

**September 2012****AMENDMENT NO. 1****SUPPLEMENT 303 TO AMS MASTER SOLICITATION****PURCHASE OF HAM, BONELESS, FULLY-COOKED, WATER-ADDED  
FOR DISTRIBUTION TO  
FEDERAL FOOD AND NUTRITION PROGRAMS**

This document amends Supplement 303, dated June 2011, in order to 1) update various sections (as detailed below); 2) replace Exhibit A; 3) replace Attachment I, Item Description and Checklist of Requirements for Fully Cooked Boneless, Cured Ham Products; and 4) include Attachment III, Experimental Item Description and Checklist of Requirements for Ham Products, Reduced Sodium, Cured, Boneless, Fully Cooked, Frozen.

Details are as follows:

1) Amend sections of Supplement 303, as follows:

- a. Throughout Supplement 303, replace all references to “Contracting Officer” with “Contracting Officer’s Technical Representative (COTR).”
- b. Throughout Supplement 303, replace all references to “LS-303” with “303.”
- c. Page 1: Section I.B. is amended to read, in part:

To become an eligible supplier, the following must be submitted **electronically** to the **Food Safety and Commodity Specification Division, Livestock, Poultry, and Seed Program, Agricultural Marketing Service, U.S. Department of Agriculture**, for evaluation and approval prior to bidding...

d. Page 2: Section I.B.b is amended to read:

- 1) A sample ham (whole, sliced, or diced) with the ingredient statement, package (if applicable), and Nutrition Facts panel that conforms to the **applicable IDCR** (Attachment I **and Attachment II**).

e. Page 5: Section III.A. is amended to read:

The Government has provided a technical proposal format which is to be used in preparing the technical proposal (see Exhibit B). The offeror shall submit the technical proposal in an electronic format through the company’s external portal site maintained by the AMS Commodity Procurement Staff (see Exhibit C for instructions to obtain an external portal site). When submitting the technical proposal through the company’s external portal site, e-mail notification to the COTR must be provided to [Darin.Doerscher@ams.usda.gov](mailto:Darin.Doerscher@ams.usda.gov) or [Steve.Whisenant@ams.usda.gov](mailto:Steve.Whisenant@ams.usda.gov). The technical

proposal must be submitted in its entirety. The collection of attachments and appendices may be submitted as a separate document. This format and electronic form provided will aid in the evaluation of the technical proposal.

f. Page 5: Section III.B. is amended to read:

The technical proposal must be submitted by an authorized agent of the company.

g. Page 5: Remove Section III.C.

h. Page 6: Section III.D is amended to remove the "Note".

i. Page 6: Section III.E is amended to revise the "Note":

Note: When revisions to the approved technical proposal are submitted in their external portal site, the contractor must provide an e-mail notification to the COTR.

- 2) Replace Exhibit A, Checklist and References to Applicable Bid and Contract Provisions, dated June 2011, with the updated version, dated September 2012.
- 3) Remove the Errata Page dated April 2011, and replace Attachment I, Item Description and Checklist of Requirements for Fully Cooked Boneless, Cured Ham Products, dated April 2011, with the updated version, renamed Item Description and Checklist of Requirements (IDCR) for Ham Products, Cured, Boneless, Fully Cooked, and dated September 2012.
- 4) Include Attachment III, Experimental Item Description and Checklist of Requirements for Ham Products, Reduced Sodium, Cured, Boneless, Fully Cooked, Frozen, dated September 2012.



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Director

Attachments

SUPPLEMENT 303 TO AMS MASTER SOLICITATION

EXHIBIT A  
DATED SEPTEMBER 2012  
PAGE 1 OF 2

**CHECKLIST AND REFERENCES TO APPLICABLE BID AND CONTRACT PROVISIONS  
SUPPLEMENT 303 TO AMS MASTER SOLICITATION, FOR FROZEN HAM PRODUCTS**

| PRODUCT DESCRIPTION                      |  |                     |   | OFFER/CONTRACT PROVISIONS              |  |   |                       |                                |
|--|--|---------------------|---|--|--|---|-----------------------|--------------------------------|
| WBSCM Material Description               | Specifications   | WBSCM Material Code | Packaging and Packing   | Minimum Offer Unit Size/ Shipping Unit | Tolerance  | Delivery Period                             | Federal/ State Plants | Competition (See Solicitation) |
| PORK HAM WATERAD FRZ PKG 4/10 LB         | Item Description and Checklist of Requirements (IDCR) for Ham Products, Cured, Boneless, Fully Cooked, dated September 2012. | 100184              | Individual hams must be produced "cook-n-ship" casings with a diameter of 4.0 to 4.5 inches. Four 10-lb. hams are packed 40 lbs. net weight per shipping container and shipped frozen.                        | 40,000 lbs.<br>1,000 cases             | NONE   | 1st half/last half of month delivery period | Federal & State       | Full & Open                    |
| PORK HAM WATERAD CHILLED PKG-4/10 LB     |  | 100186              | Individual hams must be produced "cook-n-ship" casings with a diameter of 4.0 to 4.5 inches. Four 10-lb. hams are packed 40 lbs. net weight per shipping container and shipped chilled (not less than 28° F). | 40,000 lbs.<br>1,000 cases             | NONE   | 1st half/last half of month delivery period | Federal & State       | Full & Open                    |
| PORK HAM WATERAD FRZ CTN-12/3 LB         |  | 100182              | Individual hams must be produced "cook-n-ship" casings with a diameter of 4.0 to 4.5 inches. Twelve 3-lb. hams are packed 36 lbs. net weight per shipping container and shipped frozen.                       | 36,000 lbs.<br>1,000 cases             | Minus 60 lbs. – delivery unit must be between 35,940 and 36,000 lbs. | 1st half/last half of month delivery period | Federal & State       | Full & Open                    |
| PORK HAM WATERAD SLC FRZ PKG-8/5 LB      |  | 100187              | Eight 5-lb. packages of thinly sliced shingle layered packages are packed 40 lbs. net weight per shipping container and shipped frozen.   | 40,000 lbs.<br>1,000 cases             | NONE   | 1st half/last half of month delivery period | Federal & State       | Full & Open                    |
| PORK HAM WTRADCBEDFRZ PKG-4/10 OR 8/5 LB |  | 100188              | Eight 5-lb. or four 10-lb. packages of diced ham of approximately ¼ inch diced pieces are packed 40 lbs. net weight per shipping container and shipped frozen.  | 40,000 lbs.<br>1,000 cases             | NONE   | 1st half/last half of month delivery period | Federal & State       | Full & Open                    |
| PORK HAM WATERAD SLC FRZ PKG-20/2 LB     |  | 100891              | Twenty 2-lb. packages of thinly sliced shingle layered packages are packed 40 lbs. net weight per shipping container and shipped frozen.  | 40,000 lbs.<br>1,000 cases             | NONE   | 1st half/last half of month delivery period | Federal & State       | Full & Open                    |



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**SUPPLEMENT 303 TO AMS MASTER SOLICITATION**

**EXHIBIT A  
DATED SEPTEMBER 2012  
PAGE 2 OF 2**

**CHECKLIST AND REFERENCES TO APPLICABLE BID AND CONTRACT PROVISIONS  
SUPPLEMENT 303 TO AMS MASTER SOLICITATION, FOR FROZEN HAM PRODUCTS**

| PRODUCT DESCRIPTION                      |  |                     |   | OFFER/CONTRACT PROVISIONS              |  |   |                       |                                |
|--|--|---------------------|---|--|--|---|-----------------------|--------------------------------|
| WBSCM Material Description               | Specifications   | WBSCM Material Code | Packaging and Packing   | Minimum Offer Unit Size/ Shipping Unit | Tolerance  | Delivery Period                             | Federal/ State Plants | Competition (See Solicitation) |
| PORK HAM WATERAD RDU SOD FRZ PKG-12/3 LB | Experimental Item Description and Checklist of Requirements (IDCRX) for Ham Products, Reduced Sodium, Cured, Boneless, Fully Cooked, Frozen, dated September 2012. | 110297              | Individual hams must be produced "cook-n-ship" casings with a diameter of 4.0 to 4.5 inches. Twelve 3-lb. hams are packed 36 lbs. net weight per shipping container and shipped frozen. | 36,000 lbs.<br>1,000 cases             | Minus 60 lbs. – delivery unit must be between 35,940 and 36,000 lbs. | 1st half/last half of month delivery period | Federal & State       | Full & Open                    |
| PORK HAM WTRAD RDUSOD SLC FRZ PKG-8/5 LB | Experimental Item Description and Checklist of Requirements (IDCRX) for Ham Products, Reduced Sodium, Cured, Boneless, Fully Cooked, Frozen, dated September 2012. | 110296              | Eight 5-lb. packages of thinly sliced shingle layered packages are packed 40 lbs. net weight per shipping container and shipped frozen.   | 40,000 lbs.<br>1,000 cases             | NONE   | 1st half/last half of month delivery period | Federal & State       | Full & Open                    |



# APPROVED

Contracting Officer Technical Representative (COTR)  
 Livestock, Poultry and Seed Program  
 Food Safety and Commodity Specification Division  
 Room 2607 S-Bldg, Phone: (202) 260-8295

## ITEM DESCRIPTION AND CHECKLIST OF REQUIREMENTS (IDCR) FOR HAM PRODUCTS, CURED, BONELESS, FULLY COOKED, FROZEN OR CHILLED

Effective: **September 2012**

### 100 ITEM DESCRIPTION

- 110 Bulk Ham, Cured, Boneless, Fully-Cooked, Water Added, Frozen or Chilled** – For material numbers 100184 and 100186, four 10-pound hams will be snugly packed into shipping containers to a net weight of 40 pounds. For material number 100182, twelve 3-pound hams will be snugly packed into a shipping container to a net weight of 36 pounds. The bulk packaged hams will be round or oval shaped and have a diameter of 4.0 to 4.5 inches.
- 120 Sliced Ham, Cured, Boneless, Fully-Cooked, Water Added, Frozen** –Thinly sliced (not shaved) ham (material numbers 100187 and 100891) shall be shingle layered and packaged. For material number 100187, eight 5-pound packages will be snugly packed into shipping containers to a net weight of 40 pounds. For material number 100891, twenty 2-pound packages will be snugly packed into shipping containers to a net weight of 40 pounds. The full intact slices shall be round, or oval shaped with a diameter of 4.0 to 4.5 inches or square shaped with dimensions of 4X4 or 4X6 inches.
- 130 Items described in Sections 110 and 120** shall be 97 percent fat free (3 percent fat), minimum Protein Fat Free (PFF) value of 17.0 percent, and have a whole muscle appearance (not ground or chopped), uniform color (slightly two tone color is permissible), no spongy (porous texture) appearance (after thawing of frozen ham).
- 140 Diced Ham, Cured, Boneless, Fully-Cooked, Frozen** – The product shall be 97 percent fat free and have a minimum PFF value of 15.0 percent. This item (material number 100188) is recommended for use as a topping for pizza, salads, omelets and as a component for soups, stews, and casseroles. Eight 5-pound packages will be snugly packed into shipping containers to a net weight of 40 pounds. The dices shall be ¼-inch cubes and may be made from ground or chopped and formed ham.

### 200 CHECKLIST OF REQUIREMENTS

- 210** All items must be produced in accordance with Food Safety and Inspection Service (FSIS) regulations and the checklist of requirements.

**300 MATERIALS**

310 The contractor's technical proposal must include procedures to address conformance with the following material requirements.

**320 MEAT COMPONENT**

321 Pork (shall be derived from suitable lean from any portion of the sow and/or hog carcass) will be the only meat component allowed. Pork derived from boars is not permissible.

322 Domestic Origin of Meat Component – All sows and/or hogs will originate from U.S. produced livestock as defined in the Supplement.

323 Harvesting (Slaughtering) – All sows and/or hogs will be harvested in facilities that comply with the following requirements:

323.1 Humane Handling – All sows and/or hogs will be humanely handled in accordance with all applicable FSIS regulations and AMS requirements.

323.2 Non-Ambulatory Disabled Animals – Meat from carcasses of non-ambulatory disabled livestock will not be included in USDA Purchase Programs.

324 Boneless Pork Legs – Hams will be derived from boneless pork legs that comply with the following requirements:

324.1 Traceability – Contractors are responsible for providing sufficient product traceability and must have records to verify the source of raw materials used in each lot of product.

324.2 Handling – All boneless pork legs must be maintained in excellent condition. The contractor's technical proposal shall include detailed production scheduling with time and temperature controls necessary to maintain excellent condition of the boneless pork legs.

324.3 Fresh Chilled Only – Meat will be derived from fresh chilled boneless pork legs. Previously frozen boneless pork legs cannot be used.

324.4 Uniform Color – To the extent possible, pork leg muscles should be sorted for color uniformity.

324.5 Lean Quality – The pork leg muscles must not exhibit any evidence of pale, soft, and/or exudative conditions.

324.6 Shanks and Inner Shanks – If used, shanks and inner shanks must be ground, emulsified, or otherwise reduced in size.

324.7 Objectionable Materials – Pork legs will be free of bones, cartilages, skins, spinal cord, and foreign materials.

- 324.8 Ground Meat – Pork leg trimmings (including shank meat and rework) that is ground, emulsified, or otherwise reduced in size cannot exceed 7 percent of the meat component.
- 324.9 Rework - If used, rework must be derived from finished ham product intended for delivery to USDA, not be associated with any positive pathogen test and be included as a component of the ground meat (see Section 324.8) while not exceeding a level of 2 percent based on finished product weight.
- 325 Mechanical Separation – Meat that is mechanically separated from bone with automatic deboning systems, advanced lean (meat) recovery (AMR) systems, or powered knives will not be allowed.

### 330 NON-MEAT COMPONENTS

- 331 All non-meat components will be listed in the ingredient statements.
- 332 [Domestic Origin – Significant ingredients \(more than 1 percent\) shall be derived from U.S. produced products.](#)
- 333 Product Formula – The production formula must include water, dextrose, salt, sodium phosphate and sodium nitrite. Sodium erythorbate, and/or sodium ascorbate, may be used.
- 334 Ingredient Limitations – The ingredients in the product formula must comply with the amount as listed:
- 334.1 Dextrose – 3%
- 334.2 Salt – 2.5%
- 334.3 Sodium Phosphate – No more than 0.5%
- 335 Binder Agent – Binder agents such as carrageenan, modified food starch, and isolated soy protein may be used.

### 400 PROCESSING

#### 410 PROCESSING DATE

- 411 [Ham products, as delivered to AMS destinations,](#) will be processed no more than 60 days prior to shipment.

#### 420 CASING DIAMETER / DIMENSION

- 421 Bulk Packaged Ham - All bulk packaged hams will be stuffed and processed within high oxygen and high moisture barrier poly “cook-n-ship” casings with a diameter of 4.0 to 4.5 inches. Ham then may be pressed.

422 Sliced and Diced Packaged Ham - All sliced and diced packaged hams will be stuffed and processed within high oxygen and high moisture barrier poly "cook-n-ship" casings with a diameter of 4.0 to 4.5 inches or square shaped with dimensions of 4X4 or 4X6 inches. Ham then may be sliced or diced and repackaged (see Section 712.2).

#### 430 PRODUCT COOKING

431 [Ham will be fully cooked in accordance with FSIS regulations.](#)

#### 440 METAL DETECTION

441 All hams must be free of metal contamination. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required. The equipment, location, detection procedure, sensitivity levels, frequency of equipment validation, and corrective action procedures will be identified and described.

#### 500 FINISHED PRODUCT LIMITATIONS

510 Fat and protein-fat-free label declarations shall comply with FSIS labeling regulations.

#### 520 FAT

521 The contractor will target production to maintain a process average for fat content to be 3.0 percent or less. The contractor will use a Statistical Process Control (SPC) program to analyze fat test results. The SPC Upper Specification Limit (USL) is 3.6 percent fat. The average test results of each production lot exceeding the USL will not be allowed delivery to USDA. For the purpose of this section, a lot cannot exceed one day's production.

#### 530 PROTEIN FAT FREE (PFF)

531 The contractor will target their production to maintain the PFF values as specified with the item description.

#### 540 MICROBIAL

541 Contractor must have a documented plan to comply with the latest FSIS *Salmonella* and *Listeria monocytogenes* requirements for ready-to-eat foods. Product tested positive for any pathogen will not be allowed as rework or delivery to USDA.

#### 550 PHYSICAL CHARACTERISTICS

551 Since one or more freeze/thaw cycles will cause moisture loss and affect quality, hams shall not appear spongy or porous in texture after freezing and thawing. Diced hams will be processed to minimize 'clumping' so that it is easily removed from bags by the end user without completely thawing.

**600 STATE OF REFRIGERATION**

610 Hams must comply with the following holding time and temperature requirements:

**620 HOLDING TIME**

621 Frozen Ham Products – After processing, ham destined for freezing will be refrigerated for a minimum of 24 hours. The diced ham will be frozen in a manner to minimize 'clumping' after freezing.

**630 HOLDING TEMPERATURE**

631 Frozen Hams ([material numbers 100184, 100182, 100187, 100188, 100891](#)) – Hams destined for freezing will have an internal temperature not to exceed 40°F prior to placement in the freezer.

632 Chilled Hams ([material number 100186](#)) – Chilled hams will be maintained at a temperature of not less than 28°F (2.2°C) or higher than 40°F (4.4°C).

**640 72 HOURS TEMPERATURE**

641 Frozen hams must be 0°F or below within 72 hours after placement into the freezer.

**700 PREPARATION FOR DELIVERY****710 PACKAGING**

711 Package – All bulk packaged hams will be stuffed and processed within poly "cook-n-ship" high oxygen and high moisture barrier casings. Sliced, shingle layered hams and diced hams will be packaged into bags or thermoformed packaging and vacuum sealed. All packages will be closed by heat seal or metal clips.

712 Package Net Weight –

712.1 [Bulk Ham – For material number 100182, ham will be packaged into casings to a net weight of 3 pounds. For material numbers 100184 and 100186, ham will be packaged into casings to a net weight of 10 pounds.](#)

712.2 [Sliced and Diced Hams – For material numbers 100187 and 100188, ham product will be vacuum packaged or thermoformed vacuum packaged to a net weight of 5 pounds. For material number 100891, ham product will be vacuum packaged or thermoformed vacuum packaged to a net weight of 2 pounds.](#)

**720 PACKING**

- 721 Bulk Ham – For [material number 100182](#), twelve, 3-pound hams will be snugly packed into a new shipping container to a net weight of 36 pounds. For [material numbers 100184 and 100186](#), four 10-pound hams will be snugly packed into a new shipping container to a net weight of 40 pounds.
- 722 Sliced or Diced Hams – For [material numbers 100187 and 100188](#), eight 5-pound packages will be snugly packed into a new shipping container to a net weight of 40 pounds. For [material number 100891](#), twenty 2-pound packages will be snugly packed into a new shipping container to a net weight of 40 pounds.

**730 LABELING<sup>1/</sup>**

- 731 The shipping containers will be in compliance with the National Motor Freight Classification, or the Uniform Freight Classification, as applicable. Both immediate (packaging material) and shipping containers will be labeled to include all information required by FSIS regulations.
- 732 10-Pound Ham, 5-Pound Sliced and Diced Hams Immediate Container Labels (casings or package) – Each immediate container is required to have a traceability code that is traced back to establishment number, production lot, and date.
- 733 3-Pound Ham and 2-Pound Sliced Immediate Container Label (casings or package) – Each immediate container will contain the following information:
- 733.1 A traceability code that is traced back to establishment number, production lot, and date.
- 733.2 A “Best-If-Used-By” date that is 180 calendar days from the date of production.
- 733.3 Nutrition facts panel based on actual nutritional analysis of the product.
- 734 Shipping Container Label – Shipping containers will contain the following information:
- 734.1 USDA shield at least 2 inches high and appearing on the top of the container or on the principle display panel.
- 734.2 Appropriate [purchase order number](#).
- 734.3 A traceability code that is traced back to establishment number, production lot, and date.
- 734.4 A nutrition facts panel based on actual nutritional analysis of the product.
- 734.5 10-Pound Ham, 5-Pound Sliced and Diced Hams shipping containers shall have the statement “for institutional use only”.



734.6 The appropriate [product name and material number](#) listed in the table below for each of the items.

| <a href="#">Item</a>   | <a href="#">Material Number</a> |
|--|---------------------------------|
| 10 lb. Bulk Ham, Cured, Boneless, Fully Cooked, Water Added, Frozen  | 100184                          |
| 10 lb. Bulk Ham, Cured, Boneless, Fully Cooked, Water Added, Chilled | 100186                          |
| 3 lb. Bulk Ham, Cured, Boneless, Fully Cooked, Water Added, Frozen   | 100182                          |
| 5 lb. Sliced Ham, Cured, Boneless, Fully Cooked, Water Added, Frozen | 100187                          |
| 5 lb. Diced Ham, Cured, Boneless, Fully Cooked, Frozen               | 100188                          |
| 2 lb. Sliced Ham, Cured, Boneless, Fully Cooked, Water Added, Frozen | 100891                          |

734.7 An allergen statement in a format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains \_\_\_\_\_.

<sup>1</sup>All labeling illustrations must be provided.

**740 CLOSURE**

741 Shipping containers will be closed by strapping, taping or gluing. When strapping is used, the initial closure (usually the bottom of container) shall be secured by the gluing or taping method.

**750 PALLETIZED UNIT LOADS**

751 All product 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 principle display panel to facilitate certification examinations.

**800 DELIVERY UNIT**

810 The delivery units for each of the following respective [material numbers](#) are as follows:

**820 MATERIAL NUMBERS 100184, 100186, 100187, 100188, 100891**

821 Each delivery will consist of 1,000 shipping containers with a net weight of 40,000 pounds.

**830 MATERIAL NUMBER 100182**

831 Each delivery will consist of 1,000 shipping containers with a net weight of 35,940 - 36,000 pounds.

**900 DELIVERED PRODUCT****910 SIZE AND STYLE OF CONTAINER**

911 Only one size and style of immediate (casings) and shipping containers may be offered in an individual shipping unit.

**920 TEMPERATURE**

921 Chilled Ham Temperature – Chilled ham will be delivered at a temperature of not less than 28°F (2.2°C) or higher than 40°F (4.4°C).

922 Frozen Ham Temperature – All products will be frozen and will not exceed 0°F at the time of shipment and delivery.

**930 SEALING**

931 All products must be delivered to AMS destinations under seal with tamper proof, tamper resistant, serially numbered, high security seals that meet the American Society for Testing and Materials Standard F 1157-04 as required under the AMS Master Solicitation.

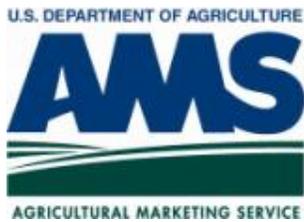
**1000 PRODUCT ASSURANCE****1010 WARRANTY AND COMPLAINT RESOLUTION**

1011 Warranty – The contractor will guarantee that the product complies with all contractual requirements required under this [Supplement](#).

1012 Complaint Resolution – The contractor's technical proposal must provide steps taken to resolve complaints received on the product (i.e. point of contact, cause and effect analysis, corrective and preventative actions taken, and product replacement).

**1020 NON-CONFORMING PRODUCT**

1021 The contractor must have documented procedures that assure nonconforming product identification, segregation, and disposition in order to prevent misuse and that nonconforming product is not delivered to USDA. The plan must address 1) control and segregation of non-conforming product, 2) removal of any USDA markings, and 3) disposition of non-conforming product.



# APPROVED

Contracting Officer Technical Representative (COTR)  
 Livestock, Poultry and Seed Program  
 Food Safety and Commodity Specification Division  
 Room 2607 S-Bldg, Phone: (202) 260-8295

## EXPERIMENTAL ITEM DESCRIPTION AND CHECKLIST OF REQUIREMENTS (IDCRX) FOR HAM PRODUCTS, REDUCED SODIUM, CURED, BONELESS, FULLY COOKED, FROZEN

Effective: September 2012

### 100 ITEM DESCRIPTION

**110 Bulk Ham, Reduced Sodium, Cured, Boneless, Fully-Cooked, Water Added, Frozen** – Twelve 3-pound hams will be snugly packed into a shipping container to a net weight of 36 pounds. The bulk packaged hams will be round or oval shaped and have a diameter of 4.0 to 4.5 inches.

**120 Sliced Ham, Reduced Sodium, Cured, Boneless, Fully-Cooked, Water Added, Frozen** – Eight 5-pound packages will be snugly packed into shipping containers to a net weight of 40 pounds. The full, intact slices (thinly sliced; not shaved) shall be round, or oval shaped with a diameter of 4.0 to 4.5 inches or square shaped with dimensions of 4X4 or 4X6 inches.

### 200 CHECKLIST OF REQUIREMENTS

210 All items must be produced in accordance with Food Safety and Inspection Service (FSIS) regulations and the checklist of requirements.

### 300 MATERIALS

310 The contractor's technical proposal must include procedures to address conformance with the following material requirements.

### 320 MEAT COMPONENT

321 Pork (shall be derived from suitable lean from any portion of the sow and/or hog carcass) will be the only meat component allowed. Pork derived from boars is not permissible.

322 Domestic Origin of Meat Component – All sows and/or hogs will originate from U.S. produced livestock as defined in the Supplement.

323 Harvesting (Slaughtering) – All sows and/or hogs will be harvested in facilities that comply with the following requirements:

- 323.1 Humane Handling – All sows and/or hogs will be humanely handled in accordance with all applicable FSIS regulations and AMS requirements.
- 323.2 Non-Ambulatory Disabled Animals – Meat from carcasses of non-ambulatory disabled livestock will not be included in USDA Purchase Programs.
- 324 Boneless Pork Legs – Hams will be derived from boneless pork legs that comply with the following requirements:
- 324.1 Traceability – Contractors are responsible for providing sufficient product traceability and must have records to verify the source of raw materials used in each lot of product.
- 324.2 Handling – All boneless pork legs must be maintained in excellent condition. The contractor's technical proposal shall include detailed production scheduling with time and temperature controls necessary to maintain excellent condition of the boneless pork legs.
- 324.3 Fresh Chilled Only – Meat will be derived from fresh chilled boneless pork legs. Previously frozen boneless pork legs cannot be used.
- 324.4 Uniform Color – To the extent possible, pork leg muscles should be sorted for color uniformity.
- 324.5 Lean Quality – The pork leg muscles must not exhibit any evidence of pale, soft, and/or exudative conditions.
- 324.6 Shanks and Inner Shanks – If used, shanks and inner shanks must be ground, emulsified, or otherwise reduced in size.
- 324.7 Objectionable Materials – Pork legs will be free of bones, cartilages, skins, spinal cord, and foreign materials.
- 324.8 Ground Meat – Pork leg trimmings (including shank meat and rework) that is ground, emulsified, or otherwise reduced in size cannot exceed 7 percent of the meat component.
- 324.9 Rework - If used, rework must be derived from finished ham product intended for delivery to USDA, not be associated with any positive pathogen test and be included as a component of the ground meat (see Section 324.8) while not exceeding a level of 2 percent based on finished product weight.
- 325 Mechanical Separation – Meat that is mechanically separated from bone with automatic deboning systems, advanced lean (meat) recovery (AMR) systems, or powered knives will not be allowed.
- 330 NON-MEAT COMPONENTS**
- 331 All non-meat components will be listed in the ingredient statements.

332 Domestic Origin – Significant ingredients (more than 1 percent) shall be derived from U.S. produced products.

333 Product Formula – The production formula must include water, dextrose, salt, sodium phosphate, antimicrobial agent(s) and sodium nitrite. Sodium erythorbate, and/or sodium ascorbate, may be used.

#### **400 PROCESSING**

#### **410 PROCESSING DATE**

411 Ham products, as delivered to AMS destinations, will be processed no more than 60 days prior to shipment.

#### **420 CASING DIAMETER / DIMENSION**

421 Bulk Packaged Ham - All bulk packaged hams will be stuffed and processed within high oxygen and high moisture barrier poly “cook-n-ship” casings with a diameter of 4.0 to 4.5 inches. Ham then may be pressed.

422 Sliced Packaged Ham - All sliced packaged hams will be stuffed and processed within high oxygen and high moisture barrier poly “cook-n-ship” casings with a diameter of 4.0 to 4.5 inches or square shaped with dimensions of 4X4 or 4X6 inches. Ham then may be sliced and repackaged (see Section 712.2).

#### **430 PRODUCT COOKING**

431 Ham will be fully cooked in accordance with FSIS regulations.

#### **440 METAL DETECTION**

441 All hams must be free of metal contamination. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required. The equipment, location, detection procedure, sensitivity levels, frequency of equipment validation, and corrective action procedures will be identified and described.

#### **500 FINISHED PRODUCT LIMITATIONS**

510 Fat and protein-fat-free label declarations shall comply with FSIS labeling regulations.

#### **520 FAT**

521 The contractor will target production to maintain a process average for fat content to be 3.0 percent or less. The contractor will use a Statistical Process Control (SPC) program to analyze fat test results. The SPC Upper Specification Limit (USL) is 3.6 percent fat. The average test results of each production lot exceeding the USL will not be allowed delivery to USDA. For the purpose of this section, a lot cannot exceed one day's production.

**530 PROTEIN FAT FREE (PFF)**

531 The contractor will target their production to maintain a PFF value of 17 -18.4 percent.

**540 SODIUM**

541 The sodium level shall not exceed 700 mg per 100 g serving.

((Declared Sodium Level (mg) X 100) ÷ Declared Serving Size (g; racc) ≤ 700))

**550 MICROBIAL**

551 Contractor must have a documented plan to comply with the latest FSIS *Salmonella* and *Listeria monocytogenes* requirements for ready-to-eat foods. Product tested positive for any pathogen will not be allowed as rework or delivery to USDA.

**560 PHYSICAL CHARACTERISTICS**

561 Since one or more freeze/thaw cycles will cause moisture loss and affect quality, hams shall not appear spongy or porous in texture after freezing and thawing.

**600 STATE OF REFRIGERATION**

610 Hams must comply with the following holding time and temperature requirements:

**620 HOLDING TIME**

621 After processing, ham shall be refrigerated for a minimum of 24 hours prior to being placed in the freezer.

**630 HOLDING TEMPERATURE**

631 Prior to placement into the freezer, hams shall have an internal temperature not to exceed 40°F.

**640 72 HOURS TEMPERATURE**

641 Hams must be 0°F or below within 72 hours after placement into the freezer.

**700 PREPARATION FOR DELIVERY****710 PACKAGING**

711 Package – Bulk packaged hams will be stuffed and processed within poly "cook-n-ship" high oxygen and high moisture barrier casings. Sliced hams will be packaged into bags or thermoformed packaging and vacuum sealed. All packages will be closed by heat seal or metal clips.

712 Package Net Weight –

712.1 Bulk ham will be packaged into casings to a net weight of 3 pounds.

712.2 Sliced ham will be vacuum bagged or thermoformed vacuum packaged to a net weight 5 pounds.

## 720 PACKING

721 Bulk Ham – Twelve 3 pound hams will be snugly packed into a new shipping container to a net weight of 36 pounds.

722 Sliced Ham – Eight 5 pound packages will be snugly packed into a new shipping container to a net weight of 40 pounds.

## 730 LABELING<sup>1/</sup>

731 The shipping containers will be in compliance with the National Motor Freight Classification, or the Uniform Freight Classification, as applicable. Both immediate and shipping containers will be labeled to include all information required by FSIS regulations.

732 Sliced Ham Immediate Container Labels – Each immediate container is required to have a traceability code that is traced back to establishment number, production lot, and date.

733 Bulk Ham Immediate Container Label – Each immediate container will contain the following information:

733.1 A traceability code that is traced back to establishment number, production lot, and date.

733.2 A “Best-If-Used-By” date that is 180 calendar days from the date of production.

733.3 Nutrition facts panel based on actual nutritional analysis of the product.

734 Shipping Container Label – Shipping containers will contain the following information:

734.1 USDA shield at least 2 inches high and appearing on the top of the container or on the principle display panel.

734.2 Appropriate purchase order number.

734.3 A traceability code that is traced back to establishment number, production lot, and date.

734.4 A nutrition facts panel based on actual nutritional analysis of the product.



734.5 Sliced ham shipping containers shall have the statement “for institutional use only”.

734.6 The appropriate product name and material numbers listed in the table below for each of the items.

| <u>Item</u>  | <u>Material Number</u> |
|--|------------------------|
| 3lb. Bulk Ham, Reduced Sodium, Cured, Boneless, Fully-Cooked, Water Added, Frozen    | 110297                 |
| 5 lb. Sliced Ham, Reduced Sodium, Cured, Boneless, Fully-Cooked, Water Added, Frozen | 110296                 |

734.7 An allergen statement in a format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains \_\_\_\_\_.

<sup>1/</sup>All labeling illustrations must be provided.

**740 CLOSURE**

741 Shipping containers will be closed by strapping, taping or gluing. When strapping is used, the initial closure (usually the bottom of container) shall be secured by the gluing or taping method.

**750 PALLETIZED UNIT LOADS**

751 All product 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 principle display panel to facilitate certification examinations.

**800 DELIVERY UNIT**

810 The delivery units for each of the following respective material numbers are as follows:

**820 MATERIAL NUMBER 110296**

821 Each delivery will consist of 1,000 shipping containers with a net weight of 40,000 pounds.

**830 MATERIAL NUMBER 110297**

831 Each delivery will consist of 1,000 shipping containers with a net weight of 35,940 - 36,000 pounds.

**900 DELIVERED PRODUCT****910 SIZE AND STYLE OF CONTAINER**

911 Only one size and style of immediate (casings) and shipping containers may be offered in an individual shipping unit.

**920 TEMPERATURE**

921 All products will be frozen and will not exceed 0°F at the time of shipment and delivery.

**930 SEALING**

931 All products must be delivered to AMS destinations under seal with tamper proof, tamper resistant, serially numbered, high security seals that meet the American Society for Testing and Materials Standard F 1157-04 as required under the AMS Master Solicitation.

**1000 PRODUCT ASSURANCE****1010 WARRANTY AND COMPLAINT RESOLUTION**

1011 Warranty – The contractor will guarantee that the product complies with all contractual requirements required under this Supplement.

1012 Complaint Resolution – The contractor's technical proposal must provide steps taken to resolve complaints received on the product (i.e. point of contact, cause and effect analysis, corrective and preventative actions taken, and product replacement).

**1020 NON-CONFORMING PRODUCT**

1021 The contractor must have documented procedures that assure nonconforming product identification, segregation, and disposition in order to prevent misuse and that nonconforming product is not delivered to USDA. The plan must address 1) control and segregation of non-conforming product, 2) removal of any USDA markings, and 3) disposition of non-conforming product.