

Agricultural Marketing Service (AMS)
Livestock and Poultry (LP) Program
Standards and Specifications Division (SSD)
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**FEDERAL PURCHASE
SPECIFICATION (FPPS) FOR
FULLY-COOKED, SMOKED
TURKEY HAM PRODUCTS**

Supersedes: FPPS for Smoked Turkey Ham April 2020 –
Changes from previous requirements in [blue](#)

Effective: [August 2024](#)

100 ITEM DESCRIPTION

- 110 Smoked Turkey Ham – Frozen, fully cooked smoked turkey hams, produced from non-basted, ready-to-cook chunked and formed turkey thigh meat. Each smoked turkey ham shall be vacuum packaged in a shrinkable oxygen and moisture proof bag or casing, and be packed as:
- 110.1 100126 – Four (4) [approximately](#) 10-pound smoked turkey hams [packed into shipping containers with a net weight of 40 pounds](#). The packaged commodity shall be 4 to 5 inches in diameter and round. A purchase unit shall [consist of 1,000 cases totaling](#) 40,000 pounds.
- 110.2 100886 – Twenty (20) 2-pound smoked turkey hams [packed into shipping containers with a net weight of 40 pounds](#). The packaged commodity shall be 4 to 5 inches in diameter and round. A purchase unit shall [consist of 1,000 cases totaling](#) 40,000 pounds.
- 110.3 110911 (Sliced) – Eight (8) 5-pound packages of thinly sliced (not shaved), shingle layered smoked turkey ham packed into shipping containers with a net weight of 40 pounds. A purchase unit shall [consist of 1,000 cases totaling 40,000 pounds](#).
- 110.4 111223 (Sliced) – Twenty (20) 2-pound packages of thinly sliced (not shaved), shingle layered smoked turkey ham packed into shipping containers with a net weight of 40 pounds. A purchase unit shall [consist of 1,000 cases totaling](#) 40,000 pounds.

200 APPLICABLE DOCUMENTS

- 210 The following documents are incorporated as part of this USDA, AMS, SSD on FPPS – Smoked Turkey Ham Products – [August 2024](#):
- 210.1 AMS/LP/Quality Assessment Division (QAD) Policies and Procedures.

- 210.2 Poultry Products Inspection Regulations (9 CFR § 381).
- 210.3 Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 CFR § 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*, 9 CFR § 381.170 to 172).
- 210.4 AMS Master Solicitation for Commodity Procurements – Domestic Programs (MSCP-D) [and Solicitation](#).

300 CHECKLIST OF REQUIREMENTS

- 310 Domestic Products – Refer to the current AMS MSCP-D.
- 320 Food Defense – Refer to the current AMS MSCP-D.
- 330 [Pre-Bid Contract Compliance and Certification Requirements – Refer to the Supplement for Turkey Products](#). The Contractor shall ensure that all raw material is graded or certified by the USDA AMS Grader. For all processing steps, following raw material certification, the Contractor may request the use of either Option A – AMS QAD Grading-based Monitoring and Certification service, or Option B – QAD Audit-based Verification service, for assessing contract compliance of the finished product.

400 HARVESTING

- 410 All harvesting activities shall comply with all applicable Food Safety and Inspection Service (FSIS) regulations and requirements, including 9 CFR § 381, and shall be done under FSIS inspection.
- 420 Humane Handling – All poultry shall be humanely handled in accordance with [FSIS Directive 6110.1 Verification of Poultry Good Commercial Practices](#).

500 PROCESSING

- 510 All processing activities shall comply with all applicable FSIS regulations and requirements, including 9 CFR § 381, and shall be done under FSIS inspection.
- 511 Date Processed – The commodity shall not be processed more than 90 calendar days prior to the first date of the delivery period for each sales order.
- 512 Lot Definition – A lot is the amount of packaged commodity produced during a processing shift.
- 520 Performance Standards – Product shall be produced under FSIS pathogen reduction standards, as specified in 9 CFR § 381.
- 521 Inspection for contract and FPPS Compliance shall be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 CFR § 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*).

- 522 AMS Certification – Procedures and a schedule of fees for these services may be obtained by contacting the nearest QAD field office. This information can be found on the [QAD Procedures webpage \(https://www.ams.usda.gov/resources/qad-procedures\)](https://www.ams.usda.gov/resources/qad-procedures), or by contacting:
- USDA/AMS, Livestock and Poultry Program, Office of the Deputy Administrator,
1400 Independence Avenue, SW, Washington, DC 20250-0258, Room 2092-S,
STOP 0249, Office Phone Number (202) 720-5705.
- 523 The AMS Grader shall be responsible for certification of [raw material](#) compliance with the requirements of this FPPS for ready-to-cook turkey carcasses and parts. This includes certification of [organoleptic requirements and defects for meat, trim and size-reduction as outlined in Table 1 and Table 2](#).
- 523.1 [Based on the option selected, the AMS Grader and/or Auditor](#) shall be responsible for [certification or verification of](#) formulation and fabrication of turkey hams; smoking, cooking and cooling turkey hams; slicing; packaging and packing; freezing; labeling and marking; sampling; and net weight.
- 523.2 [Under AMS QAD Grading-based Monitoring and certification](#), all steps in the manufacturing process shall be under the direct supervision of an AMS Grader and as outlined in QAD Policies and Procedures for quality and compliance with product requirements. The AMS Grader may also select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination.
- 523.3 [Under AMS QAD Audit-based Verification](#), all steps in the manufacturing process shall be verified through routine audits performed by an AMS Auditor according to the Contractor's and/or Subcontractor's approved technical proposal and the applicable FPPS.
- 523.3.1 [The Contractor and/or Subcontractor shall ensure that raw material procured is certified by an AMS Grader and accompanied by an USDA LP 210-S Poultry Products Grading Certificate stating that raw material requirements of this FPPS are met.](#)
- 530 Boneless, Skinless Thigh Meat
- 531 The commodity shall be produced from non-basted, young ready-to-cooks turkeys in accordance with [AMS 70.200 et seq](#). Boneless, skinless turkey thighs shall be in recognizable portions; that is, complete thighs, or thighs with no more than one-half of the meat missing.
- 531.1 Turkey thigh meat trimmings that are removed from the turkey thighs during the boning and trimming process may be used if they represent no more than 15 percent of the total weight of the turkey thigh meat as specified in the formulation section.

- 531.2 Skin – Shall not be used in the commodity. All skin shall be removed from each part or meat portion.
- 532 Frozen meat may be used when:
- 532.1 produced from freshly harvested turkeys;
- 532.2 packaged to protect against quality deterioration during frozen storage and identified so the time in storage and the class, kind, and specific deboned turkey product can be determined;
- 532.3 held not more than 180 days in frozen storage; and
- 532.4 product shows no evidence of thawing and refreezing or freezer deterioration.
- 533 Other than the final freezing process for finished, packaged commodity, the commodity shall not be derived from turkey meat that has been frozen more than one time.
- 534 Turkey from Other Plants – Turkey carcasses and parts may be transferred or obtained from other processing plants provided it:
- 534.1 has been processed, handled, and identified in accordance with this FPPS, and
- 534.2 complies with the non-basted, organoleptic, and other applicable requirements of this FPPS as evidenced by USDA certification. USDA certification may occur either at the plant of origin or at the receiving plant [by the USDA AMS Grader](#).
- 535 Type, class, and specific name of the product, part, boneless, skinless part or meat; date harvested or date placed in frozen storage, as applicable; and the USDA-assigned plant number shall be shown on each shipping container.
- 536 The chilled turkey and parts shall maintain an internal product temperature between 26°F (-3.3°C) and 40°F (4.4°C) during transit, from plant origin to destination.
- 540 Meat Time Requirements
- 541 Smoked Turkey Ham (100126 and 100886) – The chilled commodity shall be processed, packaged, packed, and placed in a freezer within 7 calendar days after the date of harvest.
- 542 For sliced commodity (110911 and 111223) – The chilled commodity shall be processed, packed in casing, sliced, packaged, packed and placed in a freezer within 10 calendar days after the date of harvest.
- 543 Maximum Temperature – The temperature of the meat shall not exceed 55 °F (12.8 °C) at any time during preparation or processing into the commodity.
- 544 Cooling Requirements – The thigh meat which is not used in the commodity on a

continuous basis, after deboning shall be cooled by methods or media to continuously lower and ensure that the internal product temperature is between 26 °F (-3.3 °C) and 40 °F (4.4 °C).

- 544.1 Cooling Medium – Cooling methods and media, such as liquid carbon dioxide (CO₂), dry ice or liquid nitrogen (N₂), may be used to maintain the temperature of meat.
- 544.2 Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat or parts shall not be incorporated into the commodity. Liquid associated with normal product purge is acceptable.
- 550 Organoleptic Requirements and Defects for Meat
- 551 Organoleptic Requirements – Boneless skinless thighs and thigh trim shall be examined on a continuous basis for organoleptic requirements shown in Table 1. Any product that does not comply with the organoleptic requirements shall be rejected for use under this FPPS.
- 552 Meat Defects – A sample of 30 pieces of boneless skinless thighs and 2 pounds of thigh trim (as applicable) shall be drawn and examined for the defects, shown in Table 1, before it is used in the formula. The frequency of sampling and the number of defects allowed shall be those outlined in QAD's Sample Plan Level 1 (SPL-1) for boneless thighs; and Sample Plan Level 2 (SPL-2) for thigh trim. If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents shall be rejected.
- 553 Unacceptable Meat – Mechanically separated turkey (comminuted), finely ground, flaked, or finely chopped turkey meat.
- 554 Processing and Size Reduction – Thigh meat shall be reduced in size through a plate with openings that are not less than 0.50 inch and not greater than 1.00 inch.
- 554.1 Thigh trimmings shall be ground through a plate with holes no less than 0.125 inch (1/8 inch) in diameter; or reduced through a desinewer plate or screen with holes 0.0591 inch to 0.0787 inch in diameter. For trim meat reduced through a desinewer plate or screen, the patella (kneecap) and portions of the condyle of the femur may be present when attached to the thigh trim.
- 554.1.1 Additionally, the plate, screen, or equipment shall be designed to extract and discharge bone, bone-like material, cartilage, etc., simultaneously with size-reduction. The system shall provide a continuous flow of discharge material during size-reduction. The discharge material shall not be used in the commodity produced under this FPPS.
- 555 Defects – Thigh trim that is size-reduced using equipment designed to extract and discharge the material listed above shall be examined for bone, bone-like material, cartilage (gristle), cartilage-like material, or hard tendons or tendinous material after size reduction only. Regardless of the size-reduction system used, thigh trim shall

be examined for skin, blood clots, and discolorations prior to size reduction.

556 Organoleptic Requirements and Defects for Size-Reduced Meat

- 556.1 Organoleptic Requirements – The size-reduced meat and size-reduced trim meat shall be examined in the fresh state on a continuous basis for the organoleptic requirements listed in Table 2 prior to formulation. If the product does not comply with the organoleptic requirements, it shall be rejected for use under this FPPS.
- 556.2 A 5-pound sample of size-reduced meat and a 2-pound sample of size-reduced trim meat shall be drawn and examined in the fresh state for the defects listed in Table 2 prior to formulation.
- 556.3 If the sample of size-reduced meat or trim meat contains bone or bone-like material, or has more meat defects (listed in Table 2) than the maximum tolerance for SPL-2, the product the sample represents shall be rejected for use under this FPPS.
- 556.4 Temperature Requirements – Size-reduced meat or trim which is not used in the turkey ham on a continuous basis, shall be cooled by using cooling methods or media (e.g., use of liquid CO₂, dry ice or liquid N₂) that ensure the internal product temperature is between 26 °F (-3.3 °C) and 40 °F (4.4 °C).
- 556.4.1 Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat or trim shall not be incorporated into the size-reduced product. Liquid associated with normal product purge is acceptable. No frozen or previously frozen size-reduced meat or trim may be used in the turkey hams.

560 Processing Sequence and Formulation

561 Unless otherwise specified, the size reduction; formulation; mixing; stuffing into casings, smoking/cooking, cooling; slicing, packing; and freezing of the commodity shall be a continuous process that complies with the time and temperature requirements of this FPPS.

561.1 Formulation – Proportions of ingredients in preparing the commodity are as follows:

561.1.1 Smoked Turkey Ham Products

	<u>Percent of Total by Weight</u>
Size-Reduced Meat Block (minimum)	80.0
Other Ingredients (total shall not exceed):	20.0
Water (up to)	14.4
Added Processing Aids including	
Curing Agents (up to)	7.6
Total	100.0

561.2 Sodium Requirement – The sodium content of the cooked commodity shall be no more than 600 mg per 100 grams basis as evidenced by the Nutrition Facts panel.

- 561.3 Crediting and Serving Size – Cooked product shall credit as a minimum (2) ounce equivalents meat/meat alternate per 2.90-ounce to 3.25-ounce serving.
- 561.4 Water and/or ice shall be added to assist in the processing of turkey hams. The amount of water/ice and other ingredients shall comply with the “12-percent water added” statement for the finished commodity. See EXHIBIT 1 for an example of this calculation.
- 561.5 Dry ingredients may be mixed with water to form a brine solution prior to the addition of the meat. As an option to forming a brine solution, dry ingredients may be added directly to the meat portion and thoroughly mixed.
- 561.5.1 Soy and gluten [containing ingredients](#) are not allowed.
- 561.6 If liquid smoke flavoring is added to the formulation, the percentages for salt, sugar, and phosphate may be adjusted (reduced) to include this ingredient.
- 561.7 Verification of compliance with actual percentages of sodium erythorbate or sodium ascorbate and sodium nitrite used shall be monitored by FSIS.
- 561.8 “Other ingredients” (salt, sodium phosphate, binder, cure, and cure accelerator) [outlined in the](#) formulation requirements [shall be verified or monitored by an AMS Grader or Auditor](#). FSIS shall monitor compliance with the labeled “12-percent added water” statement.
- 561.9 Batches of turkey thigh meat, trimmings, and other ingredients shall be formulated to comply with the required 95 percent fat free labeling. Verification shall be monitored by FSIS personnel.
- 562 Processing aids, [such as anti-caking agents, anti-dusting agents, or other manufacturing aids \(as present in salt, sugar, etc.\)](#), are allowed. If processing agents are used, the ingredients and amount of ingredients listed in the formulation shall remain the same.
- 563 Mixing – The brine solution shall be incorporated into the size-reduced thigh meat by mixing/blending, tumbling or massaging with or without vacuum. If the option of adding dry ingredients directly with the meat portion is used, batches of meat, dry ingredients, and water/ice shall be thoroughly mixed (by mixing/blending, tumbling or massaging with or without vacuum) to ensure even distribution of ingredients throughout the batch.
- 564 Stuffing into Casings
- 564.1 After blending, the formulated batches of ingredients shall be stuffed into a cook-in-film bag, pouch, plastic casing, moisture proof casing, standard fibrous casing, or smoke impregnated casing.
- 564.2 Formulated batches of ingredients shall be stuffed into casings (pre-smoked casing is allowed) that conform to the finished smoked ham commodity requirements of 4

to 5 inches in diameter, round, and approximately 10 pounds or 2 pounds net weight.

- 564.3 In no case shall the stuffing of the formulated batches of ingredients into casings be delayed longer than 48 hours or the formulated batches shall be held at an ambient temperature between 26 °F (-3.3 °C) and 40 °F (4.4 °C).
- 565 Smoking – Stuffed casings of formulated product shall be smoked. Liquid smoke flavoring and smoke impregnated fibrous casings may be used. The processor shall inform the AMS Grader of the smoking method being used, and appropriately label that method on each commodity label.
- 566 Product Color Characteristic – Product shall have a mahogany color that is commonly associated with smoked meats and not be lighter or darker than the color tolerance.
- 566.1 To obtain a copy of the Official USDA Color Control Standard on Turkey Ham, please contact SSD at (202) 309-3182.
- 567 Cooking – The turkey hams must be smoked/cooked to an internal product temperature of 155 °F (68.3 °C) or higher. All products shall be fully cooked in accordance with FSIS regulations.
- 567.1 All finished product shall meet the organoleptic requirements listed in Table 3.
- 568 Cooling – After cooking, the commodity shall be cooled to an internal product temperature of 40 °F (4.4 °C) or lower. Cooling methods and procedures shall be in compliance with FSIS directives and guidelines for cooked products.
- 569 Slicing – For sliced commodity, the commodity shall be removed from casing, and thinly sliced (not shaved), have no spongy (porous texture) appearance, after cooling and prior to repackaging and freezing.
- 570 Reworked Commodity – Smoked turkey hams which are fractured (separated into two or more pieces); are misshaped; have cuts; have more internal or external defects than the maximum tolerances allowed; or do not meet the size and weight requirements may be reworked (defects removed) and incorporated into formulated batches of turkey ham provided:
- 570.1 Temperature of the hams has not exceeded an internal product temperature of 40° F (4.4° C) and they have been maintained at that temperature or lower;
- 570.2 Hams are reworked within 72 hours from the end of the shift it was packaged;
- 570.3 Hams are ground through a plate with holes 0.125 inch (1/8 inch) in diameter;
- 570.4 Hams are incorporated at a maximum of 2 percent of the formulated batch (2 percent of the total 15 percent trimmings allowed); and

- 570.5 Hams are added to formulated product that shall undergo the same smoking method(s).
- 580 Freezing – Packaged commodity shall be placed in a freezer within 48 hours of packing. The commodity shall be frozen by lowering the internal product temperature to 10 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If the commodity is not placed in a freezer immediately after packing, the product shall be held at a temperature between 26 °F (-3.3 °C) and 36 °F (2.2 °C). When packaged product is held at a temperature below 26° F (-3.3 °C), the commodity shall be considered to be in a freezer and subject to the 72-hour freezing requirement which begins at the end of the shift the commodity enters the 26 °F (-3.3 °C) or lower facility.
- 590 Metal Detection – The commodity shall be examined by a metal detection device capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips, metal fragments from cutting equipment, and pieces of metal according to QAD policies and procedures.
- 591 As an alternate method, the formulated product may be examined by an in-line metal detection device installed in the mechanical stuffing or forming system before cooking and/or smoking. If the alternate metal detection method (in-line) is used and casings are later cut to meet the physical requirements, the product shall also be examined by a metal detection device after it is placed in the bag or casing.
- 592 Commodity found to be contaminated with metal shall be handled in accordance with FSIS procedures. Other procedures for examination of the commodity shall be approved by the Director of SSD in writing.
- 600 PACKAGING AND PACKING**
- 610 The Contractor shall ensure that all packaging, packing, labeling, closure, marking, and palletization comply with the National Motor Freight Regulations and FSIS regulations and the requirements listed below.
- 620 Packing – Product shall be packed in four (4) 10-pound, twenty (20) 2-pound, twenty (20) 2-pound sliced or eight (8) 5-pound sliced packages.
- 630 Packaging – All packaging and packing materials shall be clean and in new condition, shall not impart objectionable odors or flavors to the commodity, shall be safe for use in contact with food products (cannot adulterate product or be injurious to health), and shall be tamper-evident. Tamper-evident is defined as packaging and packing materials with one or more indicators of barriers to entry, which, if breached or missing, can reasonably be expected to provide visible evidence that tampering has occurred. All packaging material shall comply with FSIS regulations (9 CFR § 381.144(c)).
- 631 Films, Bags, and Casings – Shall be made of water-proof film with oxygen barrier properties; be heat-shrinkable; and shall protect the product from dehydration, freezer burn, quality deterioration or contamination during the conditions of use.

- 631.1 When fibrous casings are used, the casing shall be removed from the commodity after the smoking, cooking, and cooling processes just prior to packaging.
- 631.2 The commodity shall be packaged in a heat shrinkable oxygen- and water-proof film, bag, or casing, as appropriate. The excess air shall be removed (by vacuum) from each film, bag, or casing. The bag or casing shall be shrunk to fit tightly against the surface of the commodity.
- 631.3 After the air is removed, the film, bags or casings shall be hermetically heat sealed to ensure a vacuum closure and to prevent product dehydration and quality deterioration. Metal wire ties, paper-coated wire ties, or staples shall not be used for sealing bags or casings.
- 640 **Shipping Containers** – Shipping Containers shall:
- 640.1 Be good commercial fiberboard containers that are acceptable by common or other carrier for safe transport to point of destination,
- 640.2 Be of such size to pack the commodity without slack filling or bulging,
- 640.3 Withstand the stresses of handling, shipping, stacking, and storage, and
- 640.4 Be closed by commercially accepted methods and materials. Steel or wire straps shall not be used for final closure.
- 641 Staples shall 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.
- 700 LABELING**
- 710 **Child Nutrition** (CN) Labeling information or a Product Formulation Statement demonstrating product contribution to the National School Lunch Program meal pattern requirements is required. For more information on the CN Labeling Program, see the section for Food Manufacturers/Industry on the FNS website:

<http://www.fns.usda.gov/cnlabeling/child-nutrition-cn-labeling-program> .
- 720 **Water Added Statement** – The commodity shall be formulated with water and other ingredients in a manner that complies with the required labeling of “12-percent water added.”
- 721 **Percent Fat Free Statement** – The commodity shall be formulated to comply with the requirements of this FPPS and comply with the “95 Percent Fat Free” statement to be placed on each shipping container. The Contractor/Processor is responsible

for providing any analysis data required by FSIS to label this commodity.

- 730 Commercial labeling or USDA labeling shall be used. When commercial or USDA labeling is selected, both the individual packages and shipping containers within a purchase unit shall be labeled in that format. The Contractor shall use the same label format (either commercial or USDA) within a purchase unit.
- 740 Commercial Labeling Requirements
- 741 Each individual package (100886 and 111223; 110911 when destined for households in the Solicitation) and shipping container shall be commercially labeled in accordance with FSIS requirements. Labeling shall be approved by FSIS prior to acceptance for use under this FPPS. Individual packages shall comply with retail consumer labeling requirements and shall meet the [Commodity/Packaging Labeling Requirements Section of the current MSCP-D](#).
- 741.1 For 2-pound sliced commodity (100886 and 111223), labels shall be adhered directly on individual package or printed label.
- 741.2 For 5-pound sliced commodity (110911), when destined for households in the Solicitation, labels shall be adhered directly on the individual package or printed label.
- 742 Commercial Labels shall be the processor's own commercial label.
- 743 Traceable Product – The processor shall establish a product identification and record system that clearly links product by place and time of manufacture to specific USDA contracts and destinations. When the company uses the same commercial label for the product certified as complying with this FPPS and commercial product, the identification system shall differentiate between USDA and non-USDA products. An alpha numeric code may be used for information that is in addition to FSIS labeling requirements. The required product identification and record system, including codes, shall be reviewed by USDA/AMS before production begins for the contract(s).
- 744 Nutrition Facts, Ingredients, and Allergen Statements on individual packages (110886 and 111223) or shipping containers (100126 and 110911) – Nutrition Facts shall be provided. The ingredient statement, even for single ingredient foods, shall be included as a statement separate from the name of the product, e.g., Ingredients: _____. The allergen statement shall be provided in the format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) and [the Food Allergy Safety, Treatment, Education, and Research \(FASTER\) Act](#), for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soybeans, wheat, and sesame; e.g., Allergen: This product contains _____. For additional guidance refer to the Compliance Guidance at: <https://www.fsis.usda.gov/sites/default/files/import/Allergens-Ingredients.pdf>
- 750 USDA Labeling Requirements

- 751 When USDA labeling is used, any deviations from the USDA labeling requirements in this FPPS shall be approved by the Contracting Officer, in writing, prior to start of production. Labeling and marking of the commodity shall be in accordance with this FPPS.
- 752 Labeling and marking information shall be water-fast, non-smearing, of a contrasting color, clear, and readable.
- 753 USDA-Labeled Shipping Container Requirements
- 753.1 Labeling and marking information shall be preprinted, stamped, or stenciled on each shipping containers, or printed on a self-adhesive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 2 - 4.
- 753.2 Nutrition Facts, Ingredients and Allergen statements on individual packages (100886 and 111223; [110911 when destined for households in the Solicitation](#)) or shipping containers (100126 and 110911) – Nutrition Facts shall be provided. The ingredient statement, even for single ingredient foods, shall be included as a statement separate from the name of the product, e.g., Ingredients: _____. The allergen statement shall be provided in the format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) [and the Food Allergy Safety, Treatment, Education, and Research \(FASTER\) Act](#), for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soybeans, wheat, [and sesame](#); e.g., Allergen: This product contains _____. For additional guidance refer to the Compliance Guidance at:
- <https://www.fsis.usda.gov/sites/default/files/import/Allergens-Ingredients.pdf>
- 753.3 Universal Product Code (UPC) Bar
- 753.3.1 A 14-digit UPC code for smoked turkey ham products shall be as follows:
- 753.3.2 Material Code 100126 – 1 07 15001 00126 6.
- 753.3.3 Material Code 100886 – 1 07 15001 00886 9.
- 753.3.4 Material Code 110911 – 1 07 15001 10911 5.
- 753.3.5 Material Code 111223 – 1 07 15001 11223 8.
- 753.4 The UPC code shall be placed in the lower right-hand corner of the principal display panel of each shipping container.
- 754 Inventory Control Information – The processor may include any additional information (including bar codes) for processor inventory control purposes. This information may be applied somewhere on the surface of the shipping container but shall not cover or conflict with the labeling requirements of this FPPS.
- 760 Unacceptable Labeling:

- 761 Commercial labels that do not have a processor traceability system and code;
- 762 Commercial labeling traceability coding and systems that have not been reviewed by a representative of USDA/AMS/LP/QAD;
- 763 Distributor Commercial Labels;
- 764 Two or more different commercial labels in the same purchase unit.
- 770 Free Along Side (FAS) Vessel Deliveries
- 771 FAS vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Sales Order/Item Number. The address shall be clearly printed on at least two sides of each pallet.
- 800 FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY**
- 810 Packaging Defects – Contractor shall ensure that packages in a delivery unit shall be examined for defects that affect protection, expose product, or permit dehydration or freezer burn, or quality deterioration during storage, such as tears, holes, or improperly sealed packages.
- 820 Packing Defects – Shipping containers in a delivery unit shall be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers (7 CFR § 42).
- 830 Tolerance for Defects – If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable QAD sample plan, the delivery unit shall be rejected.
- 840 Net Weight – A purchase or delivery unit shall consist of four (4) 10-pound, twenty (20) 2-pound, twenty (20) 2-pound sliced and eight (8) 5-pound sliced packages and shall total 40,000 pounds net, or multiples thereof.
- 841 Test Weighing Procedures
- 841.1 The tare weight of all packing materials shall be determined by weighing a representative sample of all packaging components such as plastic-film bags, clips, and fiberboard containers.
- 841.2 Weight Variation – A weight variation of minus 1 percent (39,600 pounds) is permitted on each delivery unit. USDA shall pay the Contractor only for the amount of commodity delivered within the required weight range. Any delivery unit not within the required weight range shall be rejected.
- 842 The net weight shall be shown on the Contractor's Certificate of Conformance or LP 210-S Grading Certificate (scale receipt or Bill of Lading (BOL) may accompany load).

- 850 Loading and Shipping Frozen Commodity
- 851 Visual Inspection – Frozen commodity showing any evidence of thawing, refreezing, or freezer deterioration shall be rejected for use under this FPPS.
- 852 Internal Product Temperature
- 852.1 Frozen – Commodity shall be 2 °F (-16.7 °C) or lower at time of loading. Delivery units with internal product temperatures exceeding 2 °F (-16.7 °C) and up to 5 °F (-15 °C) shall be tentatively rejected. Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2 °F (-16.7 °C) or lower and reoffered one time only. Delivery units exceeding 5 °F (-15 °C) or delivery units that have been tentatively rejected and exceed 2° F (-16.7° C) when reoffered shall be rejected for use under this FPPS.
- 852.2 Optional Temperature Verification – The Contractor may request an alternate method utilizing product temperature-sensing devices. If this option is selected, a Federal-State supervisor shall determine that the facilities, equipment, procedures, and the Contractors' current level of freezing compliance are in accordance with the established guidelines outlined in the applicable LP Program's instructions for this FPPS.
- 852.3 Compliance with the internal product temperature requirement shall be documented and records maintained for AMS review.
- 860 Inspection and Checkloading
- 861 For inspection and checkloading at time of shipping, the Contractor shall utilize either USDA Grader or Contractor Checkloading to certify. The Contractor shall notify USDA AMS QAD Supervisor prior to production. The requirements for selection are as follows:
- 862 USDA Grader Checkloading Requirements – Inspection for contract compliance shall be made by a USDA representative, in accordance with 7 CFR § 70, FSIS regulations, and this FPPS, at site of processing, both during and after processing and packaging. Inspection records shall be complete and made available to USDA, as requested, to ensure contract compliance.
- 862.1 Procedures – The inspection and checkloading shall be performed by the AMS Grader. Procedures and a schedule of fees for these services may be obtained by contacting the nearest QAD field office. This information can be found on the [QAD Procedures webpage](https://www.ams.usda.gov/resources/qad-procedures) (<https://www.ams.usda.gov/resources/qad-procedures>), or by contacting:
- USDA/AMS, Livestock and Poultry Program, Office of the Deputy Administrator,
1400 Independence Avenue, SW, Washington, DC 20250-0258, Room 2092-S,
STOP 0249, Office Phone Number (202) 720-5705.
- 862.2 The quality, quantity, weight, packaging, packing, and checkloading of the

commodity shall be evidenced by certificates issued by the AMS Grader. Contractor shall not ship the commodity unless informed by the AMS Grader that the designated commodity to be shipped meets the requirements of the AMS MSCP-D, Solicitation, and this FPPS.

- 863 Contractor Checkloading Requirements – Inspection for final contract compliance shall be made by the Contractor, in accordance with 7 CFR § 70, FSIS regulations, and this FPPS. The quality, quantity, weight, packaging and packing of the commodity shall be evidenced by a Certificate of Conformance that verifies the designated commodity to be shipped meets all the requirements as stated in this FPPS, MSCP-D and Solicitation.
- 863.1 Procedures – The Contractor shall perform checkloading examinations at the time of shipment – as described in this FPPS starting at the section labeled Loading and Shipping Frozen Commodity and sections thereafter – and shall issue a corresponding Certificate of Conformance (Exhibit 6). The Contractor is required to provide an acceptance document to accompany each shipment. Additional details are found in the current AMS MSCP-D Section for Bill of Lading Notations.
- 863.2 Contractor's inspection records and checkloading documentation shall be complete and maintained, including the Certificate of Conformance, and made available to USDA, as requested, to assure Contractor Checkloading compliance. Contractor Checkloading activity shall be reviewed by USDA under AMS at the cost of the Contractor.

900 PALLETIZED UNIT LOADS

- 910 All products shall be stacked on new or well-maintained pallets and palletized with shrink wrap plastic, unless otherwise specified in the Solicitation. Pallet loads shall be stacked in a manner that minimizes the overhang of the shipping containers over the edges of the pallets and exposes each shipping container's principal display panel to facilitate certification examinations.
- 920 Size and Style of Container – Only one size and style of shipping container shall be used in any one delivery unit.

1000 SHIPMENT AND DELIVERY

- 1010 Shipment and Delivery, including Loading and Sealing, Delivery Notification and Split Deliveries – Refer to the current AMS MSCP-D.
- 1011 In addition, the Contractor shall adhere to the following provisions:
- 1011.1 Under Grading Certification, each shipping container shall be identified with a USDA Contract Compliance stamp with the applicable production date. An AMS Grader, or other authorized personnel under the supervision of the AMS Grader, shall stamp one end of each shipping container online. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

1011.2 As an alternative to stamping, the Contractor may preprint the stamp on the shipping container or label. Prior approval by QAD is required before using this alternative method.

1011.2.1 Under Audit-Based Verification service, each shipping container shall be identified with the USDA Food shield (Exhibit 5) at least 2 inches high on the principal display panel. The Contractor may preprint the USDA shield on the shipping container or label.



1012 Documentation and Grading Certificate

1012.1 A copy of the Contractor's Certificate of Conformance and Bill of Lading or the original USDA LP 210-S Poultry Products Grading Certificate issued at time of checkloading shall accompany each shipment.

1100 DESTINATION EXAMINATION

1110 **Costs for Destination Examination** – The cost of a destination examination, before or after delivery, by an USDA representative on accepted product shall be for the account of USDA. Costs for destination examinations of rejected purchase units shall be for the account of the Contractor. The USDA representative shall make arrangements for destination examination prior to delivery.

1120 **Commodity Requirements** – Before acceptance by recipient, the commodity may be examined on a spot-check basis for temperature, condition, identity, count, when applicable, or any other contract provision. If a recipient complaint is received, re-inspection may be performed by USDA AMS at the expense of Contractor.

1130 **Temperature** – The commodity shall arrive at destination at an average internal product temperature not to exceed 10 °F (-12.2 °C) with no individual temperature exceeding 15 °F (-9.4 °C) when shipped, during transit, and when received at the destination plant. When any sample exceeds 15°F (-9.4°C) the purchase unit shall be rejected for use under this FPPS.

1200 PRODUCT ASSURANCE AND COMPLAINT RESOLUTION

1210 **Product Assurance** – The Contractor shall guarantee that the product complies with all FPPS requirements and provisions set forth in the AMS MSCP-D and Solicitation.

1220 **Waiver Requests** – Contractor shall submit all waiver requests directly to the Commodity Procurement Program (CPP) Contracting Officer for review and

determination. A full list of CPP contacts can be found at:

<https://www.ams.usda.gov/sites/default/files/media/AMSCommodityProcurementStaffContactList.pdf>

- 1230 Complaint Resolution – Customer complaint resolution procedures shall be the responsibility of the Contractor. These procedures shall include: a point of contact, investigation steps, and intent to cooperate with AMS, and product replacement or monetary compensation. The procedures shall be used to resolve product complaints from recipient agencies or AMS.

Table 1. Organoleptic Requirements and Defects for Meat

	Criteria
Organoleptic Requirements:	Meat shall: (a) not be rancid; have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign or off-odors; contain foreign materials (e.g., glass, paper, rubber, metal, plastic, wood); or show no evidence of mishandling or deterioration; or dehydration or freezer burn or thawing and refreezing and (b) have a bright color.
	Defects
Boneless, Skinless Meat and Trim: Bone:	Bone or bone-like material greater than 0.40 inch (1.02 cm). Bone or Bone-like material less than or equal to 0.40 inch (1.02 cm)
Discoloration:	Any moderate discolorations. Lightly shaded discolorations exceeding an area equivalent to the area of a circle with a diameter of 0.50 inch (1.27 cm). Slight discolorations are permitted, provided the discoloration does not detract from the overall appearance of the meat.
Other:	Cartilage (gristle), hard tendons or tendinous material, or blood clots.
Boneless Thighs:	Thigh with more than one-half of the meat missing.

Table 2. Organoleptic Requirements and Defects for Size-Reduced Meat and Trim Meat

Organoleptic Requirements:	Meat shall: (a) not be rancid; not have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign and off-odors; not contain foreign materials (e.g., glass, paper, rubber, metal, plastic, wood); or show evidence of mishandling or deterioration; and (b) have a bright color.
Defects – Meat and Trim	Bone or bone-like material.
	Cartilage (gristle) or cartilage-like material, or hard tendons or tendinous material.

Table 3. Organoleptic Requirements and Defects for Finished Turkey Hams

Organoleptic Requirements:	Finished product shall: (a) not be rancid; not have a metallic, overcooked, burnt, scorched, bitter, oxidized, stale, fruity, beany, oily, soapy, or other foreign or off-odors; not contain foreign materials (e.g., glass, paper, rubber, metal, plastic, wood); or (b) not show evidence of mishandling or deterioration; or dehydration or freezer burn or thawing and refreezing.
Exterior: (10 products examined)	Defects
	<p>Individual major surface voids (including air voids, fat pockets, and purge pockets) exceeding an aggregate area equivalent to the area of a circle with the diameter of 0.75 inch (1.91 cm). The depth of a void or pocket shall be no greater than 0.50 inch (1.27 cm).</p> <p>Unobtrusive purge is allowed; however, pockets and voids holding purge, fat, or air shall not exceed the aggregate diameter of 0.75 inch (1.91 cm).</p> <p>Product shows evidence of excessive heating (burnt or scorched).</p> <p>Individual hams that are not 4 to 5 inches (10.16 to 12.70 cm) and round in diameter.</p> <p>Product that does not have a mahogany color associated with smoked meats, or one with a mahogany color lighter than or darker than the tolerance.</p>
Interior: (2 products examined) Product shall be cut (widthwise) in three approximately equal pieces.	Voids, gelatin, or fat pockets on the sliced surfaces that exceed an aggregate area per surface equivalent to the area of a circle with the diameter 0.75 inch (1.91 cm).

EXHIBIT 1

Example Formulation for Smoked Turkey Ham Products

In the formulation of turkey ham products, the meat portion and the added water (all other non-meat ingredient) portion are considered two separate components. Water/ice and other ingredients shall be added to the meat portion to assist in the processing of turkey hams products. Water/ice* may be added in an amount to be determined by the contractor/processor taking into consideration the smoking/cooking method and yield**. The end product shall comply with the 12 percent water added requirement (percentage includes water and all other non-meat ingredients) and this FPPS. The added water statement shall be calculated on the formulation using the raw meat (green) weight and the finished cooked weight of the product as shown below.

$$\frac{\text{Finished weight} - \text{Green weight}}{\text{Finished weight}} \times 100 = \% \text{ Added Water/Ingredients Declaration}$$

The following formulation is only an example and should not be mistaken for actual poundage to be used:

	<u>Number of Pounds</u>
Meat Portion (Green Weight)	
Size-Reduced Turkey Thigh Meat	<u>100.00</u>
(may contain up to 15% thigh trimmings)	
Raw Meat Weight w/o Water/Ingredients	100.00 lbs.
<u>Water / Other Ingredient Portion</u>	
*Water/Ice	18.15
Salt	1.50
Lite Salt	0.50
Brown Sugar	2.00
Sodium Phosphate	0.50
Approved Binder(s) (maximum)	0.50
Sodium Erythorbate	0.61
Sodium Nitrite	0.02
Sodium or Potassium Lactate/Diacetate (maximum)	<u>2.50</u>
Raw Batch Weight	126.28 lbs.
 **Yield (%) after cooking/smoking	 <u>x 0.90</u>
Finished Cooked/Smoked Weight	113.65 lbs.

Percent added water calculation:

$$\frac{113.65 \text{ lbs} - 100 \text{ lbs}}{113.65 \text{ lbs}} \times 100 = 12\% \text{ Added Water}$$

EXHIBIT 2 USDA Labeled Shipping Containers

Marking Information: Shipping containers may be marked substantially as shown below. Detailed USDA labeling information is provided in Exhibit 3 and Exhibit 4. Markings shall be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. The USDA symbol, **Exhibit 5**, is to be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the top panel or the principal display panel. The processor's name, address, and phone number shall be printed on the "TOP PANEL" or principal display panel. The processor's name and address shall indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints. ***The Handling Information and Nutrition Facts Label (on the principal display panel) is required on shipping containers of commodity weighing 10 and 5 pounds.***

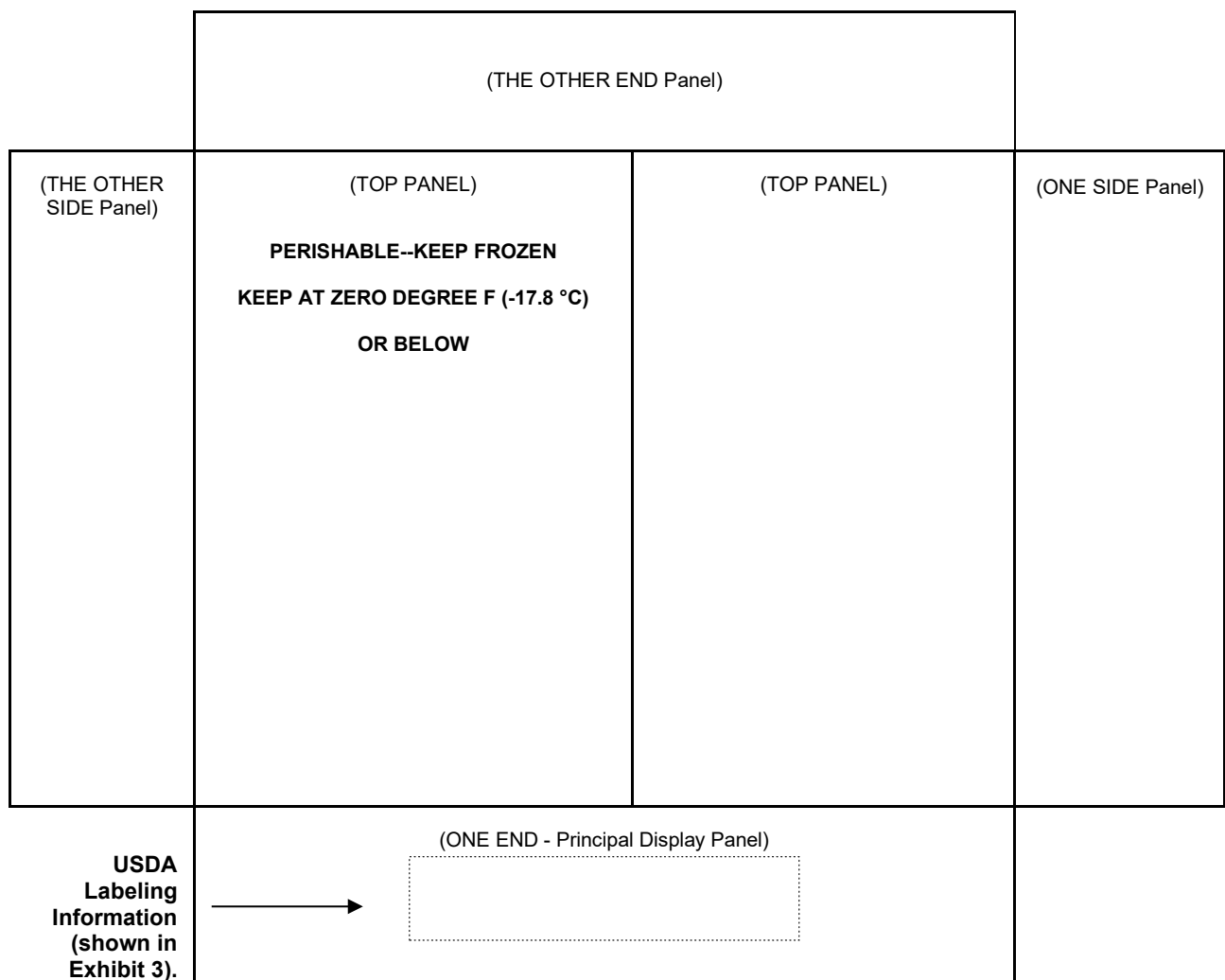


EXHIBIT 3
USDA Label Information for Smoked Turkey Hams

Marking Information: USDA labeling information shall be printed on the principal display panel of each shipping container as provided in Exhibit 2. Markings shall be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. ¹**The identification of *smoking method(s)* used below is provided only as an example. The processor shall designate the applicable smoking method used on each label and the labeling shall be approved by FSIS.** The UPC 14-digit I 2/5 bar and code, shall be shown in the lower right-hand corner of the principal display panel. The USDA symbol, **EXHIBIT 5**, shall be a minimum of 2.25 inches (5.72 cm) in height and shall be printed on the "TOP PANEL" or principal display panel. The processor's name, address, and phone number shall be printed on the top panel or the principal display panel. The processor's name and address shall indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.





	<div style="text-align: right;"></div> <p>FROZEN FULLY COOKED SMOKED TURKEY HAM* with 12% Water *Cured Turkey Thigh Meat, Chunked and Formed, Smoke Flavor Added (as applicable)¹ 95% FAT FREE Ingredients: (Food Allergen Statement, Shall be Placed Here)</p> <table style="width: 100%;"><tr><td style="width: 50%; text-align: center;">Processor's Name, Address, and Phone</td><td style="width: 50%; text-align: center;">Required Nutrition Facts Label Shall Be Placed Here</td></tr></table> <p>KEEP FROZEN</p> <p>__ Bags Net Weight __ LBS. (__ KG)</p> <p style="text-align: right;">DATE PACKED <u>Month, Day, and Year</u></p> <p style="text-align: right;">UPC Bar and Code</p>	Processor's Name, Address, and Phone	Required Nutrition Facts Label Shall Be Placed Here
Processor's Name, Address, and Phone	Required Nutrition Facts Label Shall Be Placed Here		

EXHIBIT 4
USDA Label Information for Smoked Sliced Turkey Hams

Marking Information: USDA labeling information shall be printed on the principal display panel of each shipping container as provided in Exhibit 2. Markings shall be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. ¹**The identification of *smoking method(s)* used below is provided only as an example. The processor shall designate the applicable smoking method used on each label and the labeling shall be approved by FSIS.** The UPC 14-digit I 2/5 bar and code, shall be shown in the lower right-hand corner of the principal display panel. The USDA symbol, **EXHIBIT 5**, shall be a minimum of 2.25 inches (5.72 cm) in height and shall be printed on the "TOP PANEL" or principal display panel. The processor's name, address, and phone number shall be printed on the top panel or the principal display panel. The processor's name and address shall indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.

	
<p>FROZEN FULLY COOKED SMOKED SLICED TURKEY HAM* with 12% Water</p> <p>*Cured Turkey Thigh Meat, Chunked and Formed, Smoke Flavor Added (as applicable)¹ 95% FAT FREE</p> <p>Ingredients:</p> <p>(Food Allergen Statement, Shall be Placed Here)</p>	
<p>Processor's Name, Address, and Phone</p> <p>KEEP FROZEN</p> <p>__ Bags Net Weight __ LBS. (__ KG)</p>	<p>Required Nutrition Facts Label Shall Be Placed Here</p> <p>DATE PACKED <u>Month, Day, and Year</u></p> <p>UPC Bar and Code</p>

USDA SYMBOL



Exhibit 6. Contractor Checkloading and Certificate of Conformance Requirement

**UNITED STATES DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE LIVESTOCK AND
POULTRY PROGRAM**

**CERTIFICATE OF CONFORMANCE
FOR THE PROCUREMENT OF
SMOKED TURKEY HAM PRODUCTS**

CERTIFICATE OF CONFORMANCE

I certify the following:

- (1) On [delivery date(s)], [Contractor's name] furnished the (insert the appropriate commodity description) called for by Purchase Order Number Number/Item number(s) _____ via [Carrier] under Sales Order
- (2) The (insert the appropriate material name) is of the quality specified and conforms in all respects with the purchase order requirements, including the FPPS, Master solicitation for Commodity Procurement – Domestic Programs (MSCP-D), and Solicitation.
- (3) Product identification, (i.e., production lot number(s)) is in the quantity shown on the attached acceptance document.
- (4) Contractor assures all turkey products used in fulfilling this contract was produced in the United States as defined in the AMS MSCP-D.

Date: _____

Signature: _____

(Signed by an officer or representative authorized to sign offers)

Title: _____