or scapula portion. White meat trimmed from the frame may be used, but not in excess of 3 percent of the total formulation. The remaining amount must be dark meat consisting of boneless thighs or boneless skinless thighs and desinewed drumstick meat. Dark meat trimmed from the frame may be used, but not in excess of 2 percent of the total formulation. Formulation is based on bone-in weight before size reduction.

4. Product Formulation Verification

Graders must personally observe the formulation at the frequency stated in [QAD 604: Formulation Certification](#). Results of the formulation verification must be documented on the LP-232L2. Formulations that do not meet FPPS requirements in Sections 570-573 of the FPPS will not be acceptable and will necessitate additional formulation verification checks.

Other ingredients may include potassium phosphate. Soy Protein in dry form may not exceed 6% of the total formula. Gluten and MSG are not allowed.

B. Fully Cooked Product checks

1. Cooked Temperature

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. Appearance and Dimensions

Following cooking, a package of the finished product must be examined for defects (see FPPS table 3) using sampling frequency and acceptance criteria found in Sampling Plan Level 2 (SPL-2). If any sample does not comply with any requirement, the product the sample represents must be rejected for use. Results (*Satisfactory "S" or Unsatisfactory "U"*) must be documented on the LP-232L2 reverse side.

3. Organoleptic Examination

The ready to cook turkey must be examined on a continuous basis in accordance with [QAD 614: Organoleptic Examination](#) and FPPS requirements stated in Section 554.



The fully cooked turkey taco meat will be examined for organoleptic defects (see FPPS Table 3). Online sampling will be performed by 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.

4. Freezing Requirement

Immediately after cooking, product must be placed under refrigeration where the internal temperature of the cooked packaged product is continuously lowered. 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](#).

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

Online sampling procedures found in [QAD 611: Net Weight Examination](#) can be used to ensure each finished shipping container weighs at least 30 pounds. Each delivery unit must consist of 1300 shipping containers weighing 30 pounds each with a total net weight of 39,000 pounds. Six 5-pound or ten 3-pound bags will be packed in each shipping container in accordance with the FPPS.

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 have the option to use commercial or USDA labeling. 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. 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 300 mg per 100 gram basis as evidenced by nutritional labeling.

D. Certification and Delivery

1. Temperature Requirement

At time of shipment, product must be 2°F or below. In lieu of drilling into the product, it is acceptable to sandwich the temperature probe between two unopened bags of product until the temperature stabilizes. 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. See attached certificate example.

3. Contractor Checkloading

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


Exhibit:

Exhibit 1 - LP-210P Taco Filling Certificate Example

EXHIBIT 1

(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- 1098563
	POULTRY PRODUCTS GRADING CERTIFICATE		PLACE EXAMINED Corn Belt, IA
			PLANT NUMBER P-1234

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 Wisconsin 5435 Cheese Blvd Madison, WI 53737
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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		TOTAL NET	OFFICIAL U.S. GRADE
					<input type="checkbox"/> Shortage	<input type="checkbox"/> Overage		
1	1300	----	Frozen, Cooked Turkey Taco Filling	39,000			39,000	-----

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/yyyy
		Seal # 40221	

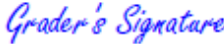
ADDITIONAL CERTIFICATION

Product represented by this certificate meets specification requirements for: FPPS for Turkey Taco Filling _____ (100119) _____ DATED November 2021			<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 # 4100032145	SALES ORDER # 500024568	ITEM # 100	Test weighing performed on _____ at _____ am/pm.

REMARKS:

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		mm/dd/yyyy
OFFICIAL GRADER (Printed Name & Signature)		DATE

1/ As stated by applicant or contractor.

LP-210P (08/2021) (Previous LPS-210P editions may be used.)