

SUPPLEMENT 603 TO AMS MASTER SOLICITATION

June 2012

**PURCHASE OF FROZEN BISON AND BUFFALO PRODUCTS
FOR DISTRIBUTION TO CHILD NUTRITION AND
OTHER FEDERAL FOOD AND NUTRITION ASSISTANCE PROGRAMS**

- A. This document provides additional USDA requirements and specifications for the purchase of frozen bison and frozen buffalo products as described in the attached CHECKLIST AND REFERENCES TO APPLICABLE OFFER AND CONTRACT PROVISIONS ([Exhibit A](#)). In addition to product descriptions, this exhibit also provides information on the applicable Technical Data Supplements (TDS) for Frozen Ground Bison and Bison Stew Meat (TDS-BIS-2012, Attachment I) and Frozen Ground Buffalo and Buffalo Stew Meat (TDS-BUF-2012, Attachment II).

I. INSTRUCTIONS TO POTENTIAL SUPPLIERS

- A. The frozen bison and frozen buffalo products will be purchased on a competitive bid basis from suppliers who have met the requirements described in Section I.B. Interested suppliers may submit a production plan at any time during this purchase program. Suppliers should allow 10 working days from receipt of the production plan by USDA for notification of the results of the evaluation of the production plan from the Contracting Officer's Technical Representative (COTR). A supplier is deemed "eligible" after notification by the COTR.

Submission of a production plan is not binding on USDA. Supplier eligibility for USDA purchase programs will be based on the technical approval of the supplier as well as the completion of additional contractor requirements described in the AMS Master Solicitation for Commodity Procurements, this Supplement, and/or a separately issued Solicitation.

B. Documentation and Assessment Requirements

To become an eligible supplier, the following must be submitted electronically to the Standardization Division, Agricultural Marketing Service, U.S. Department of Agriculture, for evaluation and approval prior to bidding:

1. Production Plan Requirement:

- a. Include a detailed description of item and each of the production steps that are taken to meet or exceed the minimum product requirements set forth in the applicable TDS. (Plan/Do)
- b. Describe all the quality assurance methods used to verify conformance to all requirements. This will include the monitoring and measurements taken during the process to verify conformance with each requirement. All measurement results shall be recorded and made available to AMS. (Check)
- c. Identify all corrective actions to be taken if deviations from contractual and specification requirements occur during production, and all preventative actions to be taken to preclude a reoccurrence. (Act)

- d. The production plan shall follow the format as describe in Section III., Production Plan Format. The production plan should be brief and concise.
- e. The production plan shall be preceded by the following, as required by the template:
 - 1) Table of Contents listing the major areas as they appear in the production plan template; and
 - 2) List of attachments, forms provided with the plan, if appropriate.
- f. The production plan should be written in the following format:
 - 1) Plan and Do - A description of the planning and production steps taken to meet each requirement.
 - 2) Check - Describes all the quality assurance methods that will be used to verify conformances to each requirement. This will include the monitoring and measurement taken during the process (all measurements results shall be recorded and made available to AMS upon request).
 - 3) Act - Identifies all corrective actions to be taken if deviations from contractual and specification requirements occur during production and all preventative actions taken to preclude reoccurrences.

The COTR will review each production plan to determine if the plan is adequate and will notify the supplier of the status of their production plan. See Section III for submission of production plans.

Once a supplier is notified by the COTR that the production plan meets the applicable criteria, the Grading and Verification Division (GVD) will contact the supplier to set up a pre-award onsite capability assessment.

2. GVD Monitoring and Evaluation Program

Eligible suppliers who receive USDA contracts must have a GVD agent present during the production of the frozen bison or frozen buffalo products. The GVD agent will monitor and verify the production based on the contractor's approved production plan and the TDS. The contractor must provide a copy of the approved production plan and have the supporting documentation readily available for review by the COTR or GVD (AMS) agent. Records may be maintained on hard copy or electronic media; however, records maintained as electronic media will be made available in printed form immediately upon request by AMS or its agents.

3. GVD Assessments

After the production plan is evaluated and approved, a GVD auditor will perform an onsite assessment of the facility(s), processes, food security plan, and quality control program used to produce the product(s) to determine the supplier's ability to meet contractual requirements. The following assessments will apply:

1) Pre-Award Onsite Capability Assessment

The pre-award onsite assessment (audit) will include, but is not limited to, a thorough evaluation of the potential contractor's and subcontractor's facility(s), processes, food security plan, quality control program, equipment, procedures, and the appropriate documents and forms used during the production of the bison products item.

Documentation must support: 1) the production of the bison or buffalo products which complies with the applicable TDS and the potential contractor's approved production plan, and 2) the contractor's or subcontractor's food security plan. In addition, the audit will consist of the review of records related to purchasing, receiving, production, quality control, inventory and shipping records, and interviews with management and production personnel.

Upon completion of the pre-award onsite capability assessment, the GVD auditor will provide a report to the COTR for final review. After the supplier has satisfactorily completed the pre-award onsite capability assessment, the supplier will receive written notification from the COTR of their technical approval for the USDA purchase program.

Once a supplier is technically eligible to bid, the supplier must follow instructions stated in the AMS Master Solicitation to participate in USDA procurement activities.

If the report demonstrates that the production plan or food security plan is inadequate, the applicant will be notified by the COTR that they have not received technical approval for the USDA purchase program. The applicant will have an opportunity to correct identified deficiencies, modify their process, food security plan, and/or production plan, and resubmit for further consideration. Eligibility will depend on whether the modifications demonstrate that 1) the process is capable of delivering the products in compliance with the applicable TDS; 2) they are in compliance with their food security plan; 3) includes the applicable assessment by USDA; and 4) they comply with other applicable contractual requirements.

2) Post-Award Assessment

Eligible suppliers who receive USDA contracts must have their documented food security plan, production plan, and supporting documentation readily available for review by the COTR or GVD (AMS) agents. Records may be maintained on hard copy or electronic media; however, records maintained as electronic media will be made available in printed form immediately upon request by AMS or its agents.

The GVD will conduct an onsite audit of the contractor's and subcontractor's facility(s) and processes when production commences for the first contract awarded. Additional audits will be conducted as determined by the Contracting Officer but not less than once per month for contractors or subcontractors with continuous or multiple contracts, or once per contract for intermittent contractors. At the discretion of the Contracting Officer, more frequent audits may be conducted when audit deficiencies are detected.

3) Post-Award Actions

Any deviation from contractual requirements will be immediately reported by the contractor to the Contracting Officer. The Contracting Officer will notify the contractor regarding eligibility to continue to participate as a contractor.

Contractor will assure that the delivered product complies with the provisions of the applicable TDS, the applicable assessment by USDA, and the contractor's production plan approved by the COTR.

C. Animal Welfare Requirements

The contractor and all subcontractors must meet the animal handling and welfare requirement set forth in the attached **Attachment III - Technical Requirements Schedule – Bison Handling and Welfare 2010 (TRS-BHW-2010)**.

D. Responsibility/Eligibility

Facilities used in fulfilling USDA contracts must be operating under the provisions of the Voluntary Exotic Animal Inspection Program of the FSIS contained in Title 9 C.F.R. Subpart 352. The firm must also be approved under an AMS pre-award supplier capability assessment audit prior to submitting an offer under this Supplement. Firms must also comply with the provisions of FSIS Final Rule for Pathogen Reduction; Hazard Analysis and Critical Control (HACCP) Systems.

Subcontractors or suppliers of frozen bison and frozen buffalo products are: (1) ineligible if they are currently delivering late on USDA contracts or USDA-approved subcontracts, and late delivery is not due to causes beyond their control; and (2) non-responsible if they are not operating under the provisions of the Voluntary Exotic Animal Inspection Program of the FSIS contained in Title 9 C.F.R. Subpart 352 or have been suspended or debarred under the provisions of 48 C.F.R. Subpart 9.4

E. Domestic Requirements

The contractor agrees to include the domestic origin certification clause in its entirety in all subcontracts for meat or meat products used in fulfilling any contracts awarded under this Supplement and/or the AMS Master Solicitation. The burden of proof of compliance is on the contractor. All raw materials will be shipped in containers labeled as "Domestic Only Product" on the principle display panel and the bill of lading accompanying the shipment will contain the statement "Domestic Only Product."

Domestic verification requirements must be included in the contractor's production plan.

II. SUBMISSION OF OFFERS

The following Item will be included in the attribute section of the offer submitted in the Web Based Supply Chain Management (WBSCM) system (see Exhibit 2 of the AMS Master Solicitation):

9. Offeror certifies that all product conforms with the (applicable specification) and no changes to the production process or production plan have occurred without proper approval by the Contracting Officer.
 - Does

III. INSTRUCTIONS FOR SUBMISSION OF PRODUCTION PLAN

The following procedures establish the acceptable minimum requirements for the format and content of the production plan (proposal):

- A. The Government has provided a production plan format which is to be used in preparing the production plan (see **Exhibit B**). The offeror shall submit the production plan in an electronic format through the company's external portal site maintained by the AMS, Commodity Procurement Division (see **Exhibit C** for instructions on how to obtain an external portal site). When submitting the production plan through the company's external portal site, e-mail notification to the COTR must be provided (darin.doerscher@ams.usda.gov or steve.whisenant@ams.usda.gov). The production plan shall be saved in a **non-portable** document file format (not PDF; e.g., Microsoft Word). The production plan must be submitted in its entirety. The collection of attachments and appendices may be submitted as a separate document. This format and the electronic form provided as **Exhibit C** will aid in the evaluation of the production plan.
- B. The production plan must be submitted by an authorized agent of the company.
- C. While it is not the desire of the Government to penalize an offeror for noncompliance with formatting instructions, technical evaluators may have difficulty evaluating the production plan to the fullest extent possible if the proposal is not presented in the proper format. Technical evaluators will not be required to search other subsections or sections of the offeror's production plan for information requested for evaluation.
- D. Production Plan Revisions

Changes to an offeror's production plan may be submitted based on the Government's Amendments, Clarification Request, monitoring program, or at the request of the offeror. Maintenance of the integrity and clarity of each production plan is critical. All production plan revisions must meet the following criteria:

1. Any changes to a production plan made by the offeror after its initial approval shall be accomplished by submitting the entire production plan. A cover letter must be submitted with the changes identified and an explanation of the need for the change. The offeror shall include the revision date and the appropriate page number(s).

2. Changes from the original production plan shall be **highlighted** and deletions in ~~strikeouts~~.

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

IV. PRODUCT SPECIFICATIONS AND AUDIT SERVICES

- A. Specifications for frozen bison and frozen buffalo products are identified in [Exhibit A](#). If documents are amended, appropriate amendments must be referenced.
- B. AMS certification agents, under the direction of the LS Program, will perform all applicable examinations and tests as required. AMS agents will conduct all certification services in accordance with the applicable GVD Instruction(s). The cost of all certification and audit services performed by the AMS certification agents must be borne by the contractor. This includes, but is not limited to, examinations, supervision, official documentation, and related services (including charges for microbiology and fat content analyses).

GVD auditors, under the direction of the LS Program, will perform audit services on the portions of the contractor's approved production plan that are not under the control of the AMS certification agent. The frequency of the audits will occur, at a minimum, once per month or, when applicable, once per contract.

- C. For certification services, AMS will pay per diem and travel expenses including travel time involved in transporting the AMS certification agents from a duty point into the area of a contractor's or subcontractor's plant. However, payment of these charges by USDA will only be made when the services rendered by an AMS certification agent are directly related to production for specific outstanding contracts. Per diem and travel expenses will be prorated to the contractor for any official services performed by the AMS certification agent not related to USDA-purchased commodities to which these provisions apply. When the services of the AMS certification agent are performed for a subcontractor, the contract number in which the product will be used must be declared to the AMS certification agent.
- D. The cost of all AMS audits required by GVD, including per diem and travel expenses, must be borne by the contractor or subcontractor.
- E. All local travel and travel time will be charged to the contractor or subcontractor in accordance with the applicable GVD instructions and regulations. The regular hourly rate and established fees for required laboratory analyses will be charged as applicable.
- F. Laboratory fees incurred for testing of the boneless bison and boneless buffalo samples and ground bison and ground buffalo items for the microbial requirements, and fees associated with the AMS process assessment sample for fat as specified in the applicable specification, will be paid by AMS.
- G. Questions concerning GVD auditors should be discussed with the GVD in Fredericksburg, Virginia at (540) 361-7640 Ext 100.

- H. Questions concerning charges and the availability of AMS agents should be discussed with the Office of Field Operations, Denver, Colorado at (720) 497-2520.
- I. Disposition of Lots Outside Specification Limits.
Any lot—in any test, **including FSIS test**—which tests positive for *E. coli O157:H7* or *Salmonella*, or exceeds the critical limit criteria of APPENDIX B of TDS-BIS-2012 (Attachment I) and TDS-BUF-2012 (Attachment II), cannot be used to produce any product purchased by USDA.

V. INVOICES AND PAYMENT

In addition to the required invoice documents referenced in the AMS Master Solicitation, the contractor must include a copy of the Contractor's Certificate of Conformance (see Exhibit D).

Purchases of the materials under this Supplement require that a “three-way match” be completed in WBSCM in order to approve an invoice; i.e., Purchase Order (PO), Goods Receipt, and Invoice with supporting documents attached.

VI. AMS CLAUSES

A. Checkloading

An AMS certification agent will perform checkloading examinations as described in the applicable specification at the time of shipment and issue an official certificate to accompany each shipment that includes all of the following information:

1. Purchase Order Number and Purchase Order line item number.
2. Sales Order Number and Sales Order Item number.
3. Name of product.
4. Applicable material number.
5. Production lot number(s) and the date each lot was produced.
6. Count of shipping containers and total projected net weight in each production lot.
7. Total projected net weights per delivery unit.
8. Identity of conveyance (numbers and letters, seals, license, etc.) as applicable.
9. Destination(s).
10. Sample average fat content analysis of each production lot for lean ground buffalo only (calculated to 2 decimal places, e.g., 8.25).

VII. PROVISIONS INCORPORATED BY REFERENCE

FAR Provisions as show in Section X of the AMS Master Solicitation are modified as shown below:

1. 52.204-8 Annual Representations and Certifications (MAR 2012)
 - (a) (1) The North American Industry Classification System code for this acquisition is 311611.
 - (2) The small business size standard is 500 employees.

Catherine V. Smith

Dave Tuckwiller, Director
Commodity Procurement Division
Agricultural Marketing Service

Attachments



Room 3932-S, STOP 0256
 1400 Independence Avenue, SW
 Washington, DC 20250-0201

EXHIBIT A
 Dated June 2012

**CHECKLIST AND REFERENCES TO APPLICABLE OFFER AND CONTRACT PROVISIONS
 SUPPLEMENT LS-601 TO AMS MASTER SOLICITATION
 for
 FROZEN BISON AND BUFFALO PRODUCTS**

PRODUCT DESCRIPTION					OFFER/CONTRACT PROVISIONS			
WBSCM Material Description	Specifications Listed in Priority Order	WBSCM Material Code	Packaging and Packing	Minimum Offer Unit Size/Shipping Unit	Tolerance Section	Delivery Period	Federal/State Plants Section I.D.	Competition (See Invitation)
BISON GROUND LEAN FRZ PKG-40/1 LB	Technical Data Supplement (TDS) for Frozen Ground Bison and Bison Stew Meat, May 2012	110001	40, 1-lb. packages packed 40 lbs. net weight (18.1 kg) per shipping container	40,000 lbs 1000 cases	None	1 st half/2 nd half delivery period	Federal Plants Only	Full & Open
BISON STEW MEAT FRZ PKG-40/1 LB		100085	40, 1-lb. packages packed 40 lbs. net weight (18.1 kg) per shipping container	40,000 lbs 1000 cases	None	1 st half/2 nd half delivery period	Federal Plants Only	Full & Open
BUFFALO GROUND LEAN FRZ PKG-40/1 LB	Technical Data Supplement (TDS) for Frozen Ground Buffalo and Buffalo Stew Meat, May 2012	100090	40, 1-lb. packages packed 40 lbs. net weight (18.1 kg) per shipping container	40,000 lbs 1000 cases	None	1 st half/2 nd half delivery period	Federal Plants Only	Full & Open
BUFFALO STEW MEAT FRZ PKG-40/1 LB		100091	40, 1-lb. packages packed 40 lbs. net weight (18.1 kg) per shipping container	40,000 lbs 1000 cases	None	1 st half/2 nd half delivery period	Federal Plants Only	Full & Open

Cover Page:

[Company Name]

[Company Address]

Contact Person, including title, phone number, including emergency contact information, e-mail address (must be authorized to represent the company).

Production plan for: [Supplement Number] and [Specification]

Table of Contents (all pages and attachments must be number and identified--any attachments must be identified and referenced in the Production plan)

The production plan should include all phases of production that meets or exceeds the requirements stated in the specification to produce complying product.

I. Scope

Brief Description of what the company plans to do to meet the requirements stated in the applicable specification (including the applicable documents).

II. Applicable Documents**III. Ordering Data**

A. ITEMS - Please provide the necessary processing steps with pictures to comply for the applicable item(s).

1. Ground Bison and Bison Stew Meat, per the applicable TDS (plan, do, check, act)
2. Materials (plan, do, check, act)
3. Processing (plan, do, check, act)
4. Metal Detection (plan, do, check, act)

B. Grade - not applicable

C. State of Refrigeration - (plan, do, check, act)

D. Fat Limitations - (plan, do, check, act)

E. Weight Range - not applicable

F. Netting and Tying - not applicable

G. Packaging and Packing - Please provide a brief description of the planning, production steps (do), check and corrective/preventive (act) measures that the company will do to assure compliance with the Preparation for Delivery section of the specification.

1. **Packaging (plan, do, check, act)**
2. **Packing (plan, do, check, act)**
3. **Closure (plan, do, check, act)**
4. **Marketing of Containers (plan, do, check, act)**
5. **Palletized Unit Loads (plan, do, check, act)**

All labeling shall be illustrated in the Offeror's production plan.

H. USDA Certification - Please provide a brief description of the planning, production steps (do), check and corrective/preventive (act) measures that the company will do to assure compliance with the Palletized Unit Load section of the specification:

1. **Product will be Certified by USDA, AMS, MGC**
2. **Lot size and Purchase unit size**
3. **AMS agent will**
4. **Official Certificate will include**

5. Microbial Requirements

I. Product Assurance

- 1. Warranty and Complaint Resolution** - (plan, do, check, act)
 - a. **Warranty**
 - b. **Complaint Resolution**
- 2. Non-Conforming Product** - (plan, do, check, act)

IV. Attachments or Appendixes

Please attach all referenced documents with the applicable document name and reference number.

UNITED STATES DEPARTMENT OF AGRICULTURE
AGRICULTURAL MARKETING SERVICE
LIVESTOCK AND SEED PROGRAM

CERTIFICATE OF CONFORMANCE FOR
THE PROCUREMENT OF BISON PRODUCTS, FROZEN

CERTIFICATE OF CONFORMANCE

I certify the following:

(1) On [shipping date(s)], [Contractor's name] furnished the (insert the appropriate commodity description) called for by Purchase Order/Item Number: _____/_____ via [Carrier] under Sales Order Number(s)/Sales Order Item number: _____/_____ .

(2) The (insert the appropriate material name) is of the quality specified and conforms in all respects with the purchase order requirements, including [Contractor's name] Technical Proposal or Production Plan as approved by the AMS Standardization Division, COTR.

(3) Product identification, (i.e. production lot number(s)) is in the quantity shown on the attached acceptance document.

(4) Contractor assures all meat or meat products used in fulfilling this contract was produced in the United States as defined in the Supplement 603, section I.F and the AMS Master Solicitation, Section I.E.

Date: _____

Signature: _____
(Signed by an officer or representative authorized to represent the company)

Title: _____



**TECHNICAL DATA SUPPLEMENT FOR
FROZEN GROUND BISON AND BISON
STEW MEAT (TDS-BIS-2012)**

APPROVED

Contracting Officer Technical Representative (COTR)
Livestock and Seed Program, Standardization Division
Room 2607 S-Bldg, Phone: (202) 260-8295

Effective: **May 2012**

I. SCOPE

This technical data supplement (TDS) is for use by the United States Department of Agriculture (USDA), Agricultural Marketing Service (AMS), [Commodity Procurement Division](#) for the procurement of frozen ground bison and bison stew meat. For this program, AMS will utilize the Institutional Meat Purchase Specifications (IMPS) descriptions and requirements for ground beef and beef for stewing as specification requirements for the production of ground bison and bison stew meat, respectively.

II. APPLICABLE DOCUMENTS

The following documents will be incorporated as part of this USDA, TDS-BIS-2012:

- Food Safety and Inspection Service (FSIS) Directive 10,010.1 Revision 3.
- IMPS General Requirements, effective June 1996.
- IMPS For Fresh Beef Products, Series 100, effective March 2010.
- IMPS Quality Assurance Provisions, effective June 1997.
- [Grading and Verification Division \(GVD\) Instruction Manual, Series 600 and 700.](#)

III. ORDERING DATA: TO BE SPECIFIED BY THE PURCHASER

(Section in the IMPS 100 Series) For the purpose of this TDS, references to "Ground Beef" (IMPS Item No. 136) and "Beef for Stewing" (IMPS Item No. 135A) are changed to Ground Bison and Bison Stew Meat, respectively.

A. ITEMS

1. GROUND BISON AND BISON STEW MEAT

The ground bison and bison stew meat shall be produced from bison harvested in, and the finished product shall be prepared and handled in, an establishment(s) operating under the Voluntary Exotic Animal Inspection Program of the USDA, Food Safety and Inspection Service (FSIS) [and must comply with the Sanitation Performance Standards provisions of 9 CFR 416.1-416.6.](#)

- a) Ground Bison – Ground bison shall be produced from fresh bison cuts and trimmings [from any portion of the carcass, which yields product that meets the end item requirements for IMPS 136.](#) Frozen, boneless bison (certified to the material requirements) may be used provided it is ground into the final product within 60 days from date of pack.

Approved by MEO MEO
Date Issued: 03/01/04
Date Revised: 05/03/12
Changes – in blue

- b) Bison Stew Meat – Bison stew meat shall be prepared from fresh bison cuts and trimmings from any portion of the carcass, which yields product that meets the end-item requirements for IMPS Item 135A.

2. MATERIAL

- a) The contractor's production plan must describe a process that includes procedures, records, forms, etc. that demonstrate conformance with the following Checklist of Requirements and have received a satisfactory onsite capability assessment by the GVD.
- b) The contractor will ensure, through their production plan, that the product complies with the MATERIAL section of IMPS Item No. 136 for ground bison, IMPS Item No. 135A for bison stew meat, and the following additional criteria:
- 1) Domestic Origin – All bison will originate from U.S. produced livestock as defined in this Supplement.
 - 2) Harvest Requirements – Contractor must have documentation and a program in place that verifies the source of raw materials used in each lot of production. All bison will be harvested in facilities that comply with the following additional requirements:
 - (a) Humane Handling – All bison shall be humanely handled in accordance with all applicable FSIS regulations and AMS requirements.
 - (b) Pathogen Intervention – The harvest process must include at least two pathogen intervention steps and must be scientifically validated to achieve a 3 log reduction of enteric pathogens.
 - (c) Carcasses Testing – Routinely test carcasses for Shiga-toxigenic *Escherichia coli* O157 (including O157:H7 and O157:Non-Motile (NM); herein referred to as *E. coli* O157:H7) at CCP to verify effectiveness of interventions.
 - (d) Spinal Cord Removal – All spinal cord tissue shall be removed during the harvesting process.
 - (e) Traceability – Boneless bison shall be traceable to sources that comply with the above domestic origin and harvest requirements.
 - 3) Mechanical Separation – Bison meat that is mechanically separated from bone with automatic deboning systems, advanced meat (lean) recovery (AMR) systems, or powered knives will not be allowed.
 - 4) Fresh Chilled Bison – Prior to processing, boneless bison shall be examined for compliance with IMPS Item No. 136 MATERIAL requirements. Product failing this examination will be rejected.

3. PROCESSING

- a) Ground Bison – Ground bison meat will be processed in accordance with IMPS and the following additional requirements:
- 1) Ground Bison Processing – Ground bison will be processed in accordance with the Processing section of IMPS Item No. 136. Frozen, boneless bison (certified to the material requirements) may be used provided it is ground into the final product within 60 days from date of pack.
 - 2) Bone Collector / Extruder System – A bone collector/extruder system must be in operation on the final grind of product.
- b) Bison Stew Meat – Bison stew meat must comply with the following additional requirements:
- 1) Bison Stew Meat Processing – Bison Stew Meat shall be processed to meet the end item requirements listed within IMPS Item No. 135A.
 - 2) Dicing – The meat shall be either hand-diced or mechanically diced (grinding is not permitted).
 - 3) Handling – To facilitate dicing, meat may be frozen and/or tempered one time only.
 - 4) Shank or Heel Meat – No shank or heel meat is permitted.

4. METAL DETECTION

All products shall be free of metal contaminants. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required. The contractor's production plan must identify and describe the equipment, location, detection procedure, sensitivity levels, frequency of equipment validation, and corrective action procedures.

B. GRADE – Not Applicable

C. STATE OF REFRIGERATION

All finished bison products will be frozen, in accordance with FREEZING OPTION 1. Refer to I. MEAT HANDLING, A. STATE OF REFRIGERATION, and B. PRODUCTION, TEMPERATURE AND TIME LIMITATIONS section of the IMPS General Requirements.

D. FAT LIMITATIONS

1. Ground Bison – The average fat content shall not exceed 10 percent, and the number of grams of fat per 112 gram serving will be declared in the nutritional facts panel on the package label. The fat content will be certified by AMS in accordance with IMPS QAPs. The 4 individual fat results shall be put into ascending order from the lowest to the highest value for evaluation (e.g., 8.30, 9.79, 10.63, and 11.20). The 4 individual fat test results shall be used to calculate average, median and range. Results not meeting the following requirements shall cause rejection of the lot:

- a) Average – The average of the 4 individual results cannot exceed 10 percent (e.g., average of the 4 test results = 9.98).
- b) Median – The median, which is the average of the middle two test results, cannot deviate from the average of the four individual samples by more than 2.0 percent (e.g., median is equal to the average of 9.79 and 10.63 = 10.21).
- c) Range – The difference between the highest and lowest test results cannot exceed 5 percent (e.g., 11.20 – 8.30 = 2.90).

2. Bison Stew Meat – Surface and seam fat will not exceed ¼-inch in thickness at any point.

E. WEIGHT RANGE – Not Applicable

F. NETTING AND TYING – Not Applicable

G. PACKAGING AND PACKING

Refer to II. PACKAGING AND PACKING section of the IMPS General Requirements and the following additional requirements:

1. Packaging – All immediate containers (casings or packages) shall function as a tamper evidence indicator to provide added assurance of product integrity through the method of sealing or closure.
 - a) Package Net Weight – Ground bison and bison stew meat shall be packaged as specified within the Contracting Officer's invitation:
 - 1) 110001 Ground Bison 1-pound
 - 2) 100085 Bison Stew Meat 1-pound
 - b) Package Method – Ground bison and bison stew meat shall be packaged using one of the following methods:
 - 1) Mechanical Packaged – Mechanically packaged into tamper-proof commercial casings.
 - 2) Vacuum Packaged – Vacuum packaged in accordance with the IMPS General requirements.
2. Packing
 - a) Shipping Container Net Weight
 - 1) Ground Bison – Forty (40) 1-pound packages of ground bison shall be packed into non-perforated shipping containers to a net weight of 40 pounds, without slackfilling or overfilling. Spacers or fillers may not be used to satisfy this requirement.

- 2) Bison Stew Meat – **Forty (40) 1-pound packages** of bison stew meat shall be packed into non-perforated shipping containers to a net weight of 40 pounds, without slackfilling or overfilling. Spacers or fillers may not be used to satisfy this requirement.
- b) Style and Size of Container – Only one style and size of shipping containers may be used in any one-delivery unit.
- c) Commingling – Commingling of ground bison and bison stew meat in the same shipping container will not be allowed.
3. Closure – 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.
4. Marking of Containers* – Immediate and shipping containers will be labeled to include all information required by FSIS regulations. In addition, each immediate and shipping container must have the following markings:
 - a) Immediate Container – Each immediate container (package) will have the following information included on commercially labeled packages:
 - 1) Name of Product.
 - 2) Safe Handling Instructions.
 - 3) "Best-if-used-by" Date – A date that is 180 calendar days from the date of production.
 - 4) Traceability Code – A code that is traceable to production lot and date.
 - 5) Nutrition Fact Panel – Include fat declaration for number of grams of fat per **112 gram (ready-to-cook) serving**.
 - 6) FSIS Establishment Number **and any other FSIS required markings**.
 - b) Shipping container – The following markings will be included on the shipping containers:
 - 1) Appendix A – Shipping containers will be marked in accordance with Appendix A. However, contractors may vary the placement of the required information shown in Appendix A. Additional markings (e.g., company bar codes, logos, etc.), that are consistent with all other commercial labels may be included.
 - 2) Traceability Code – A code that is traceable to production lot and date.
 - 3) Nutrition Fact Panel – Include fat declaration for number of grams of fat per **112 gram (ready-to-cook) serving**.

4) The appropriate product code listed in the table below for each of the items.

<u>Item</u>	<u>Material Number</u>
Ground Bison, Frozen – 1-pound	110001
Bison Stew Meat, Frozen – 1-pound	100085

5) Name of Product.

6) USDA Shield (at least 2 inches high and appearing on the top of the container or on the principle display panel).

7) Purchase Order Number.

8) Ingredient declaration (including single ingredient products).

9) 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 _____.

*All primary and shipping container labeling illustrations must be provided within the production plan.

5. Palletized Unit Loads – Required, see IMPS General Requirements.

H. USDA CERTIFICATION

1. Product Will Be Certified By USDA, AMS, **GVD** – AMS agents will perform examinations in accordance with IMPS General Requirements, IMPS QAPS, and **GVD** Instructions and as specified below:

a) Product Examinations

1) Ground Bison – Product examination for excellent condition and detailed item description requirements will be in accordance with QAPS. In TABLE 100 I, delete defect numbers 218 and 219 in their entirety and replace with the following defects:

218 Presence of any portion of the popliteal, prescapular, or prefemoral lymph glands or any other exposed lymph glands measuring 1.0 inch or more in one dimension and 0.5 inch in a second dimension.

219 Presence of non-carcass components or fat from the thoracic, lumbar, pelvic, cod, and /or udder areas of the carcass measuring 2.0 square inches or more and 0.5 inch or more in depth at any point.

Delete defect 294 in its entirety. Insert the following note at the bottom of the table:

Note: The presence of any non-meat components not listed as defects above (e.g., spinal cord, organ tissue, foreign materials, etc.) shall cause rejection of the product by AMS.

- 2) Bison Stew Meat – Refer to LOT ACCEPTANCE CRITERIA section for diced items within QAPS. In TABLE 100 H, delete defect numbers 218 in its entirety. Replace defect number 218 with the following defect:

218 Presence of any portion of the popliteal, prescapular, or prefemoral lymph glands or any other exposed lymph glands measuring 1.0 inch or more in one dimension and 0.5 inch in a second dimension.

Delete defect 194 in its entirety. Insert the following note at the bottom of the table:

Note: The presence of any non-meat components not listed as defects above (e.g., spinal cord, organ tissue, foreign materials, etc.) shall cause rejection of the product by AMS.

- b) Condition of Container – Condition of containers will be examined as follows:
- 1) Production Container Examination – At time of production, randomly scan shipping containers to ensure defective containers are corrected and replaced.
 - 2) Shipping Container Examination – Final examination of condition of shipping containers will be limited to scanning (without destructive sampling) the delivery unit for defects which may have occurred during handling and storage (e.g., crushed, torn, dirty, stained, etc.). All defective containers must be replaced or corrected.
- c) Net Weight – Net weight will be in accordance with the QAPS only.
- d) Fat Content Analysis – Fat content analysis will be in accordance with the QAPS and FAT LIMITATIONS section of this specification.
- e) Traceability Code – Stamping (sealing) of shipping containers by the AMS agent is not required. The AMS agent will ensure that each primary and shipping container has a traceability code that is traceable to a production lot and date.
- f) Temperature Examinations – Temperature will be examined using Freezing Option 1.

2. Lot Size and Purchase Unit:
 - a) Lot Size – For finished product, the lot size will not exceed the amount specified by the purchaser as a purchase unit.
 - b) Purchase Unit Size – The purchase unit size for ground bison and bison stew meat is 40,000 pounds net weight (1,000 shipping containers) plus the amount for use in making box fills at the time of laboratory sample withdrawal.
3. The AMS Agent Will:
 - a) Certify and Issue Certificate – Certify and issue an official certificate indicating the status of each lot as required by GVD Instructions.
 - b) Supervise Loading and Sealing – Supervise the loading and sealing of each truck. All products must be delivered to AMS designated destinations under seal using 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.
4. Official Certificates Shall Include:
 - a) Purchase Order Number and Purchase Order line item number.
 - b) Sales Order Number and Sales Order Item number.
 - c) Name of product.
 - d) Applicable material number.
 - e) Production lot number(s) and the date each lot was produced.
 - f) Count of shipping containers and total projected net weight in each production lot.
 - g) Total projected net weights per delivery unit.
 - h) Identity of conveyance (numbers and letters, seals, license, etc.) as applicable.
 - i) Destination(s).
 - j) Sample average fat content analysis of each production lot for ground bison only (calculated to 2 decimal places, e.g., 8.25).
- I. MICROBIOLOGICAL REQUIREMENTS FOR GROUND BISON
 1. Boneless Bison for Grinding
 - a) Lot – A lot shall consist of a single combo sized bin of approximately 2,000 pounds of boneless bison produced within a day, between “cleanup to cleanup” and that is from a single harvester or from a single processor.

- b) Microbial Testing – All lots of fresh chilled boneless bison must be tested for all microbes listed in Appendix B. All samples will be sent to the AMS designated laboratory (ADL).
- 1) Sample Preparation and Handling - The ADL will be responsible for supplying sampling procedures for sample selection, preparation, and submission. The laboratory shall require suppliers to submit a sample submission form as an official record with each sample. The laboratory will also be responsible for supplying shipping supplies (including sampling bags and shipping materials) to each supplier. Suppliers' [production plan](#) will include and describe sample collection and preparation procedures provided by the AMS accredited laboratory.
 - 2) Sample Selection
 - (i) For Bison Manufacturing Trimmings – The composite sample will be selected as described within FSIS Directive 10,010.1 Revision 3 (N-60 Sections 8, 9 and NOTE).
 - (ii) The composite sample shall [consist of exactly seventy \(70\) pieces of trim from seventy \(70\) different pieces of bison product and shall weigh 400-425 grams.](#)
 - (iii) When boneless bison has been exposed to any anti-microbial treatment, no sample units shall be selected for at least 15 minutes after such treatment.
 - 3) Testing and Results
 - (i) The microbiological testing for all microbes will be in accordance with the [applicable AMS-approved testing methodologies.](#)
 - (ii) Notification for presence of pathogens and exceeding critical limit criteria – When presence of *E. coli* O157:H7 or *Salmonella* is presumptive positive or confirmed positive or any critical limit is exceeded for indicator microbes, the ADL will immediately notify FSIS ([pathogens only](#)) and the [Contracting Officers Technical Representative \(COTR\).](#)
 - (iii) The ADL will record results on spreadsheets for each Microbial Testing performed on each approximately 2,000 pound lot.
 - (iv) Any lot that tests positive for *E. coli* O157:H7 or *Salmonella* or exceeds the critical limit criteria for indicator microbes set forth in Appendix B cannot be used to produce ground bison or any other product purchased by USDA.

- (v) Any lot subjected to microbial analysis by FSIS or other regulatory authority that results in a positive finding for *E. coli* O157:H7 or *Salmonella* or exceeds the critical limit criteria for indicator microbes set forth in Appendix B cannot be used to produce ground bison or any other product purchased by USDA.

2. Ground Bison Microbial Requirements

- a) Lot – For the purpose of microbiological testing, a lot is defined as the amount of finished ground bison product produced **within a day**, between “cleanup to cleanup” which must be further divided into sub-lots not to exceed 10,000 pounds.
- b) Microbiological Testing – All lots of ground bison will be tested for all microbes listed in Appendix B after final grinding and before freezing. All samples will be sent to the ADL.
 - 1) Sample Preparation and Handling – The ADL will be responsible for supplying sampling procedures for sample selection, preparation, and submission. The laboratory shall require suppliers to submit a sample submission form as an official record with each sample. The laboratory will also be responsible for supplying shipping supplies (including sampling bags and shipping materials), to each supplier. Suppliers’ **production plan** will include and describe sample collection and preparation procedures provided by the AMS accredited laboratory.
 - 2) Sample Selection – Production processes of ground bison will be subject to the following sampling strategy:
 - (i) Sub-lot Microbial Testing – For every **sub-lot**, an original and reserve sample of approximately **400** grams will be prepared from **four (4)** individual sample units (approximately **100** grams each) of finished ground bison, **randomly selected throughout each 10,000 pounds of production**. The sample units shall be blended to produce a composite sample that represents each sub-lot. This sample shall be submitted to the ADL for analysis. The reserve sample will be held for testing in case **COTR** deems it necessary. The contractor will describe, in their **production plan**, the approach taken for documenting the amount of ground bison produced for each sub-lot, as well as the method to be used to maintain the identity and traceability of each sub-lot. No more than 10,000 pounds shall be produced during each sub-lot, **except for the last sub-lot produced in the lot may exceed the 10,000 pound limitation by five (5) percent**.
 - 3) Testing and Results – The sample from each sub-lot will be analyzed by the ADL for all microbes listed in Appendix B.
 - (i) The microbiological testing for all microbes will be in accordance with **AMS-approved testing methodologies**.

- (ii) Any sub-lot that tests positive for *E. coli* O157:H7, *Salmonella*, or any critical limit criteria for indicator microbes set forth in Appendix B that is exceeded will result in that sub-lot and adjoining sub-lots (one preceding and one following within “clean up to clean up”) being ineligible for this program or any other USDA purchase program. Additionally, any sub-lot subjected to microbial analysis by FSIS or other regulatory authority that results in a positive finding for *E. coli* O157:H7 or *Salmonella* or exceeds the critical limit criteria for indicator microbes set forth in Appendix B will result in that sub-lot and adjoining sub-lots being ineligible for this program or any other USDA purchase program. Other sub-lots produced within that lot unit will be deemed ineligible for this program unless the contractor can demonstrate a scientific or other data-supported basis for defining the sub-lot(s) relative to test results and why ground bison produced from same source material that resulted in the ineligible determination should not be considered affected by the test results.
- (iii) Notification for presence of pathogens or when critical limit is exceeded –
When presence of *E. coli* O157:H7 or *Salmonella* is presumptive positive or confirmed positive; any critical limit is exceeded for indicator microbes:
- The ADL will immediately notify FSIS (pathogens only) and the COTR.
 - Confirmed Pathogen – The contractor shall conduct a cause and effect analysis to determine the appropriate corrective action necessary to eliminate the probable cause.
 - The ground bison associated with the positive pathogen test results or critical limit is exceeded results will be ineligible for any USDA purchase program.
- (iv) The ADL will record results on spreadsheets for each test performed on each sub-lot.

J. PRODUCT ASSURANCE

1. WARRANTY AND COMPLAINT RESOLUTION

- a) Warranty – The contractor will guarantee that the product complies with all specification requirements, production plan declarations, and provisions set forth in the program announcement.
- b) Complaint Resolution – Customer complaint resolution procedures will be included in the production plan. These procedures will include: a point of contact, investigation steps, intent to cooperate with AMS, and product replacement or monetary compensation. The procedures will be used to resolve product complaints from recipient agencies or AMS.

2. NON-CONFORMING PRODUCT

The contractor must include a plan to ensure that non-conforming product is not delivered under USDA contracts. 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, including vendor notification in writing to the **COTR** of final disposition (e.g., diverted to cooked product or destroyed).

Approved by MEO MEO
Date Issued: 03/01/04
Date Revised: 05/03/12

APPENDIX A

SHIPPING CONTAINER MARKINGS: COMMERCIALY LABELED SHIPPING CONTAINERS SHALL INCLUDE THE INFORMATION SHOWN BELOW. MANUFACTURER'S NAME AND ADDRESS SHALL APPEAR. THE NUTRITION FACTS PANEL, USDA SYMBOL, AND DONATED STATEMENT SHALL BE BLACK, FLAT, WATERFAST, AND NONSMEARING. THE USDA SYMBOL SHALL BE AT LEAST 2.0 INCHES HIGH. ALL OTHER PRINTING OR STENCILING SHALL BE OF A SIZE AND CONTRASTING COLOR TO STAND OUT PROMINENTLY AND COMPLY WITH THE USDA-FSIS REGULATIONS OR STATE REGULATIONS.

	<p>PERISHABLE FROZEN - STORE AT 0°F (-17.8°C) OR</p> <p>Boxes must include Safe Handling instructions in accordance with FSIS Mandatory Safe Handling Statements on Labeling of Raw Meat and Poultry.</p> 	
	 <p>Manufacturer's Name and Address (here or on principle display panel)</p>	
	<p>Product Name Material Number _____</p> <p>Purchase Order No. KEEP FROZEN</p>	<p>DATE PACKED LOT# _____ BOX _____</p> 

NOTES: DATE PACKED SHALL BE THE MONTH, DAY, AND YEAR OF PACKING.

SERIAL **PURCHASE ORDER NUMBER** WILL BE FURNISHED BY USDA.
LOT NO. AND BOX NO. MAY BE PLACED ON THE SAME LINE OR AS SHOWN ABOVE.
BOX NUMBERS SHALL BE SEQUENTIAL.

PER 9 CFR 317.4 & 317.5, PRIOR APPROVED LABELS NEED NOT BE RESUBMITTED. CONTRACTORS THAT DO NOT HAVE APPROVED LABELS ON FILE MUST SUBMIT LABELS IN SKETCH FORM ONLY TO THE APPROPRIATE USDA, FSIS, OR STATE AGENCY.

Approved by MEO MEO
Date Issued: 03/01/04
Date Revised: 05/03/12

APPENDIX B

AMS MICROBIAL REQUIREMENTS FOR BONELESS & GROUND BISON	
Microbial Test	Critical Limits
Standard Plate Count	100,000 cfu / gram
Total Coliforms	1,000 cfu / gram
<i>E. coli</i>	500 cfu / gram
<i>Salmonella</i>	Positive (+) result / 25 grams
<i>E. coli</i> O157:H7	Positive (+) result / 325 grams

Approved by MEO MEO
 Date Issued: 03/01/04
 Date Revised: 05/03/12



APPROVED

**TECHNICAL DATA SUPPLEMENT FOR
FROZEN GROUND BUFFALO AND
BUFFALO STEW MEAT (TDS-BUF-2012)**

Contracting Officer Technical Representative (COTR)
Livestock and Seed Program, Standardization Division
Room 2607 S-Bldg, Phone: (202) 260-8295

Effective: **May 2012**

I. SCOPE

This technical data supplement (TDS) is for use by the United States Department of Agriculture (USDA), Agricultural Marketing Service (AMS), Commodity Procurement Division for the procurement of frozen ground buffalo and buffalo stew meat. For this program, AMS will utilize the Institutional Meat Purchase Specifications (IMPS) descriptions and requirements for ground beef and beef for stewing as specification requirements for the production of ground buffalo and buffalo stew meat, respectively.

II. APPLICABLE DOCUMENTS

The following documents will be incorporated as part of this USDA, TDS-BUF-2012:

- Food Safety and Inspection Service (FSIS) Directive 10,010.1 Revision 3.
- IMPS General Requirements, effective June 1996.
- IMPS For Fresh Beef Products, Series 100, effective March 2010.
- IMPS Quality Assurance Provisions, effective June 1997.
- Grading and Verification Division (GVD) Instruction Manual, Series 600 and 700.

III. ORDERING DATA: TO BE SPECIFIED BY THE PURCHASER

(Section in the IMPS 100 Series) For the purposes of this TDS, references to "Ground Beef" (IMPS Item No. 136) and "Beef for Stewing" (IMPS Item No. 135A) are changed to Ground Buffalo and Buffalo Stew Meat, respectively.

A. ITEMS

1. GROUND BUFFALO AND BUFFALO STEW MEAT

The ground buffalo and buffalo stew meat shall be produced from buffalo harvested in, and the finished product shall be prepared and handled in, an establishment(s) operating under the Voluntary Exotic Animal Inspection Program of the USDA, Food Safety and Inspection Service (FSIS) and must comply with the Sanitation Performance Standards provisions of 9 CFR 416.1-416.6. Buffalo must originate from U.S. produced American buffalo which have been range-fed (animals that have not been finished in confinement or supplemented/finished with grain).

- a) Ground Buffalo - Ground Buffalo shall be produced from fresh buffalo cuts and trimmings from any portion of the carcass, which yields product that meets the end item requirements for IMPS Item 136. Frozen, boneless buffalo (certified to the material requirements) may be used provided it is ground into the final product within 60 days from date of pack.

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Changes – in blue

- b) Buffalo Stew Meat – Buffalo stew meat shall be prepared from fresh buffalo cuts and trimmings from any portion of the carcass, which yields product that meets the end- item requirements for IMPS 135A.

2. MATERIAL

- a) The contractor's production plan must describe a process that includes procedures, records, forms, etc. that demonstrate conformance with the following Checklist of Requirements and have received a satisfactory onsite capability assessment by GVD.
- b) The contractor will ensure, through their production plan, that the product complies with the Material section of IMPS Item No. 136 for ground buffalo and IMPS Item No. 135A for buffalo stew meat, and the following additional criteria:
- 1) Domestic Origin – All buffalo will originate from U.S. produced livestock as defined in this Supplement.
 - 2) Harvest Requirements – Contractor must have documentation and a program in place that verifies the source of raw materials used in each lot of production. All buffalo will be harvested in facilities that comply with the following additional requirements:
 - (a) Humane Handling – All buffalo shall be humanely handled in accordance with all applicable FSIS regulations and AMS requirements.
 - (b) Pathogen Intervention – The harvest process must include at least two pathogen intervention steps and must be scientifically validated to collectively achieve a 3 log reduction of enteric pathogens.
 - (c) Carcasses Testing – Routinely test carcasses for Shiga-toxigenic *Escherichia coli* O157 (including O157:H7 and O157:Non-Motile (NM); herein referred to as *E. coli* O157:H7) at CCP to verify effectiveness of interventions.
 - (d) Spinal Cord Removal – All spinal cord tissue shall be removed during the harvesting process.
 - (e) Traceability – Boneless buffalo shall be traceable to sources that comply with the above domestic origin and harvest requirements.
 - 3) Mechanical Separation – Buffalo meat that is mechanically separated from bone with automatic deboning systems, advanced meat (lean) recovery (AMR) systems or powered knives, will not be allowed.
 - 4) Fresh Chilled Buffalo – Prior to processing, boneless buffalo shall be examined for compliance with IMPS Item No. 136 MATERIAL requirements. Product failing this examination will be rejected.

3. PROCESSING

- a) Ground Buffalo – Ground buffalo will be processed in accordance with IMPS and the following additional requirements:
 - 1) Ground Buffalo Processing – Ground buffalo will be processed in accordance with the Processing section of IMPS Item No. 136. Frozen, boneless buffalo (certified to the material requirements) may be used provided it is ground into the final product within 60 days from date of pack.
 - 2) Bone Collector / Extruder System – A bone collector/extruder system must be in operation on the final grind of product.
- b) Buffalo Stew Meat – Buffalo stew meat must comply with the following additional requirements:
 - 1) Buffalo Stew Meat Processing – Buffalo Stew Meat shall be processed to meet the end item requirements listed within IMPS Item No. 135A.
 - 2) Dicing – The meat shall be either hand-diced or mechanically diced (grinding is not permitted).
 - 3) Handling – To facilitate dicing, meat may be frozen and/or tempered one time only.
 - 4) Shank or Heel Meat – No shank or heel meat is permitted.

4. METAL DETECTION

All products shall be free of metal contaminants. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required. The contractor's production plan must identify and describe the equipment, location, detection procedure, sensitivity levels, frequency of equipment validation, and corrective action procedures.

B. GRADE – Not applicable.

C. STATE OF REFRIGERATION

All finished buffalo products will be frozen, in accordance with FREEZING OPTION 1. Refer to I. MEAT HANDLING, A. STATE OF REFRIGERATION, and B. PRODUCTION, TEMPERATURE AND TIME LIMITATIONS section of the IMPS General Requirements.

D. FAT LIMITATIONS

1. Ground Buffalo - The average fat content shall be less than 10 percent and the number of grams of fat per 112 gram serving will be declared in the nutritional facts panel on the package label. The fat content will be certified by AMS in accordance with IMPS QAPs. The 4 individual fat results shall be put into ascending order from the lowest to the highest value for evaluation (e.g., 8.30, 9.19, 9.63, and 9.80). The 4 individual fat test results shall be used to calculate average, median and range. Results not meeting the following requirements shall cause rejection of the lot:

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Date Issued: 05/01/03
Date Revised: 05/03/12

- a) Average – The average of the 4 individual results cannot exceed 10 percent (e.g., average of the 4 test results =9.23).
- b) Median – The median, which is the average of the middle two test results, cannot deviate from the average of the four individual samples by more than 2.0 percent (e.g., median is equal to the average of 9.19 and 9.63 = 9.41).
- c) Range – The difference between the highest and lowest test results cannot exceed 5 percent (e.g., 9.80 – 8.30 = 1.50).

2. Buffalo Stew Meat – Surface and seam fat will not exceed ¼-inch in thickness at any point.

E. WEIGHT RANGE – Not applicable.

F. NETTING AND TYING – Not applicable.

G. PACKAGING AND PACKING

Refer to II. PACKAGING AND PACKING section of the IMPS General Requirements and the following additional requirements:

1. Packaging – All immediate containers (casings or packages) shall function as a tamper evidence indicator to provide added assurance of product integrity through the method of sealing or closure.
 - a) Package Net Weight – Ground buffalo and buffalo stew meat shall be packaged as specified within the Contracting Officer's invitation:

1) 100090 Ground Buffalo	1-pound
2) 100091 Buffalo Stew Meat	1-pound
 - b) Package Method – Ground buffalo and buffalo stew meat shall be packaged using one of the following methods:
 - 1) Mechanical Packaged – Mechanically packaged into tamper-proof commercial casings.
 - 2) Vacuum Packaged – Vacuum packaged in accordance with the IMPS General requirements.
2. Packing
 - a) Shipping Container Net Weight
 - 1) Ground Buffalo – Forty (40) 1-pound packages of lean ground buffalo shall be packed into non-perforated shipping containers to a net weight of 40pounds, without slackfilling or overfilling. Spacers or fillers may not be used to satisfy this requirement.
 - 2) Buffalo Stew Meat – Forty (40) 1-pound packages of buffalo stew meat shall be packed into non-perforated shipping containers to a net weight of 40 pounds, without slackfilling or overfilling. Spacers or fillers may not be used to satisfy this requirement.

- b) Style and Size of Container – Only one style and size of shipping containers may be used in any one-delivery unit.
 - c) Commingling – Commingling of lean ground buffalo and buffalo stew meat in the same shipping container will not be allowed.
3. Closure - 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.
4. Marking of Containers*– Immediate and shipping containers will be labeled to include all information required by FSIS regulations. In addition, each immediate and shipping container must have the following markings:
- a) Immediate Container – Each immediate container (package) will have the following information included on commercially labeled packages:
 - 1) Name of Product.
 - 2) Safe Handling Instructions.
 - 3) "Best-if-used-by" Date – A date that is 180 calendar days from the date of production.
 - 4) Traceability Code – A code that is traceable to production lot and date.
 - 5) Nutrition Fact Panel – Include fat declaration for number of grams of fat per 112 gram (ready-to-cook) serving.
 - 6) FSIS Establishment Number and any other FSIS required markings.
 - b) Shipping container – The following markings will be included on the shipping containers:
 - 1) Appendix A – Shipping containers will be marked in accordance with Appendix A. However, contractors may vary the placement of the required information shown in Appendix A. Additional markings (e.g., company bar codes, logos, etc.) that are consistent with all other commercial labels may be included.
 - 2) Traceability Code – A code that is traceable to production lot and date.
 - 3) Nutrition Fact Panel – Include fat declaration for number of grams of fat per 112 gram (ready-to-cook) serving.

- 4) The appropriate material number listed in the table below for each of the items.

<u>Item</u>	<u>Material Number</u>
Ground Buffalo, Frozen – 1-pound	100090
Buffalo Stew Meat, Frozen – 1-pound	100091

- 5) Name of Product.
- 6) USDA Shield (at least 2 inches high and appearing on the top of the container or on the principle display panel).
- 7) Purchase Order Number.
- 8) Ingredient declaration (including single ingredient products).
- 9) 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 _____.

*All primary and shipping container labeling illustrations must be provided within the production plan.

5. Palletized Unit Loads – Required, see IMPS General Requirements.

H. USDA CERTIFICATION

1. Product Will Be Certified By USDA, AMS, GVD – AMS agents will perform examinations in accordance with IMPS General Requirements, IMPS QAPS, and GVD Instructions and as specified below:

a) Product Examinations

1) Ground Buffalo – Product examination for excellent condition and detailed item description requirements will be in accordance with QAPS. In TABLE 100 I, delete defect numbers 218 and 219 in their entirety and replace with the following defects:

218 Presence of any portion of the popliteal, prescapular, or prefemoral lymph glands or any other exposed lymph glands measuring 1.0 inch or more in one dimension and 0.5 inch in a second dimension.

219 Presence of non-carcass components or fat from the thoracic, lumbar, pelvic, cod, and /or udder areas of the carcass measuring 2.0 square inches or more and 0.5 inch or more in depth at any point.

Delete defect 294 in its entirety. Insert the following note at the bottom of the table:

Note: The presence of any non-meat components not listed as defects above (e.g., spinal cord, organ tissue, foreign materials, etc.) shall cause rejection of the product by AMS.

- 2) Buffalo Stew Meat – Refer to LOT ACCEPTANCE CRITERIA section for diced items within QAPS. In TABLE 100 H, delete defect number 218 in its entirety. Replace defect number 218 with the following defect:

218 Presence of any portion of the popliteal, prescapular, or prefemoral lymph glands or any other exposed lymph glands measuring 1.0 inch or more in one dimension and 0.5 inch in a second dimension.

Delete defect 194 in its entirety. Insert the following note at the bottom of the table:

Note: The presence of any non-meat components not listed as defects above (e.g., spinal cord, organ tissue, foreign materials, etc.) shall cause rejection of the product by AMS.

- b) Condition of Container – Condition of containers will be examined as follow:
- 1) Production Container Examination – At time of production, randomly scan shipping containers to ensure defective containers are corrected and replaced.
 - 2) Shipping Container Examination – Final examination of condition of shipping containers will be limited to scanning (without destructive sampling) the delivery unit for defects which may have occurred during handling and storage (e.g., crushed, torn, dirty, stained, etc.). All defective containers must be replaced or corrected.
- c) Net Weight – Net weight will be in accordance with the QAPS only.
- d) Fat Content Analysis – Fat content analysis will be in accordance with the QAPS and FAT LIMITATIONS section of this specification.
- e) Traceability Code – Stamping (sealing) of shipping containers by the AMS agent is not required. The AMS agent will ensure that each primary and shipping container has a traceability code that is traceable to a production lot and date.
- f) Temperature Examinations – Temperature will be examined using Freezing Option 1.

2. Lot Size and Purchase Unit:
 - a) Lot Size – For finished product, the lot size will not exceed the amount specified by the purchaser as a purchase unit.
 - b) Purchase Unit Size – The purchase unit size for lean ground buffalo and buffalo stew meat is 40,000 pounds net weight (1,000 shipping containers) plus the amount for use in making box fills at the time of laboratory sample withdrawal.
3. The AMS Agent Will:
 - a) Certify and Issue Certificate – Certify and issue an official certificate indicating the status of each lot as required by GVD Instructions.
 - b) Supervise Loading and Sealing – Supervise the loading and sealing of each truck. All products must be delivered to AMS designated destinations under seal using 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 this Supplement.
4. Official Certificates Shall Include:
 - a) Purchase Order Number and Purchase Order line item number.
 - b) Sales Order Number and Sales Order Item number.
 - c) Name of product.
 - d) Applicable material number.
 - e) Production lot number(s) and the date each lot was produced.
 - f) Count of shipping containers and total projected net weight in each production lot.
 - g) Total projected net weights per delivery unit.
 - h) Identity of conveyance (numbers and letters, seals, license, etc.) as applicable.
 - i) Destination(s).
 - j) Sample average fat content analysis of each production lot for lean ground buffalo only (calculated to 2 decimal places, e.g., 8.25).

I. MICROBIOLOGICAL REQUIREMENTS FOR GROUND BUFFALO

1. Boneless Buffalo for Grinding
 - a) Lot – A lot shall consist of a single combo sized bin of approximately 2,000 pounds of boneless buffalo produced within a day, between “cleanup to cleanup” and that is from a single harvester or from a single processor.

- b) Microbial Testing – All lots of fresh chilled boneless buffalo must be tested for all microbes listed in Appendix B. All samples will be sent to the AMS designated laboratory (ADL).
- 1) Sample Preparation and Handling – The ADL will be responsible for supplying sampling procedures for sample selection, preparation, and submission. The laboratory shall require suppliers to submit a sample submission form as an official record with each sample. The laboratory will also be responsible for supplying shipping supplies (including sampling bags and shipping materials), to each supplier. Suppliers' production plan will include and describe sample collection and preparation procedures provided by the AMS accredited laboratory.
 - 2) Sample Selection
 - (i) For Buffalo Manufacturing Trimmings – The composite sample will be selected as described within FSIS Directive 10,010.1 Revision 3 (N-60 Sections 8, 9 and NOTE).
 - (ii) The composite sample shall **consist of exactly seventy (70) pieces of trim from seventy (70) different pieces of buffalo product and shall weigh 400-425 grams.**
 - (iii) When boneless buffalo has been exposed to any anti-microbial treatment, no sample units shall be selected for at least 15 minutes after such treatment.
 - 3) Testing and Results
 - (i) The microbiological testing for all microbes will be in accordance with the applicable **AMS-approved testing methodologies.**
 - (ii) Notification for presence of pathogens and exceeding critical limit criteria – When presence of *E. coli* O157:H7 or *Salmonella* is presumptive positive or confirmed positive or any critical limit is exceeded for indicator microbes, the ADL will immediately notify FSIS (**pathogens only**) and the **Contracting Officers Technical Representative (COTR).**
 - (iii) The ADL will record results on spreadsheets for each Microbial Testing performed on each approximately 2,000 pound lot.
 - (iv) Any lot that tests positive for *E. coli* O157:H7 or *Salmonella* or exceeds the critical limit criteria for indicator microbes set forth in Appendix B cannot be used to produce ground buffalo or any other product purchased by USDA.
 - (v) Any lot subjected to microbial analysis by FSIS or other regulatory authority that results in a positive finding for *E. coli* O157:H7 or *Salmonella* or exceeds the critical limit criteria for indicator microbes set forth in Appendix B cannot be used to produce ground buffalo or any other product purchased by USDA.

2. Ground Buffalo Microbial Requirements
 - a) Lot – For the purpose of microbiological testing, a lot is defined as the amount of finished ground buffalo product produced **within a day**, between “cleanup to cleanup” which must be further divided into sub-lots not to exceed 10,000 pounds.
 - b) Microbiological Testing – All lots of ground buffalo will be tested for all microbes listed in Appendix B after final grinding and before freezing. All samples will be sent to the ADL.
 - 1) Sample Preparation and Handling – The ADL will be responsible for supplying sampling procedures for sample selection, preparation, and submission. The laboratory shall require suppliers to submit a sample submission form as an official record with each sample. The laboratory will also be responsible for supplying shipping supplies (including sampling bags and shipping materials), to each supplier. Suppliers’ production plan will include and describe sample collection and preparation procedures provided by the AMS accredited laboratory.
 - 2) Sample Selection – Production processes of ground buffalo will be subject to the following sampling strategy:
 - (i) Sub-lot Microbial Testing – For every **sub-lot**, an **original** and reserve sample of approximately **400** grams will be prepared from individual sample units (approximately **100** grams each) of finished ground buffalo, **randomly selected throughout each 10,000 pounds of production**. The four (4) individual sample units shall be blended to produce a composite sample that represents each sub-lot. This sample shall be submitted to the ADL for analysis. The reserve sample will be held for testing in case the **COTR** deems it necessary. The contractor will describe, in their **production plan**, the approach taken for documenting the amount of ground buffalo produced for each sub-lot, as well as the method to be used to maintain the identity and traceability of each sub-lot. No more than 10,000 pounds shall be produced during each sub-lot, **except for the last sub-lot produced in the lot, may exceed the 10,000 pound limitation by five (5) percent**.
 - 3) Testing and Results - The sample from each sub-lot will be analyzed by the ADL for all microbes listed in Appendix B.
 - (i) The microbiological testing for all microbes will be in accordance with the applicable **AMS-approved testing methodologies**.

- (ii) Any sub-lot that tests positive for *E. coli* O157:H7, *Salmonella*, or any critical limit criteria for indicator microbes set forth in Appendix B that is exceeded will result in that sub-lot and adjoining sub-lots (one preceding and one following within “clean up to clean up”) being ineligible for this program or any other USDA purchase program. Additionally, any sub-lot subjected to microbial analysis by FSIS or other regulatory authority that results in a positive finding for *E. coli* O157:H7 or *Salmonella* or exceeds the critical limit criteria for indicator microbes set forth in Appendix B will result in that sub-lot and adjoining sub-lots being ineligible for this program or any other USDA purchase program. Other sub-lots produced within that lot unit will be deemed ineligible for this program unless the contractor can demonstrate a scientific or other data-supported basis for defining the sub-lot(s) relative to test results and why ground buffalo produced from same source material that resulted in the ineligible determination should not be considered affected by the test results.
- (iii) Notification for presence of pathogens or when critical limit is exceeded – When presence of *E. coli* O157:H7 or *Salmonella* is presumptive positive or confirmed positive; any critical limit is exceeded for indicator microbes:
- The ADL will immediately notify FSIS (pathogens only) and the COTR.
 - Confirmed Pathogen – The contractor shall conduct a cause and effect analysis to determine the appropriate corrective action necessary to eliminate the probable cause.
 - The ground buffalo associated with the positive pathogen test results or critical limit exceeded results will be ineligible for any USDA purchase program.
- (iv) The ADL will record results on spreadsheets for each test performed on each Sub-lot.

J. PRODUCT ASSURANCE

1. WARRANTY AND COMPLAINT RESOLUTION

- a) Warranty – The contractor will guarantee that the product complies with all specification requirements, production plan declarations, and provisions set forth in the program announcement.
- b) Complaint Resolution – Customer complaint resolution procedures will be included in the production plan. These procedures will include: a point of contact, investigation steps, intent to cooperate with AMS, and product replacement or monetary compensation. The procedures will be used to resolve product complaints from recipient agencies or AMS.

2. NON-CONFORMING PRODUCT

The contractor must include a plan to ensure that non-conforming product is not delivered under USDA contracts. 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, including vendor notification in writing to the **COTR** of final disposition (e.g., diverted to commercial production, cooked product, or destroyed).

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APPENDIX A

SHIPPING CONTAINER MARKINGS: COMMERCIALY LABELED SHIPPING CONTAINERS SHALL INCLUDE THE INFORMATION SHOWN BELOW. MANUFACTURER'S NAME AND ADDRESS SHALL APPEAR. THE NUTRITION FACTS PANEL, USDA SYMBOL, AND DONATED STATEMENT SHALL BE BLACK, FLAT, WATERFAST, AND NONSMEARING. THE USDA SYMBOL SHALL BE AT LEAST 2.0 INCHES HIGH. ALL OTHER PRINTING OR STENCILING SHALL BE OF A SIZE AND CONTRASTING COLOR TO STAND OUT PROMINENTLY AND COMPLY WITH THE USDA-FSIS REGULATIONS OR STATE REGULATIONS.

	<p>PERISHABLE FROZEN - STORE AT 0°F (-17.8°C) OR BELOW</p> <p>Boxes must include Safe Handling instructions in accordance with FSIS Mandatory Safe Handling Statements on Labeling of Raw Meat and Poultry.</p> 	
	 <p>Manufacturer's Name and Address (here or on principle display panel)</p>	
<p>Product Name Material Number _____</p> <p>Purchase Order No. KEEP FROZEN</p>	<p>DATE PACKED LOT# _____ BOX _____</p>	

NOTES: DATE PACKED SHALL BE THE MONTH, DAY, AND YEAR OF PACKING.

SERIAL PURCHASE ORDER NUMBER WILL BE FURNISHED BY USDA.
LOT NO. AND BOX NO. MAY BE PLACED ON THE SAME LINE OR AS SHOWN ABOVE.
BOX NUMBERS SHALL BE SEQUENTIAL.

PER 9 CFR 317.4 & 317.5, PRIOR APPROVED LABELS NEED NOT BE RESUBMITTED. CONTRACTORS THAT DO NOT HAVE APPROVED LABELS ON FILE MUST SUBMIT LABELS IN SKETCH FORM ONLY TO THE APPROPRIATE USDA, FSIS OR STATE AGENCY.

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APPENDIX B

AMS MICROBIAL REQUIREMENTS FOR BONELESS & GROUND BUFFALO	
Microbial Test	Critical Limits
Standard Plate Count	100,000 cfu / gram
Total Coliforms	1,000 cfu / gram
<i>E. coli</i>	500 cfu / gram
<i>Salmonella</i>	Positive (+) result / 25 grams
<i>E. coli</i> O157:H7	Positive (+) result / 325 grams

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APPROVED

TECHNICAL REQUIREMENTS SCHEDULE – BISON HANDLING AND WELFARE 2010 (TRS-BHW-2010)

Contracting Officer Technical
Representative (COTR) Standards,
Analysis, and Technology Branch
Room 2607 S-Bldg, Phone: (202) 720-
4486

Effective: October 2010

Bison Handling and Welfare

1.0 General

1.1 Program Approach

The contractor and all subcontractors must develop and implement a written program that is consistent with a systematic approach to humane handling and welfare as outlined in 69 FR 54625. The program will discuss the applicable provisions of 9 CFR 352 to ensure proper bison handling and welfare techniques are conducted from the time the transportation conveyance enters the facility's premises through the stunning and exsanguination processes.

1.2 Contracting Officer

The contracting officer can declare a contractor's and/or subcontractor's Bison Handling and Welfare Program out of compliance at any time.

1.3 Program Submission

The program will be submitted as a supporting document to the firm's approved technical proposal and must address the requirements outlined in **Section 2.0 – Program Components**.

2.0 Program Components

The contractor must ensure that any facility that harvests bison for the program has a:

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2.1 Mission Statement

Mission Statement on Bison Handling and Welfare that is distributed to all employees and conspicuously displayed at the premises.

2.2 Training Program^{1, 2, 3}

Training program on Bison Handling and Welfare that:

- is provided to all employees interacting with bison;
- covers Chapter 3: Transportation Audit Guidelines, Core Criteria 1 and 3 of the AMI *Recommended Animal Handling Guidelines and Audit Guide 2010 Edition*;
- covers Chapter 4: Auditing Animal Handling and Stunning 7 Core Criteria of the AMI *Recommended Animal Handling Guidelines and Audit Guide 2010 Edition*;
- is conducted no less frequently than once a year for each designated employee; and,
- requires signed documentation from each employee and confirmation by signature of the designated trainer upon successful completion of training.

2.3 Quality Management Plan^{1, 2, 3}

Written quality management plan (internal) which addresses the provisions of Chapter 3: Transportation Audit Guidelines, Core Criteria 1 and 3, and Chapter 4: Auditing Animal Handling and Stunning, 7 Core Criteria, of the AMI *Recommended Animal Handling Guidelines and Audit Guide 2010 Edition*, found at the following web site:

<http://www.animalhandling.org/ht/d/sp/i/26752/pid/26752>

This internal quality management plan must also provide for routine assessment and monitoring of humane handling through the use of a numerical scoring system conducted by a trained employee.

¹Guidlines and audit criteria specified for cattle in Chapter 4: Auditing Animal Handling and Stunning 7 Core Criteria of the AMI *Recommended Animal Handling Guidelines and Audit Guide 2010 Edition* should be emulated, to the extent possible, for bison.

²Core Criteria 4: Vocalization in Chapter 4: Auditing Animal Handling and Stunning 7 Core Criteria of the AMI *Recommended Animal Handling Guidelines and Audit Guide 2010 Edition* shall be amended to so that vocalization *only* is evaluated at the lead up chute prior to the restrainer with five percent or less vocalization being an acceptable score. Grunting should not be counted.

³Core Criteria 5: Electric Prod Use in Chapter 4: Auditing Animal Handling and Stunning 7 Core Criteria of the AMI *Recommended Animal Handling Guidelines and Audit Guide 2010 Edition* shall be amended to provide for a “zero tolerance” threshold for bison.

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2.4 Non-Ambulatory Bison

Written protocol in-place and enforced that precludes the receipt of or having non-ambulatory, disabled bison on the harvest facility premise. In the event that bison become non-ambulatory or disabled at any time while present at the harvest facility, the bison will be humanely euthanized and the carcass removed from the premise in a timely manner through contracted services or other means.

3.0 Program Evaluation and Eligibility

The program will be audited (external) by a firm accredited by AMS. The accreditation of the firm will be conducted by the Audit, Review and Compliance Branch through the **LS ISO Guide 65 Program**. Alternatively, at the option of the contractor or subcontractor, the audits can be performed by AMS auditors. Audit findings thought to be in conflict with Food Safety and Inspection Service (FSIS) regulations will be communicated to the establishment's Inspector in Charge (IIC) or designee.

3.1 Audit Format

The AMS accredited auditing firm must conduct audits utilizing the following format:

3.1.1 Transportation Segment (*Chapter 3: AMI Recommended Animal Handling Guidelines and Audit Guide 2010 Edition*)

Audited firms must pass Core Criteria 1 with a minimum scoring of excellent and Core Criteria 3 with a minimum scoring of acceptable each time an audit is performed.

3.1.2 Animal Handling and Stunning Segment (*Chapter 4: AMI Recommended Animal Handling Guidelines and Audit Guide 2010 Edition*)

Audited firms must pass Core Criteria 1 through 4 with a minimum scoring of acceptable while Core Criteria 5 and 7 must be adhered to with full compliance (zero tolerance) each time an audit is performed.

3.2 Initial Audit

Initial audit must be performed prior to award of contracts.

3.3 Audit Failure

If an audit is failed for any of the Core Criteria, the firm is not eligible to provide product until such a time that corrective and preventative actions are approved by the Contracting Officer, implemented and proven effective.

3.4 Audit Frequency and Status

- STANDARD - Until four (4) consecutive successfully passed audits are attained, an audit must be conducted within 3 months of the previous audit.
- MONTHLY - If at any time an audit identifies any of the Core Criteria not meeting the pass requirements while in the STANDARD phase, auditing will be required to be conducted on a monthly basis once corrective and preventative actions have been approved by the Contracting Officer, implemented and proven effective. This schedule will be for a period of time until four (4) successive audits are found to meet the pass requirements noted within Chapter 3 (Core Criteria 1 and 3) and Chapter 4 (Core Criteria 1 through 7) of the *AMI Recommended Animal Handling Guidelines and Audit Guide 2010 Edition*; at which time audits shall be conducted on the STANDARD basis.
- If four successfully conducted audits are sequentially completed within a one year period while in STANDARD auditing phase, the facility may move to a SEMI-ANNUAL audit basis.
- SEMI-ANNUAL - Semi-annual audits may continue until such time that a failed audit is reported or a period of greater than six months has elapsed without any audits being performed; at which time the audits must resume as described for STANDARD audits.

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