



## **Agricultural Marketing Service**

### **Commodity Specification**

# **TURKEY TACO FILLING**

**April 2013**

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## **I. GENERAL**

### **A. Product Description**

Frozen fully cooked turkey taco filling (commodity) produced under this Specification will be packaged and packed in the following form as specified in the contract:

Turkey Taco Filling (100119) – Frozen, fully-cooked turkey taco filling, produced from ground turkey (ready-to-cook, non-basted, young turkeys or turkey carcasses and parts) and spices/seasonings. The commodity must be packaged in 3-or 5-pound (1.36 or 2.27-kg) packages to a net weight of 30 pounds (13.61 kg) in each fiberboard shipping container. A purchase unit will consist of 1,300 shipping containers totaling 39,000 pounds (17,690 kg).

### **B. Food Defense Requirements**

Contractors and subcontractors participating in the commodity purchase program must have a documented and operational food defense plan that provides for the security of a plant's production processes and includes the storage and transportation of finished product after production. The plan shall address the following areas: (1) food security plan management; (2) outside and inside security of the production and storage facilities; (3) slaughter and processing, including all raw material sources; (4) shipping and receiving; (5) storage; (6) water and ice supply; (7) mail handling; (8) personnel security; and (9) controlled access to production and storage areas. The food defense plan shall be made available to the United States Department of Agriculture's (USDA) Agricultural Marketing Service (AMS) Auditor immediately upon request. Verification of the Food Defense Program at the processing, storage, and distribution facility will be conducted by the USDA/AMS Auditor.

### **C. Commodity Complaints**

The contractor/producer must immediately report all complaints received on the commodity to the USDA Contracting Officer.

### **D. Humane Handling**

All poultry shall be humanely handled in accordance with all applicable Food Safety and Inspection Service (FSIS) regulations, directives, and notices.

## **II. COMMODITY SPECIFICATION**

### **A. Basic Requirements**

1. Date Processed. The commodity must not be processed more than 90 days prior to the first day of the delivery period.

2. Origin of Turkeys. The commodity must be produced and processed from ready-to-cook turkeys, turkey parts, boneless parts, and meat which were produced, raised, and processed in the United States, its territories or possessions, the Commonwealth of Puerto Rico, or the Trust Territories of the Pacific Islands. If the contractor processes or handles turkey products originating from sources other than the United States, its territories or possessions, the commonwealth of Puerto Rico, or the Trust Territories of the Pacific Islands, the contractor must have an acceptable identification and segregation plan for those turkey products to ensure they are not used in the commodities produced under this specification. This plan must be made available to a representative of the Grading Division, Livestock, Poultry and Seed Program, AMS, USDA (Grader), and the Contracting Officer or agent thereof upon request. The contractor must ensure that both contractor and subcontractor(s) maintain records such as invoices, or production and inventory records evidencing product origin, and make such records available for review by the Grader or other Government official(s).

3. Inspection. Processing operations must comply with the Poultry Products Inspection Regulations (9 CFR part 381), and be under the supervision of a representative of the USDA/ FSIS (Inspector). Inspection for contract and Specification compliance will be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 CFR part 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*) under the supervision of a Grader. The Grader will be responsible for certification of compliance with the requirements of this Specification for chilled turkey carcasses and parts; size-reduced turkey products; ground turkey; processing, formulation, packaging, cooking of the commodity, and packing; turkey taco filling; freezing; labeling and marking; sampling; laboratory results; net weight; and checkloading.

4. FSIS Requirements. The commodity must be produced and processed in a federally (FSIS/USDA) inspected establishment, be accurately marked and/or labeled, and meet all FSIS regulatory requirements, including all microbiological testing requirements, currently in place.

5. Pre-Bid Samples. Production sample preparation will be in accordance with Livestock, Poultry and Seed Program's guidelines. Instructions in the Poultry Grader's Handbook; Section 10; VI. Pre-Bid Sample Certification, will be used to certify the pre-bid samples. Pre-bid samples will be subject to USDA, AMS supervision for formulation and processing procedures only. See additional information regarding pre-bid requirements in Livestock, Poultry and Seed Program's "Source Selection Plan for Turkey Taco Filling (September 2010)." A copy of this document may be obtained from: Director, Food Safety and Commodity Specification Division; USDA/AMS/ Poultry Programs; 1400 Independence Avenue, Room 2628 S, Stop 0254; Washington, DC 20250, telephone: (202) 692-0342, or Agricultural Marketing Specialist, Standards, Promotion and Technology Division; USDA/AMS/ Poultry Programs; 1400 Independence Avenue, Room 2624 S, Stop 0254; Washington, DC 20250, telephone: 202-720-7060.

a. Pre-bid samples, formulation, and production procedures. A pre-bid sample and written documentation of the actual formulation, production procedures, and equipment used (technical proposal) along with nutritional analysis for fat and sodium must be submitted to USDA for review and approval prior to the award of contracts. Nutritional analysis of the pre-bid samples for fat and sodium contents must be performed at a USDA/AMS approved laboratory.

(1) The same formulation, production procedures, and type of equipment must be used by the contractor/processor for the production of the pre-bid sample, as will be used for the commodity. Changes made to the formulation, production procedures, and equipment after commodity processing has begun will require re-submitting samples using the new formulation, procedures, and/or equipment for evaluation and approval along with laboratory analysis results.

(2) The sample and technical proposal will be evaluated in accordance with the standards for evaluation factors as written in Livestock, Poultry and Seed Program's "Source Selection Plan for Turkey Taco Filling."

b. Pre-bid samples. The pre-bid sample will also be evaluated to ensure compliance with the product characteristics found in Section C.7. Table 3.

6. USDA Sampling Option. USDA may select additional product for further inspection or may draw samples for laboratory analyses.

7. Turkey from Other Plants. Turkey carcasses and parts may be transferred or obtained from other plants, provided they: (a) have been processed, handled, and identified in accordance with this Specification, and (b) comply with the non-basted, organoleptic, and other applicable requirements of this Specification as evidenced by USDA certification.

a. Type, class, and specific name of the product, part, boneless part, or meat; date slaughtered or date placed in frozen storage; and the USDA-assigned plant number must be shown on each shipping container.

b. The chilled and/or frozen turkey and turkey carcasses and parts must be maintained at an internal product temperature not higher than 40 °F (4.4 °C) when shipped from the origin plant and when received at the destination plant.

## B. Requirements for Turkey

1. Sources of Meat and Skin. The commodity must be produced from meat (with skin attached or without skin), non-basted carcasses, and parts (no solution or ingredients added).

a. Skin. Skin that is not attached to meat must not be used in the commodity.

b. Chilled. The chilled turkey and bone-in, skin-on must be deboned, and/or skinless boneless turkey parts used in the finished cooked commodity within 7 calendar days after the date of slaughter. Within this 7-day timeframe the ground turkey must be fabricated into the cooked commodity within 72 hours after size reduction.

c. Frozen. Frozen meat (bone-in and skin-on or skinless turkey carcasses and parts, or boneless with attached skin/boneless without attached skin turkey meat) may be used when: (1) produced from freshly slaughtered turkeys; (2) packaged to protect against quality deterioration during frozen storage and identified so the time in storage and the class, kind, and specific deboned turkey product can be determined; (3) held not more than 180 days in frozen storage; and (4) the

product shows no evidence of thawing and refreezing or freezer deterioration. After tempering, the meat must be used to produce the finished cooked commodity within 48 hours. The temperature of the meat must not exceed 40 °F (4.4 °C) during the tempering process.

d. Limitations. Other than the final freezing process for finished, packaged commodity (II.D.9.), the commodity must not be derived from turkey meat (carcasses, parts, or ground turkey) that has been frozen more than one time. For example: if the finished commodity is produced from frozen carcasses, parts, deboned meat (II.B.1.c.) or frozen ground turkey (II.D.1.a.(2)), prior to producing the finished commodity, re-freezing of this meat is not allowed. The meat must be tempered and continuously processed into the finished product.

2. Maximum Temperature. The temperature of the carcasses, bone-in or boneless parts, and skin must not exceed 55 °F (12.8 °C) at any time during preparation or processing into ground turkey.

3. Cooling. Carcasses and bone-in or boneless parts which are not used in the ground turkey on a continuous basis must be cooled by methods or media to ensure that the internal product temperature is continuously lowered to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C).

4. Cooling Medium.

a. Cooling methods and media (e.g., use of liquid carbon dioxide (CO<sub>2</sub>), dry ice or liquid nitrogen (N<sub>2</sub>)) may be used to maintain the temperature of meat and parts.

b. Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat or parts must not be incorporated into the ground turkey. Liquid associated with normal product purge is acceptable.

5. Neck and Crop Skin. Neck and crop skin cannot be used in ground turkey.

6. Requirements for Desinewing. The long bone (tibiotarsus) must be removed from the drumsticks (with or without attached skin) prior to processing through a desinewer to remove the tendons.

7. Organoleptic Requirements and Defects.

a. Organoleptic requirements. Meat, boneless parts, deboned drumsticks, and parts (bone-in) will be examined on a continuous basis for the organoleptic requirements listed in Table 1. Any product that does not comply with the organoleptic requirements will be rejected for use under this Specification.

b. Defects.

(1) A sample of 30 pieces of meat, boneless parts, deboned drumsticks, and parts (bone-in) will be examined for the defects listed in Table 1 before formulation or size reduction. The frequency of sampling and the number of defects allowed will be those outlined in Livestock, Poultry and Seed Program's Sample Plan Level 1 (SPL-1). If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

(2) If simultaneous size-reduction and bone removal systems are to be used, boneless parts and deboned drumsticks shall be examined for the applicable defects listed in Table 1 except for the presence of bone or bone-like material, hard tendinous material, or cartilage (gristle).



**Table 1. Organoleptic Requirements and Defects for Meat and Skin**

	<b>Criteria</b>
<b>Organoleptic Requirements:</b>	Must be free from rancidity; free of fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, chlorine-like, or other off or foreign odors; free of foreign materials (e.g., glass, paper, rubber, metal, plastic); must show no evidence of mishandling or deterioration; and must have a bright color with no evidence of dehydration or thawing and refreezing.
<b>All Meat and Parts (With Skin Attached or Without Skin):</b>	<b>Defects</b>
	<p><b>A flesh bruise</b> on meat or on a part that exceeds an area equivalent to the area of a circle with a diameter of 0.75 inch (1.91 cm).</p> <p><b>Large blood clots</b> on the meat or on a part that exceed an area equivalent to the area of a circle with a diameter of 0.25 inch (0.64 cm).</p> <p><b>Skin</b> that is not attached to the meat.</p> <p><b>A defect for discolorations</b> in the meat or skin is when the area of all discolorations, that are moderate in intensity, exceeds an area equivalent to the area of a circle with a diameter of 1.50 inch (3.81 cm).</p>
<b>Bone-In Parts (With Skin Attached or Without Skin):</b>	<b>More than one-third of the meat</b> is missing on a bone-in part.
<b>Boneless Drumstick Meat (With Skin Attached or Without Skin):</b>	<b>Bone</b> or bone-like material, except that the knuckle bone (patella) may be present.
<b>Other Boneless Meat (With Skin Attached or Without Skin):</b>	<p><b>Bone</b> or bone-like material, hard tendon or tendinous material, or cartilage (gristle).</p> <p><b>A boneless thigh</b> with more than one-half of the meat missing.</p>

C. Formulation and Processing Requirements for Ground Turkey

1. Formulas. Ground turkey must be formulated according to one of the following two formulas:

a. Meat and skin basis. Formula is based on deboned meat (with skin attached or without skin) or boneless parts. The maximum amount that can be used in a formula is specified when applicable.

(1) White meat (with skin attached or without skin). The maximum amount of white meat (with or without attached skin) that can be used in a formula is 30 percent of the total weight of the formula. The white meat may be wing meat or scapula portion. Other white meat trimmed from the frames (white frame meat) may be used. White frame meat is limited to no more than 3 percent of the total weight of the formula.

(2) Dark meat (with skin attached or without skin). Boneless thighs or boneless and skinless thighs (not more than one-half of meat missing) or desinewed drumstick meat may be used. Dark meat trimmed from the frame (dark frame meat) may be used. Dark frame meat is limited to no more than 2 percent of the total weight of the formula.

b. Bone-in basis. Formula is based on bone-in parts (with or without attached skin). The maximum amount of a specific part that can be used in a formula is specified when applicable. These parts are for preparation of ground turkey by mechanically removing the meat and skin directly from the parts and simultaneously reducing the size of the meat and skin (mechanical and simultaneous reduction process).

(1) Drumsticks/Thighs. Drumsticks and/or thighs may be used.

(2) Wings. Wings may be whole wings, the first portions, or attached first and second portions. Wing tips can only be used when they are part of a whole wing. The maximum amount of wings or wing portions that can be used in a formula is 40 percent of the total weight of the formula.

2. Skin. Skin that is attached to the chilled or frozen meat or parts may be formulated according to II.C.1. in natural proportion only. Chilled or frozen skin that is not attached to the meat must not be used in the commodity.

3. Processing and Size Reduction.

a. Processing. The meat (with skin attached or without skin) must be processed and blended, as applicable, and reduced in size by equipment and procedures that produce a uniform blend of meat and skin with muscle fibers and strand-like texture, and having the functional properties of ground turkey.

b. Size reduction. Meat (with skin attached or without skin) for the ground turkey must be reduced in size by one of the following procedures:

(1) Ground through a plate with holes 0.125 inch (1/8 inch) (3.175 mm) in diameter;

(2) Desinewed or reduced through a desinewer plate or screen with holes 0.0591 inch to 0.0787 inch (1.5 mm to 2.0 mm) in diameter or as required to ensure equivalent removal of tendons present in the meat;

(3) Reduced through a head consisting of a series of screen plates with rectangular-like openings that measure: (a) 0.018 to 0.020 inch by 0.765 to 0.831 inch and (b) 0.018 to 0.020 inch by 0.255 to 0.302 inch. (Measurement of the rectangular-like openings in metric units: (a) 0.4572 to 0.5080 mm by 19.4310 to 21.1074 mm and (b) 0.4572 to 0.5080 mm by 6.4770 to 7.6708 mm). The screen plates with the smaller openings will be positioned at the exit end of the auger and the number of these screen plates cannot be more than 12 percent of the total number of screen plates in the head; or

(4) Ground through a plate with holes 2 inches (5.08 cm) in diameter followed by size reduction through a stainless steel cylinder or screen with a series of round openings which divide the surface into thirds. Two-thirds (2/3) of the surface will have openings which measure 0.050 inch (1.27 mm). The exit end (the final 1/3) of the surface will be blank (no openings).

For mechanical removal and simultaneous reduction process, the contractor must give the Grader the model of the machine, the size of the cylinder screen or screen plates, the number of each size, and the sequence of the screen plates that will be used to produce size-reduced meat and skin for use under this Specification. In addition, the contractor must have established control procedures to ensure the cylinder screen or screen plates are in the correct position, the screen plates are in the correct sequence, and that the cylinder screen or screen plates and the auger are aligned and maintained in an operating condition that will continuously produce a product which complies with the texture criteria and other requirements of this Specification. These control procedures must be reviewed and found acceptable by supervisory personnel of the Grading Division, Livestock, Poultry and Seed Program, AMS, USDA, before size-reduced meat and skin can be used as ground turkey under this Specification.

c. Size reduction equipment. Any bent, broken, or defective blade, cylinder, screen, or plate must be replaced before the size reduction equipment can be used for reducing meat and skin.

d. Unacceptable size-reduced products. Meat and skin which cannot be used in the ground turkey: (1) comminuted meat; (2) any skin that is not attached to the meat; (3) meat (with skin attached or without skin) reduced to an emulsified or pasty consistency; or (4) meat (with skin attached or without skin) which developed a discoloration during size-reduction process.

4. Cooling Size-Reduced Turkey. Cooling methods and media (e.g., liquid CO<sub>2</sub>/dry-ice or liquid N<sub>2</sub>) may be used before, during, or after size reduction. Ice or ice water may not be used to lower the temperature of the ground product.

5. Temperature of Size-Reduced Turkey. Temperature of ground turkey or any size-reduced component of the product (ground, desinewed, or mechanically reduced meat and skin) hereinafter referred to as “ground turkey / ground product” must not exceed 55 °F (12.8 °C).

6. Organoleptic Requirements and Defects.

a. Organoleptic requirements. The ground turkey will be examined on a continuous basis for the organoleptic requirements listed in Table 2. Any ground turkey that does not comply with the organoleptic requirements will be rejected for use under this Specification.

b. Defects. A 5-pound (2.27-kg) sample of ground turkey will be examined for the defects listed in Table 2 prior to formulating into the commodity. The defect requirements will be examined in the fresh state.

(1) The examination for bone will be made separately from the examination for other defects.

(2) Regardless of the kind and number of defects (within Table 2) found, any sample containing bone and bone-like material will be cause for rejection of the product the sample represents.

(3) The frequency of sampling and the number of defects allowed will be those outlined in Livestock, Poultry and Seed Program’s Sample Plan Level 2 (SPL-2).

(4) If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents will be rejected.

**Table 2. Organoleptic Requirements and Defects for Ground Turkey**

<b>Organoleptic Requirements:</b>	<b>Criteria</b>
	Must have: (1) muscle fibers and a strand-like texture and (2) a uniform light and bright color with no discolorations or dehydration.
	Must not have: (1) the texture of comminuted meat and skin, (2) a gritty texture, or (3) an emulsified or pasty consistency.
	Must be free of: (1) rancidity; (2) sour, stale, fruity, sulfide-like, cardboardy, tallowy, oily, oxidized, metallic, acidic, or other off or foreign odors; and (3) foreign materials (e.g., glass, paper, rubber, metal, plastic, wood).
<b>Bone:</b>	<b>Defects</b>
	Bone or bone-like material.
<b>Other:</b>	Tendons, cartilage (gristle), and tendinous or ligamentous material that exceeds 0.50 inch (1.27 cm) in any dimension.

7. Ground Turkey Rework.

a. Eligible Product. Ground turkey may be reworked provided: (1) the temperature of the ground turkey has not exceeded 55 °F (10 °C) and has been maintained at that temperature or lower, (2) it complies with organoleptic requirements of II.C.6., and (3) it is incorporated into batches of ground turkey within 12 hours.

b. Time and temperature requirements. Additionally, ground turkey which has been chilled to no higher than 40 °F (4.4 °C) or lower than 26 °F (-3.3 °C), packaged, and maintained at

a product temperature of not higher than 40 °F (4.4 °C) or lower than 26 °F (-3.3 °C) may be reworked within 72 hours from the end of the shift it was produced. When the chilled ground turkey is reworked, the temperature of the commodity must not exceed 40 °F (4.4 °C) during tempering.

8. Freezing Ground Turkey. If the ground turkey is frozen prior to being processed into the finished commodity, the ground turkey must be packaged and/or packed (to protect against quality deterioration), and continuously lowered to an internal temperature of 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If any sample of packaged ground turkey does not comply with the freezing requirements, the product or lot the sample represents will be rejected for use under this Specification.

#### D. Processing Ground Turkey into Commodity

##### 1. Prerequisites for Use of Ground Turkey.

a. Temperature. Ground turkey that does not comply with the temperature requirements of this section will be rejected for use under this Specification.

(1) The internal product temperature of ground turkey must be not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) before it is processed into the commodity and will be determined just before it is formulated and mixed with spices and flavorings. Unless otherwise specified, chilled ground turkey must be fabricated into the cooked commodity within 72 hours after grinding.

(2) Frozen ground turkey may be used when: (a) packaged to protect against quality deterioration during storage and identified so the time in storage can be determined; (b) held not more than 60 days in frozen storage if produced from freshly slaughtered turkey carcasses, and parts; (c) the product shows no evidence of thawing and refreezing or freezer deterioration; and (d) the product temperature is not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) during tempering or prior to processing into the commodity. After tempering, the ground turkey must be used in the production of commodity within 36 hours.

(3) Other than the final freezing process for finished, packaged commodity (II.D.9.), the commodity must not be derived from turkey meat (carcasses, parts, deboned meat or ground turkey) that has been frozen more than one time. Also see II.B.1.c.

b. Ground turkey from other plants. Ground turkey may be transferred or obtained from other plants to produce the commodity, provided it is: (1) processed, handled, and identified in accordance with this Specification and meets the temperature requirements outlined in II.D.1.a., and (2) processed from turkey carcasses and parts which comply with the non-basted, organoleptic, and other applicable requirements of this Specification for turkey as evidenced by USDA certification.

(1) Type, class, specific name of the product, date slaughtered or placed in frozen storage, and the USDA-assigned plant number must be shown on each shipping container of ground turkey.

(2) The chilled and/or frozen ground turkey must be maintained at an internal product temperature not higher than 40 °F (4.4 °C) when shipped from the origin plant and when received at the destination plant.

2. Processing Sequence. Commodity processing must follow the sequence stated within this paragraph (II.D.2.). Unless otherwise specified, ground turkey processing, turkey taco formulation, mixing, packaging then cooking or cooking then packaging (or other packaging/cooking alternative), chilling, and freezing of the commodity must be a continuous process that complies with the time and temperature requirements of this Specification. Formulation and mixing may be accomplished during the cooking processes.

3. Formulation. Proportions of ingredients required in preparing the commodities are as follows:

<u>Ingredients</u>	<u>Percentage</u>
Ground Turkey (minimum)	74.00
Water (maximum)	14.00
Spices/Flavorings / Other Ingredients Formulation (Range)	4.00 – 6.00
Soy Protein (maximum percent of total formula)	<u>6.00</u>
<b>Must Total</b>	100.00

a. “Other ingredients” may include potassium phosphate. Spices/seasonings must be the types used in conjunction with mild turkey taco seasoning. The sodium content of the cooked turkey taco filling must be equal to or lower than 310 mg per 100 g.

b. Soy protein (in a dry form, not hydrated) used in the spices/seasonings/other ingredients formulation must not exceed 6 percent of the total formula. The contractor must furnish the Grader a statement by the manufacturer certifying the spices, seasonings, and other ingredients are in compliance with this Specification prior to production.

c. Processing aids (e.g., anti-caking agents, anti-dusting agents, or other manufacturing aids) are allowed. If processing agents are used, the ingredients and amount of ingredients listed in the formulation (II.D.3.) must remain the same.

4. Mixing. A uniform blend of ground turkey, water, and spices/seasonings must be achieved by mechanically mixing all ingredients prior to packaging.

5. Cooking.

a. Formulated raw commodity must be cooked prior to or after packaging (or other packaging/cooking alternative) in accordance with the processing sequence provided in II.D.2.

b. The commodity must reach an internal temperature of at least 165 °F (73.9 °C) during cooking. The temperature of cooking must provide cooked commodity that complies with II.D.8. Cooking methods and product temperature will be monitored by FSIS personnel.

6. Packaging and Packing. All packaging materials must be clean and in new condition, must not impart objectionable odors or flavors to the commodity, must be safe (not adulterated or injurious to health) for use in contact with food products, and must be tamper-evident. Tamper-evident is defined as packaging materials with one or more indicators or barriers to entry, which, if breached or missing, can reasonably be expected to provide visible evidence that tampering has occurred.

a. Packaging materials. The commodity must be packaged in plastic-film bags. The bags must be made of water-proof film with oxygen barrier properties with a wall thickness of not less than 4 mil (0.004 inch). The bags must have the capability of being boiled and steamed during or after cooking, and freezing the commodity as required within this Specification; and must protect the commodity from contamination, dehydration, freezer burn, or quality deterioration during the conditions of use.

b. Packaging. Approximately 3 or 5 pounds (1.36 or 2.27 kg) of commodity must be packaged into a plastic-film bag and sealed. The bag must be of a width and length to accommodate proper space for filling and reheating. The bag must be sealed to protect the commodity from contamination, dehydration, and freezer burn. Metal clips, wire ties, paper-coated wire ties, and staples must not be used for sealing bags. The bag and seal must be of a design and structure to remain intact (sealed) and prevent leaking when the commodity is reheated (by recipient) in a boiling water bath.

c. Shipping containers. Shipping containers must: (1) be good commercial fiberboard containers that are acceptable by common or other carrier for safe transport to point of destination; (2) be of such size to pack the commodity without slack filling or bulging; (3) withstand the stresses of handling, shipping, stacking, and storage; and (4) be closed by commercially accepted methods and materials. Steel or wire straps must not be used for final closure. Staples must not be used for final closure of shipping containers. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. Staples may be used to manufacture and to assemble the fiberboard shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.

d. Packing. Ten 3-pound (1.36-kg) or six 5-pound (2.27-kg) packages of commodity must be packed in each fiberboard shipping container to 30 pounds (13.61 kg) net weight.

7. Organoleptic Requirements and Product Characteristics.

a. After packaging, a package of commodity will be sampled and examined for organoleptic requirements. If any sample does not comply with the organoleptic requirements, the product the sample represents will be rejected for use under this Specification. Additionally, the commodity will be evaluated for the product characteristics (defects) shown in Table 3. The frequency of sampling and the defects allowed will be in accordance with those outlined in Livestock, Poultry and Seed Program’s SPL-2.

b. Production samples will also be evaluated, reviewed, and compared to a pre-bid sample (II.A.5.) to ensure compliance with the product characteristics found in Table 3 by USDA, AMS, Livestock, Poultry and Seed Program, Grading Division supervisory personnel. The frequency of production sample review will be in accordance with Livestock, Poultry and Seed Program’s “Sampling Requirements and Procedures for Turkey Taco Filling.”

**Table 3. Organoleptic Requirements and Product Characteristics for Cooked Commodity**

	<b>Criteria</b>
<b>Organoleptic Requirements:</b> Examined after packaging	<b>The commodity must be free of:</b> (a) rancidity; (b) metallic, overcooked, burnt, scorched, bitter, oxidized, stale, fruity, beany, oily, soapy, or other flavors or odors foreign to properly prepared and cooked turkey taco filling; and (c) foreign materials (e.g., glass, paper, rubber, plastic, metal).
<b>Product Characteristics:</b> Examined after packaging	<b>Must have the:</b> texture, appearance, color, and flavor of properly prepared cooked turkey taco filling (i.e., similar to cooked ground beef in taco seasoned sauce). See the current “sample prototype” product packaging characteristics written in Poultry Programs’ “Source Selection Plan for Turkey Taco Filling,” for additional requirements/information.
<b>Texture:</b>	<b>Must have:</b> moist, crumbled appearance and mouth feel, and be slightly firm, yet easy to chew.
<b>Appearance:</b>	<b>Must have:</b> distinct crumbled particles that do not stick/clump together, remain in large masses (retain package shape), or require that the commodity be physically separated with a fork or other utensil.
<b>Color:</b>	<b>Must have:</b> the color typical of similarly formulated and cooked meat products, not burnt, scorched, or under cooked.
<b>Flavor:</b>	<b>Must have:</b> a mild turkey taco-seasoned flavor that is not hot or spicy, not salty, not greasy, and does not have a prominent tomato flavor.

8. Reprocessing Cooked Commodity. Cooked and packaged commodity which does not meet the Specification requirements may be reprocessed provided the: (a) product is reprocessed within 8 hours from the time of cooking; (b) temperature of the cooked commodity has been lowered to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) if the product is held



for longer than 8 hours; and (c) commodity is incorporated into raw formulated commodity (at a maximum of 5 percent of the formulated batch), packaged, cooked, and placed in a freezer within 48 hours of packing.

9. Freezing. Immediately after cooking, the product must be placed under refrigeration where the internal product temperature of the cooked packaged commodity is continuously lowered. The commodity must be packed and placed in a freezer within 48 hours of packing. The internal temperature of the packaged and packed commodity must be continuously lowered to 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If any sample of the commodity does not comply with the freezing requirements, the product or lot the samples represent will not be accepted for use under this Specification.

10. Metal Detection. The commodity must be examined by a metal detection device capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips, metal fragments from cutting equipment, and pieces of wire. The commodity must be examined after it is packaged or packed in shipping containers in accordance with the procedures in AMS 910, Poultry Grader's Handbook. Commodity found to be contaminated with metal will be handled in accordance with FSIS procedures. Other procedures for examination of the commodity may be approved by the Deputy Administrator of Livestock, Poultry and Seed Program, in writing.

#### E. Fat and Sodium Requirements for Turkey Taco Filling

A lot or subplot (as defined in II.F.1. and II.F.2.) of turkey taco filling (commodity) must contain no more than an average of 11.0 percent fat as evidenced by laboratory analysis. Sodium content must not exceed 310 mg per 100 grams and may be tested at the option of the Contracting Officer.

#### F. Lots and Sublot

##### 1. Definition of a Lot.

a. A lot is the amount of commodity (turkey taco filling) produced during a processing shift.

b. The commodity will be: (1) sampled for laboratory analysis and analyzed for compliance with fat content requirements, and (2) accepted or rejected on a lot basis.

##### 2. Definition of a Sublot.

a. A lot may be separated into sublots for the purpose of sampling and analyzing for compliance with the fat content requirements. If this option is used, the commodity must be sublotted on the basis of consecutively produced: (1) shipping containers or (2) pallets. The sublots of containers or pallets must be consecutively identified prior to formulation.

b. Commodity sampled and analyzed on the basis of subplot will be accepted or rejected on a subplot basis.

## G. Sampling and Laboratory Analyses

### 1. Sampling.

a. A lot. The number of containers of commodity to be drawn from each lot will be as follows:

<u>Number of Shipping Containers in Lot</u>	<u>Minimum Number of Packages</u>
250 or less	8
251 - 500	12
501 - 1000	16
1,001 - 2,000	24
over 2,000	36

b. A subplot. A minimum of four (4) containers will be drawn from each subplot. The total number of containers drawn from each subplot must be a multiple of four. The total number of containers drawn from all sublots in a lot must equal or exceed those specified for the appropriate size lot described in paragraph G.1.a.

### 2. Samples for Laboratory Analyses.

a. The Grader will randomly draw samples for fat content analysis from each lot or subplot and prepare samples as follows: The Grader will draw a 9-ounce (255-g) sample of turkey taco filling at random from each sample package and separate it into three (approximately equal) sample portions. The remaining commodity may be reprocessed in accordance with II.D.9.

b. Each portion will be placed in a moisture-proof sample bag or a leak-proof cup.

c. The three portions of each sample will be used as follows:

(1) one for fat analysis at a USDA or USDA-approved laboratory.

(2) one for the contractor.

(3) one for a reserve sample.

d. Samples will be kept in a freezer under the Grader's control until all samples are drawn and prepared for the lot or subplot.

(1) The reserve samples will be retained in a freezer under the control of the Grader. Reserve samples will be used for laboratory analyses when: (a) the original samples are lost; (b) the original samples arrive at the USDA-approved laboratory in a condition that does not permit accurate analyses; or (c) requested by the Grading Division, Livestock, Poultry and Seed Program, AMS, USDA, Washington, D.C.

(2) The samples for the contractor will be given to the contractor after the lot or subplot has been produced and all the samples for the lot or subplot have been drawn and prepared.

e. Samples which are not used by USDA will be returned to the contractor and may be reprocessed in accordance with II.D.9.

3. Laboratory Analyses.

a. The USDA or USDA-approved laboratory will equally combine the samples submitted for a lot or subplot in numerical sequence into four composite samples.

b. The USDA or USDA-approved laboratory will grind and mix each composite sample twice into a homogeneous mixture.

c. Each composite will be analyzed in duplicate for fat. The USDA or USDA-approved laboratory will report the result for each duplicate to the nearest 100<sup>th</sup> of a percent and the average for each composite to the nearest 100<sup>th</sup> of a percent on the USDA certificate. In addition, the USDA or USDA-approved laboratory will average the results of the composites and report the average for the lot or subplot to the nearest 10<sup>th</sup> of a percent on the USDA certificate, except when the average result for any one composite exceeds 11.0 percent. As an alternative to reporting the results on the USDA certificate, the results may be reported on a laboratory generated (Laboratory Information Management System (LIMS)) laboratory testing report, which will contain the USDA certificate number, that may be faxed to recipients.

d. Chemical analyses will be in accordance with any approved Association of Official Analytical Chemists (AOAC) International methods, or methods approved by other National or International organizations and accepted by AMS for fat determinations.

4. USDA Laboratory. The samples for laboratory analyses may be submitted to the USDA or USDA-approved laboratory listed below. All costs incurred for shipping the samples and the laboratory analyses will be paid by the contractor.

USDA, AMS, Science and Technology Programs  
National Sciences Laboratory  
801 Summit Crossing Place, Suite B  
Gastonia, North Carolina 28054  
Telephone: (704) 867-3873

5. Timely Receipt of Laboratory Results. The contractor must present the turkey taco filling to USDA so the product may be sampled, the samples sent to the USDA or USDA-approved laboratory, and the laboratory analyses performed in time for the laboratory results to be available for the contractor to meet the shipment or delivery requirements of the contract. If laboratory results are received by the contractor later than 7 calendar days, excluding Sundays and Federal holidays, from the receipt of the samples by the USDA or USDA-approved laboratory, the number

of days' delay will be added to the shipment or delivery period before liquidated damages for late shipment or delivery will be assessed.

6. Appeal of Laboratory Analyses. An appeal of original laboratory analyses for a lot or subplot may be authorized by the Grading Division, Livestock, Poultry and Seed Program, AMS, USDA, Washington, D.C. The appeal must be filed and made in accordance with the provisions for an appeal in 7 CFR part 70. Only one appeal per lot or subplot is permitted.

a. For the appeal, a lot or subplot will be sampled and samples prepared by one of the following procedures:

(1) When the reserve samples are available, the Grader will randomly draw from the lot or subplot the same number of samples as drawn during original sampling and prepare the samples as outlined in paragraphs II.G.1. and II.G.2. These samples, plus the reserve samples previously prepared during the original sampling of the lot or subplot, will be submitted for fat analyses.

(2) When the reserve samples are not available, the Grader will randomly draw twice the number of samples required in paragraph II.G.1. from the lot or subplot. Samples will be prepared as outlined in paragraph II.G.2. and submitted for fat analysis.

b. The samples for the appeal will be submitted to the USDA or USDA-approved laboratory where the original fat analyses were performed.

c. The USDA or USDA-approved laboratory will combine the samples into twice the number of composites described in paragraph II.G.3.c. and analyze each of the composite samples for fat content. The results will be reported as outlined in paragraph II.G.3.c.

d. The laboratory results of the samples for the appeal will supersede those of the original analyses and will be final.

#### H. Contractor Analysis of Fat Content Program

As an alternative method of sampling and laboratory analyses detailed in section II.G., the contractor may elect to participate in the Contractor Analysis of Fat Content (CAFC) Program dated August 2001. AMS has developed this program to permit the use of contractor results to determine compliance with fat content requirements. Any questions about this program should be referred to the National Supervisor of Poultry at the following address:

National Supervisor of Poultry, Grading Division  
Livestock, Poultry and Seed Program, AMS, U.S. Department of Agriculture  
Rm. 3940, South Bldg., STOP 0258  
1400 Independence Avenue, SW  
Washington, D.C. 20250  
Telephone: (202) 690-3166 Fax: (202) 690-3165

The National Supervisor of Poultry will provide the procedures for participation in the CAFC Program. The contractor must comply with the: (a) requirements in this Specification (excluding section II.G.), and (b) alternate sampling procedures, lab analyses, and other provisions of the CAFC Program.

### **III. LABELING**

Commercial labeling (III.A.) or USDA labeling (III.B.) must be used. When commercial or USDA labeling is selected, both the packages and shipping containers within a purchase unit must be labeled in that format. The contractor must use the same label format (either commercial or USDA) within a purchase unit.

#### **A. Commercial Labeling Requirements**

Commercially labeled packages and shipping containers must be labeled in accordance with FSIS requirements. Labeling must be approved by FSIS prior to acceptance for use under this Specification.

1. Commercial Labels. Commercial labels must be the processor's own commercial labels. Distributors' labels will not be allowed.

2. Traceable Product. The processor must establish a product identification and record system that clearly links product by place and time of manufacture to specific USDA contracts and destinations. When the company uses the same commercial label for the product certified as complying with this Specification and commercial product, the identification system must differentiate between USDA and commercial products. An alpha numeric code may be used for information that is in addition to FSIS labeling requirements. The required product identification and record system, including codes, must be reviewed by USDA, AMS, Livestock, Poultry and Seed Program before production begins for the contract(s).

3. Nutrition Facts, Ingredients and Allergen statements on shipping containers. Nutrition Facts must be provided. The ingredient statement, even for single ingredient foods, must be included as a statement separate from the name of the product, e.g. Ingredients: \_\_\_\_\_. The allergen statement must be provided in the 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 \_\_\_\_\_.

#### **B. USDA Labeling Requirements**

When USDA labeling is used, any deviation from labeling requirements in this Specification must be approved by the Contracting Officer, in writing, prior to the start of production. Labeling and marking of the shipping containers must be in accordance with this Specification. Labeling and marking information must be water-fast, non-smearing, of a contrasting color, clear, and readable.

1. USDA Labeled Packages.

No labeling information is required on the packaging materials.

2. USDA Labeled Shipping Containers.

a. Labeling and Marking Information.

(1) Requirements. Labeling and marking information must be: (1) preprinted, stamped, or stenciled on each shipping container; or (2) printed on a self-adhesive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 1 and 2.

(2) Nutritional labeling. A nutritional label, indicating the nutrient content of the commodity, is required on the principal display panel of each shipping container. This nutritional facts information or "Nutrition Facts Label" must comply with all labeling requirements of FSIS. The nutrition facts information must be preprinted on one end of each shipping container, or printed on a self-adhesive label and applied to one end of each shipping container. The self-adhesive label must not cover or conflict with the labeling requirements of this Specification.

b. Nutrition Facts, Ingredients and Allergen statements on shipping containers.

Nutrition Facts must be provided. The ingredient statement, even for single ingredient foods, must be included as a statement separate from the name of the product, e.g. Ingredients: \_\_\_\_\_. The allergen statement must be provided in the 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 \_\_\_\_\_.

c. Universal product bar code.

(1) A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on each shipping container. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop indicators will be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance with UPC guidelines published by GS1 US, Princeton Pike Corporate Center, 1009 Lenox Drive, Suite 202, Lawrenceville, New Jersey 08648.

(2) The contractor will use the code furnished by USDA. USDA has acquired a unique manufacturer's identification number for the commodity purchase programs and will use a unique item code number for the commodity purchased under this Specification. The contractors need not join GS1 US.

(3) The 14-digit UPC code for shipping containers of this commodity is:  
1 07 15001 00119 8

(4) The UPC code must be placed in the lower right-hand corner of the principal display panel of each shipping container.

d. Recycle Symbol and Statement. The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 3. The statement “PLEASE RECYCLE” is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.

e. Inventory Control Information. The processor may include any additional information (including bar codes) for processor inventory control purposes. This information may be applied somewhere on the surface of the shipping container but must not cover or conflict with the labeling requirements of this Specification.

### C. Use of Previously Printed USDA Labeling Materials

Carryover inventories of existing supplies of printed packing materials (USDA labeling) from the Commodity Specification for Turkey Taco Filling dated September 2012 may be used. If the ingredients statement, labeling of the ingredients, or nutrition facts information or panel changes from that printed on existing supplies, the contractor/processor must request temporary approval for use of carryover inventories from FSIS.

Shipping containers or labels with incorrect: (1) plant number, (2) net weight, (3) date packed, (4) name of product, (5) ingredients statement, or (6) nutrition facts information or panel must be corrected before they are used. The incorrect information must be blocked out and the correct information legibly printed, stamped, or stenciled in permanent ink. Additionally, the name, address, and phone number of the processor must appear on each shipping container.

### D. Additional Labeling Issues

The following are not acceptable for use under this Specification:

1. Commercial labels that do not have a processor traceability system and code.
2. Commercial labeling traceability coding and systems that have not been reviewed by a representative of USDA, AMS, Livestock, Poultry and Seed Program, Grading Division.
3. Distributor commercial labels.
4. Two or more different commercial labels in the same purchase unit.
5. Commercial labels and USDA labels in the same purchase unit.

E. Free Along Side (FAS) Vessel Deliveries

FAS. vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Sales Order/Item Number. The address must be clearly printed on at least two sides of each pallet.

**IV. FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY**

A. Material and Net Weight Compliance

1. Verification of Materials and Defects.

a. Verification of packaging and packing materials. Contractor must verify compliance with packaging, packing, and marking material requirements by furnishing the Grader the following certification on company stationery signed by a person authorized to do so by the contractor:

“I/We certify that the packaging, packing, and marking materials used for any commodity presented for acceptance under the terms of the Commodity Specification for Turkey Taco Filling dated April 2013 comply or will comply with the terms of this Commodity Specification.

Name \_\_\_\_\_

Title \_\_\_\_\_”

One certification is adequate for all production under this Specification.

b. Packaging defects. Packages in a delivery unit will be examined for defects that affect protection, expose product, or permit dehydration or freezer burn; or permit quality deterioration during storage, such as tears, holes, or improperly sealed or closed packages. The exterior of filled casings, bags, or pouches must be clean and free of product.

c. Packing defects. Shipping containers in a delivery unit will be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers.

d. Tolerance for defects. If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the Livestock, Poultry and seed Program's Packaging and Packing Defects Worksheet (PY-110), the delivery unit will be rejected.

2. Net Weight.

a. A purchase unit or delivery unit must total 39,000 pounds (17,690 kg) net.



b. Each delivery unit, except as provided in IV.A.2.g., will be examined for compliance with the net weight requirements at time of checkloading.

c. The tare weight of all packing materials will be determined by weighing a representative sample of all packaging components such as plastic-film bags and fiberboard containers.

d. Fifteen (15) shipping containers of commodity will be selected at random from a delivery unit to determine net weight. The total net weight of the 15 shipping containers must be equal to or greater than 450 pounds (204.12 kg). If an individual shipping container in the sample from the delivery unit has a net weight of less than 29.7 pounds (13.47 kg), the delivery unit will be rejected.

(1) If the total net weight is less than 450 pounds (204.12 kg), but greater than or equal to 445.50 pounds (202.08 kg), the delivery unit will be accepted at a discount as stated in IV.A.2.e.

(2) If the total net weight is less than 445.50 pounds (202.08 kg), the delivery unit will be rejected (see IV.A.2.f.).

e. A delivery unit with the average net weight per container listed below will be accepted at the corresponding discount:

(Average Test Net Weight Per Container)

<u>Less Than</u>	But Not <u>Less Than</u>	Contract <u>Price Discount</u>
30.0 pounds (13.61 kg)	29.7 pounds (13.47 kg)	1.0%
29.7 pounds (13.47 kg)	--	Unacceptable

---

Payments will be made on the actual quantity delivered. All price adjustments will be based on a delivery unit.

f. Rejected delivery units may be reworked and reoffered one time only. However, if an individual shipping container in the sample of the reworked delivery unit has a net weight of less than 29.70 pounds (13.47 kg), the delivery unit will be rejected.

g. As an alternative to test weighing at time of checkloading, the contractor may request on-line verification of net weights. Upon receiving the request, a Federal-State supervisor, USDA, AMS, Grading Division, Livestock, Poultry and Seed Program (or their designee), will determine that the facilities and procedures are in accordance with applicable Livestock, Poultry and Seed Program's instructions for this Specification.

#### B. Prerequisites for Loading and Shipping Frozen Commodity

1. Visual Inspection. Frozen commodity showing any evidence of defrosting, refreezing, or freezer deterioration will be rejected for use under this Specification.

## 2. Internal Product Temperature.

a. Requirements. The internal product temperature of frozen commodity must be 2 °F (-16.7 °C) or lower at time of loading. Delivery units with internal product temperatures exceeding 2 °F (-16.7 °C) and up to 5 °F (-15 °C) will be tentatively rejected. Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2 °F (-16.7 °C) or lower and reoffered one time only. Delivery units exceeding 5 °F (-15 °C) or delivery units that have been tentatively rejected and exceed 2 °F (-16.7 °C) when reoffered will be rejected for use under this Specification.

b. Optional temperature verification. As an option to verifying internal product temperature at time of loading, the contractor may request an alternate method utilizing product temperature-sensing devices. If this option is selected, a Federal-State Supervisor, Grading Division will determine that the facilities, equipment, procedures, and the contractors' current level of freezing compliance are in accordance with the established guidelines outlined in applicable Livestock, Poultry and Seed Program's instructions for this Specification.

## C. Inspection and Checkloading

1. Requirements. Inspection for contract compliance will be made by a USDA representative, in accordance with 7 CFR part 70, FSIS regulations, and this Specification, at site of processing, both during and after processing and packaging. A USDA representative may select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination. Inspection records must be complete and made available to USDA, as requested, to assure contract compliance.

2. Procedures. The inspection and checkloading must be performed by a Grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest USDA, AMS, Livestock, Poultry and Seed Program, Grading Division field office or the Director, Grading Division, USDA, AMS, Poultry Programs, Room 3932-S, STOP 0258, 1400 Independence Avenue, SW, Washington, DC 20250, telephone (202) 720-3271. The quality, quantity, weight, packaging, packing, and checkloading of the commodity must be evidenced by certificates issued by the Grader. The contractor must not ship the commodity unless informed by the Grader that the designated lot or subplot to be shipped meets contract specifications.

## V. **UNITIZATION**

Each delivery unit of commodity must be unitized (palletized and stretch-wrapped) and comply with the following:

### A. Pallets

Pallets must be good quality, measure 48 inches x 40 inches, nonreversible, flush stringer, and partial four-way entry. Each pallet of shipping containers must be stretch-wrapped with plastic film in a manner that will secure the containers on the pallet. Palletized product must be loaded in

a way that will prevent shifting and damage to the containers of product. Pallet loads shall be stacked in a manner that minimizes the overhang of the shipping containers over the edges of the pallets and exposes the principal display panels for certification examinations.

B. Pallet Exchange

Contractors may arrange for pallet exchange with consignees; however, USDA is not responsible for such arrangements.

**VI. SHIPMENT AND DELIVERY**

Shipment and delivery must be made in accordance with the AMS Master Solicitation, the Solicitation, and this Specification. In addition, the contractor must adhere to the following provisions.

A. Contract Compliance Stamp

Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number. A Grader, or other authorized personnel under the supervision of the Grader, will stamp one end of each shipping container prior to shipment. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

B. Grading Certificate

A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading must accompany each shipment.

1. Railcar or Piggyback. If shipment is by rail or piggyback, the certificate must be placed in the railcar or trailer for easy access to the Grader, warehouseman, or consignee, as applicable.

2. Trucks. If shipment is by truck, the driver must, upon delivery, give the certificate to the Grader, warehouseman, or consignee, as applicable.

C. Loading and Sealing of Vehicles

Loading must be in accordance with good commercial practices and the initial sealing must be done at origin under the supervision of a Grader. Thereafter, all delivery units--truck lot and less-than-truck lot (LTL) quantities--must be secured at all times prior to unloading with tamper proof, tamper resistant, serially numbered, high security seals. Suppliers of commodities, products and services shall be responsible for placing a seal (seals) on all doors of each transportation conveyance upon completion of loading or servicing. Seals shall be serially numbered, barrier-type and meet the American Society for Testing and Materials (ASTM) standards (F-1157-04). Seals shall be 1/8<sup>th</sup> inch in diameter cable, high security bolt, or equivalent. The contractor must maintain a record of each seal number used for truck lot and LTL delivery units. Additionally, the

contractor must ensure that the applicable seal identification number is on each bill of lading, shipment manifest, or other delivery documents for each delivery destination.

When LTL delivery units are transported on the same trailer or railcar and destined for multiple recipients, the trailer or railcar must be sealed after each delivery. The seal number must be recorded on the appropriate delivery documents and correspond with the applied seal at the time of arrival at the next destination. It will be the responsibility of the contractor to provide a sufficient number of seals and ensure that the carrier service (truck or rail) secures the trailer or railcar after each delivery destination. Failure to seal the trailer or railcar after each stop may result in rejection of the shipment by the recipient agency at the next scheduled stop and rejection of any subsequent deliveries on the trailer or railcar.

1. Railcar. Each railcar must be sealed. The contractors are responsible for arranging railcar deliveries of more than one delivery unit so that each delivery unit contained in the same railcar can be completely separated and sealed.

2. Truck or Piggyback. Truck or piggyback shipments must be sealed at origin. Delivery unit shipped by truck or piggyback which includes split deliveries to multiple destinations will require sealing after each drop in accordance with Section VI.C. of this Specification.

#### D. Delivery Notification

The Contractor must comply with the Master Solicitation regarding the Advance Shipping Notices (ASNs) and unloading appointments.

1. In-Plant Deliveries. When in-plant delivery is made, the contractor must notify the appropriate resident Grader and furnish applicable information.

2. Delivery In Storage. Delivery may be made in store provided the destination in the Sales Order/Item Number and place the contractor has the commodity in storage are the same. Inspection and certification by a Grader are also required for transfers in store.

#### E. Split Deliveries

The contractor is responsible to deliver the quantity stated on each Sales Order/Item Number to each destination. Contractors must provide to the Grader, at time of shipment, the number of boxes and pounds for each destination.

At the option of the contractor, a purchase unit for multiple destinations (split deliveries) may be delivered on separate trucks provided each truck ships the total quantity stated on the Sales Order/Item Number. Any additional costs will accrue to the contractor's account.

### **VII. DESTINATION EXAMINATION**

The cost of a destination examination, before or after delivery, by a Grader on accepted product will be for the account of USDA. Costs for destination examinations of rejected delivery units


will be for the account of the contractor. The origin Grader will make arrangements for destination examination prior to delivery.

A. Commodity Requirements

Before acceptance by consignee, the commodity may be examined by a Grader on a spot-check basis for temperature, condition, identity, and when applicable, count. The commodity may be examined for conformance to contract provisions at any time required by the Contracting Officer.

B. Temperature

The commodity must arrive at destination at an average internal product temperature not to exceed 10 °F (-12.2 °C) with no individual temperature exceeding 15 °F (-9.4 °C). Commodity not meeting these requirements will be rejected for use under this Specification.

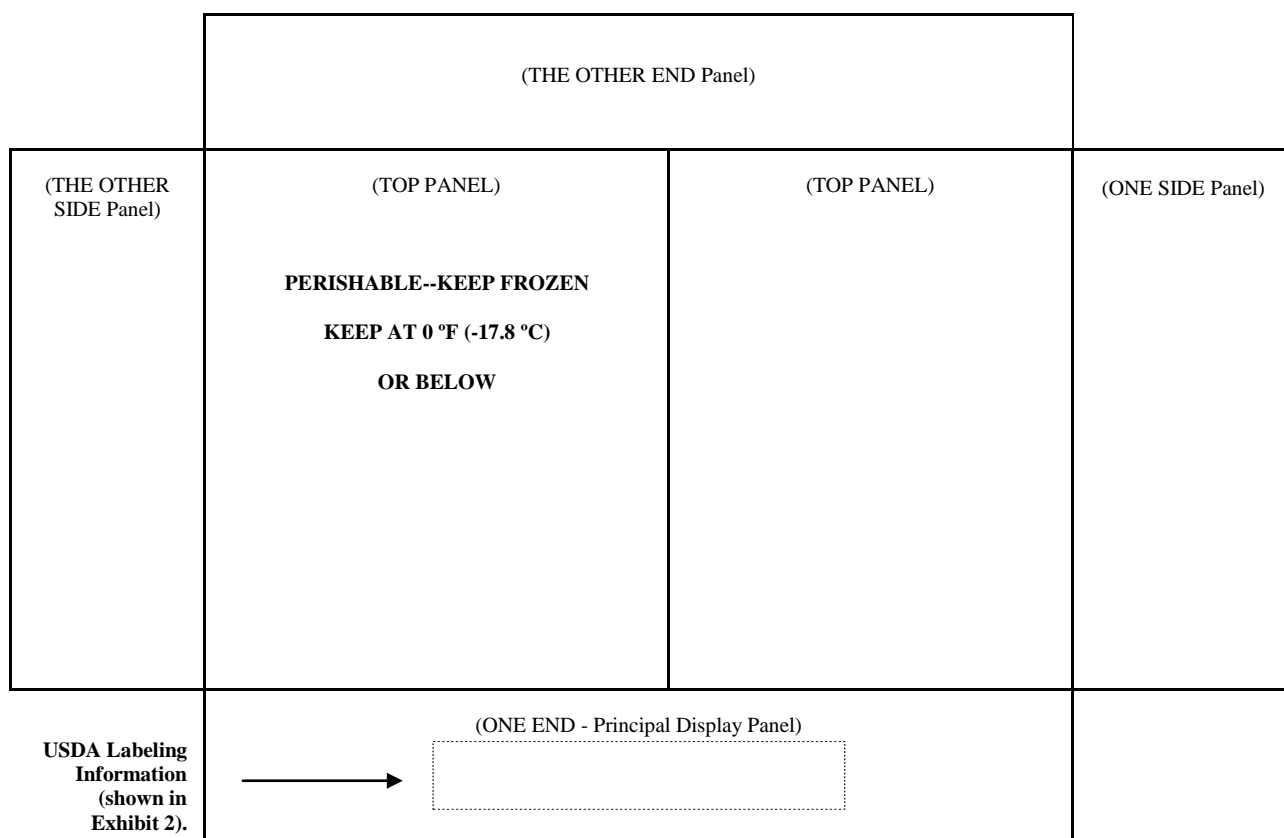


Director, Food Safety and Commodity Specification Division  
Livestock, Poultry and Seed Program

Attachments

## EXHIBIT 1 USDA Labeled Shipping Containers

**Marking Information:** Shipping containers may be marked substantially as shown below. Detailed USDA labeling information is provided in EXHIBIT 2. Markings must be preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. The USDA symbol, copy on back of Specification, is to be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or principal display panel. The processor’s name, address, and phone number must be printed on the “TOP PANEL” or principal display panel. The processor’s name and address must indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.



**EXHIBIT 2**  
**USDA Label Information for Turkey Taco Filling**

Marking Information: USDA labeling information must be printed on the principal display panel of each shipping container as provided in EXHIBIT 1. Markings must be preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. The UPC 14-digit 2/5 code and symbol, must be shown in the lower right-hand corner of the principal display panel. The USDA symbol, copy on back of Specification, must be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or principal display panel. The processor’s name, address, and phone number must be printed on the “TOP PANEL” or principal display panel. The processor’s name and address must indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.



**FROZEN COOKED  
TURKEY TACO FILLING**

Ingredients:  
(Food Allergen Statement, if applicable  
May Be Placed Here)

Processor’s Name,  
Address, and Phone Number

Nutrition Facts Label  
Must Be Placed Here

**KEEP FROZEN**

\_\_ Bags Net Weight  
30 LBS. (13.61 KG)

DATE PACKED Month, Day, and Year

UPC Code and Symbol

**EXHIBIT 3**  
**“Please Recycle” Symbol and Statement**



**PLEASE  
RECYCLE**



USDA SYMBOL

