



APPROVED

**AMENDMENT 2 TO
SUPPLEMENT 304 PORK
CHOPS (FROZEN) MAY 2013**

Agricultural Marketing Service (AMS)
Livestock, Poultry and Seed (LPS) Program
Food Safety and Commodity Specification (FSCS) Division
Room 2624 S-Bldg, Phone: (202) 692-0342

Effective: February 2015

**AMENDMENT 2 TO SUPPLEMENT 304 TO AMS MASTER SOLICITATION
PURCHASE OF PORK CHOPS (FROZEN) FOR DISTRIBUTION TO CHILD
NUTRITION AND OTHER FEDERAL FOOD AND NUTRITION ASSISTANCE
PROGRAMS**

This amendment is issued to make the following changes to Supplement 304:

- 1) All references to the Contracting Officer's Technical Representative (COTR) are to be replaced with "Food Safety and Commodity Specification (FSCS) Division."
- 2) Replace Attachment I and Attachment II with the attached Federal Purchase Program Specifications (FPPS) Pork Loin Chops, Center Cut, Boneless, Frozen and Animal Handling and Welfare, dated January 2015.
- 3) Delete Attachment III.

All other terms and conditions remain unchanged.



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**FEDERAL PURCHASE
PROGRAM SPECIFICATION
(FPPS) FOR PORK LOIN
CHOPS, CENTER CUT,
BONELESS, FROZEN**

Agricultural Marketing Service (AMS)
Livestock, Poultry and Seed (LPS) Program
Food Safety and Commodity Specification (FSCS) Division
Room 2628 S-Bldg, Phone: (202) 692-0342

Effective: [January 2015](#)

100 ITEM DESCRIPTION

110 Pork Loin Chops, Center Cut, Boneless, Frozen – This item is as described in the Institutional Meat Purchase Specifications (IMPS) Item Number 1413 PSO 1. Individual boneless chops shall not be marinated and weigh four (4) oz. (114g) +/- one-half (½) oz. (14g), exhibit a tail length of ≤ one (1) in. (26mm) and be frozen prior to packaging.

200 APPLICABLE DOCUMENTS

210 IMPS for Fresh Pork - Series 400, effective November 2014.

300 CHECKLIST OF REQUIREMENTS

310 All items must be produced in accordance with Food Safety and Inspection Service (FSIS) regulations. The contractor's technical proposal, submitted to the FSCS Division, must adhere to the following AMS Checklist of Requirements.

400 MATERIALS

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

420 MEAT COMPONENT

421 Pork derived from hog carcasses will be the only meat component allowed. Pork derived from boar and sow carcasses is not permissible.

422 Domestic Origin – All pork will originate from U.S. produced livestock as defined in the Master Solicitation and Supplement.

- 423 Harvesting – Hogs will be harvested in facilities that comply with the following requirements:
- 423.1 Humane Handling – Hogs will be humanely handled in accordance with all applicable FSIS regulations and AMS requirements.
 - 423.2 Non-Ambulatory Disabled Animals – Meat from carcasses of non-ambulatory disabled livestock will not be included in USDA Purchase Programs.
 - 423.3 Spinal Cord Removal – All spinal cord tissue will be removed during the harvesting process.
- 424 Pork – Pork must comply with the following requirements:
- 424.1 Traceability – Contractors are responsible for providing sufficient product traceability and must have records to verify the source of raw materials used in each lot of product.
 - 424.2 Handling – All pork must be maintained in excellent condition. The contractor’s technical proposal shall include detailed production scheduling that addresses time and temperature controls necessary to maintain excellent condition of the pork.
 - 424.3 Lean Quality – Fresh-chilled pork must be reasonably uniform in color (slightly two-tone color is permissible) ranging from light pink to red. The pork muscles must not exhibit any evidence of pale, soft, and/or exudative conditions.
 - 424.4 Objectionable Materials – Pork will be free of skin, bone, cartilage, organ tissue, significant glandular tissue, heavy connective tissue and foreign materials.
- 425 Mechanical Separation – Pork that is mechanically separated from bone with automatic deboning systems or powered knives will not be allowed.

500 PROCESSING

- 510 The contractor’s technical proposal shall describe the necessary processing steps (including pictures) to comply with the items below.
- 511 Processing Date – Pork chops will be processed into finished product form no more than 30 days prior to shipment.
- 512 Pork chops will be produced as outlined in **Section 100 – Item Descriptions** and as defined in IMPS Item Number 1413, PSO 1.
- 513 To facilitate portioning into chops, pork loins may be frozen and/or tempered, one time only.

514 Weight – Individual pork chops shall weigh four (4) oz. (114g) +/- one-half (½) oz. (14g).

516 Tail Length – Individual pork chops shall exhibit a tail length of ≤ one (1) in. (26 mm).

530 METAL DETECTION

531 All products will 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 technical proposal must identify and describe the equipment, location, detection procedure, sensitivity levels, frequency of equipment validation, and corrective action procedures.

600 FINISHED PRODUCT LIMITATIONS

610 The declared serving size, fat content and sodium level will be stated on the nutrition facts panel on each label according to FSIS nutritional labeling regulations.

610 FAT

611 The fat content of the finished product will not exceed 10 percent.

611.1 $((\text{Declared Fat (g)} / \text{Declared Serving Size (g; reference amount customarily consumed (racc))}) \times 100) \leq 10$ percent.

612 External (subcutaneous) fat thickness of individual pork loin chops will be an average of one-eighth (⅛) in. (3 mm) with the maximum thickness at any one point not to exceed one-quarter (¼) in. (6mm).

620 SODIUM

621 Sodium level must not exceed 70mg per 100 gram basis

622 $((\text{Declared Sodium Level (mg)} \times 100) / \text{Declared Serving Size (g; racc)}) \leq 70$.

700 STATE OF REFRIGERATION

710 Pork chops will be frozen to an internal temperature of not higher than 0°F (-17.8°C) within 72 hours from the time of final fabrication of the production lot.

800 PREPARATION FOR DELIVERY

810 PACKAGING

811 Four (4) pork chops shall be placed into a flexible immediate container and vacuum packaged to a net weight of one (1) pound.

812 Individual pork chops shall be prepared in a manner (e.g. individually quick frozen (IQF) or inter-leaving) which prevents them from sticking together after they are packaged and packed.

820 PACKING

821 Forty (40) immediate containers shall be placed into a shipping container to a net weight of 40 pounds.

830 LABELING

831 The shipping containers shall be in compliance with the National Motor Freight Classification, or the Uniform Freight Classification, as applicable. Both the immediate and shipping containers shall be labeled to include all information required by FSIS regulations, be illustrated in the contractor's technical proposal, and contain the following information:

832 Immediate Container Labels – Immediate container labels will be commercially labeled (e.g. "Brand X") and contain the following information:

832.1 A "Best-If-Used-By" date that is 180 calendar days from the date of production.

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

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

832.4 Safe handling instructions.

832.5 Ingredient declaration (including single ingredient products).

832.6 Cooking instructions.

833 Shipping Container Labels – Shipping container labels will contain the following information:

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



833.2 Applicable purchase order number.

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

- 833.4 A nutrition facts panel based on actual nutritional analysis of the product.
- 833.5 Material number: 110380
- 833.6 Product Name: Pork Loin Chops, Boneless, Center Cut, Frozen
- 833.7 An allergen statement in a format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains _____.

840 CLOSURE

- 841 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.

850 PALLETIZED UNIT LOADS

- 851 All product shall be stacked on new or well-maintained pallets and palletized with shrink wrap plastic, unless otherwise specified in the solicitation. Pallet loads shall be stacked in a manner that minimizes the overhang of the shipping containers over the edges of the pallets and exposes each shipping container's principal display panel to facilitate certification examinations.

900 DELIVERY UNIT

- 910 Each delivery unit will consist of 950 cases and 38,000 pounds.

1000 DELIVERED PRODUCT

1010 SIZE AND STYLE OF CONTAINER

- 1011 Only one size and style of immediate and shipping containers may be offered in an individual shipping unit.

1020 TEMPERATURE

- 1021 All products will not exceed 0°F at the time of shipment and delivery.

1030 SEALING

- 1031 Sealing - All products must be delivered to AMS assigned destinations under seal with tamper proof, tamper resistant, serially numbered, high security seals that meet the American Society for Testing and Materials Standard (ASTM) F 1157-04 and/or the International Organization for Standards (ISO) 17712-2010 as required under the Master Solicitation. Seals shall be $\geq \frac{1}{8}$ th inch diameter cable, high-security bolt, or equivalent.

1100 PRODUCT ASSURANCE

1110 WARRANTY AND COMPLAINT RESOLUTION

1111 Warranty – The contractor will guarantee that the product complies with all contractual requirements required under the Master Solicitation and the Supplement.

1112 Complaint Resolution – The contractor’s technical proposal must provide steps taken to resolve complaints received on the product (i.e. point of contact, cause and effect analysis, corrective and preventative actions taken, and product replacement).

1120 NON-CONFORMING PRODUCT

1121 The contractor must have documented procedures that assure nonconforming product identification, segregation, and disposition in order to prevent misuse and that nonconforming product is not delivered to USDA. The plan must address 1) control and segregation of non-conforming product, 2) removal of any USDA markings, and 3) disposition of non-conforming product, including vendor notification in writing to the FSCS Division of final disposition (e.g., diverted to commercial production, or destroyed).

1130 CONTRACTOR CHECKLOADING

1131 Contractor will perform checkloading examinations at the time of shipment and issue a contractor’s certificate to accompany each shipment that includes all of the following information:

1131.1 Purchase Order Number/Purchase Order Line Item Number;

1131.2 Sales Order Number/Sales Order Line Item Number;

1131.3 Destination of shipment;

1131.4 Name of Product and applicable Material Number;

1131.5 Shipping Date;

1131.6 Production lot number(s) and date each lot was produced along with shipping container and immediate container code(s) and the code used that provides traceability to establishment number, production lot and date;

1131.7 Count of shipping containers and total projected net weight in each production lot;

1131.8 Identity of car or truck (car numbers and letters, seals, truck license, etc.) as applicable;

1131.9 Contractor certification that product conforms with the applicable specification (FPPS-PLC-2015);

1131.10 Count and projected net weight verified and;

1131.11 Signature of company official responsible for checkloading.



APPROVED

FEDERAL PURCHASE PROGRAM SPECIFICATION (FPPS) FOR ANIMAL HANDLING AND WELFARE

Agricultural Marketing Service (AMS)
Livestock, Poultry and Seed (LPS) Program
Food Safety and Commodity Specification (FSCS) Division
Room 2628 S-Bldg, Phone: (202) 692-0342

Supersedes: FPPS-AHW-2014 June 2014 – Changes
from previous requirements in [blue](#)

Effective: [January 2015](#)

100 GENERAL

101 This document is for use by the Department of Agriculture (USDA), AMS, LPS Program to ensure that the animal handling and welfare requirements for Federal nutrition assistance programs reflect industry best practices.

110 PROGRAM APPROACH

111 All animal harvest facilities that supply raw materials from bovine, porcine and ovine species for the production of AMS destined finished products must develop and implement a written program that is consistent with a systematic approach to humane animal handling and welfare as outlined in 69 FR 54625. The program will ensure proper animal handling and welfare techniques are conducted from the time the transportation conveyance enters the facility's premises through the stunning and exsanguination of the animal.

120 PROGRAM SUBMISSION

121 The program will be submitted as a supporting document to the organization's approved technical proposal and must address the requirements outlined in **Section 200 – PROGRAM COMPONENTS**.

200 PROGRAM COMPONENTS

201 The contractor must ensure that any facility that harvests animals has a:

210 MANAGEMENT COMMITMENT

211 Steering Committee (internal) which is ultimately accountable for animal handling and welfare initiatives within the organization.

212 Mission Statement on animal handling and welfare that is distributed to all employees and conspicuously displayed at the premises.

220 TRAINING PROGRAM

221 Training program on Animal Handling and Welfare that:

221.1 is provided to all employees interacting with animals;

221.2 covers the *AMI Recommended Animal Handling Guidelines and Audit Guide 2013 Edition*;

221.3 is facilitated by an employee that has earned and maintained a certification of animal handling and welfare training, such as that offered through the Professional Animal Auditor Certification Organization (PAACO) or an equivalent.

221.4 is conducted no less frequently than once a year for each designated employee; and,

221.5 requires signed documentation from each employee and confirmation by signature of the designated, certified trainer upon successful completion of training.

230 QUALITY MANAGEMENT PLAN

231 Written quality management plan (internal) which addresses all provisions of Chapter 3: Transportation Audit Guidelines, 7 Core Criteria and Chapter 4: Auditing Animal Handling and Stunning, 7 Core Criteria, of the *AMI Recommended Animal Handling Guidelines and Audit Guide 2013 Edition*, found at the following web site address:

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

232 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.

233 All animal harvest facilities that supply raw materials from bovine, porcine and ovine species for the production of AMS destined finished products must have a fully functioning back-up stunning device onsite wherever animal stunning is performed.

240 NON-AMBULATORY AND U.S. SUSPECTS

241 CATTLE

242 Written protocol in-place and enforced that precludes the receipt of or having non-ambulatory, disabled cattle on the harvest facility premise. In the event that animals become non-ambulatory or disabled at any time while present at the harvest facility, the animal will be humanely euthanized and the carcass

removed from the premise in a timely manner through contracted services or other means.

243 HOGS AND SHEEP

244 Written protocol in-place and enforced that ensures all animals designated by Food Safety Inspection Service (FSIS) as U.S. Suspects (9 CFR 301.2) that are slaughtered are appropriately segregated during the harvest and production processes and precluded from inclusion in any products purchased by AMS.

300 PROGRAM EVALUATION AND ELIGIBILITY

301 The program will be audited (external) by AMS or a firm accredited by AMS. The accreditation of the firm will be conducted by the Quality Assessment Division (QAD) through the **USDA ISO Guide 65 Program**. Alternatively, at the option of the organization, the audits can be performed by QAD auditors.

302 Audit findings thought to be in conflict with Food Safety and Inspection Service (FSIS) regulations will be communicated to the establishment's FSIS Inspector in Charge (IIC) or designee.

310 AUDIT FORMAT

311 AMS or the AMS accredited auditing firm will conduct audits utilizing the following format:

312 TRANSPORTATION SEGMENT (*CHAPTER 3: AMI RECOMMENDED ANIMAL HANDLING GUIDELINES AND AUDIT GUIDE 2013 EDITION*)

312.1 Audited organizations must pass Core Criteria 1 and 6 with a minimum scoring of excellent, Core Criteria 2 through 5 with a minimum scoring of acceptable and Core Criteria 7 must be adhered to with full compliance (zero tolerance) each time an audit is performed.

313 ANIMAL HANDLING AND STUNNING SEGMENT (*CHAPTER 4: AMI RECOMMENDED ANIMAL HANDLING GUIDELINES AND AUDIT GUIDE 2013 EDITION*)

313.1 Audited organizations must adhere to Core Criteria 1, 2, 6 and 7 with full compliance (zero tolerance) and to Core Criteria 3, 4 and 5 with a minimum scoring of Acceptable each time an audit is performed.^{1/}

313.2 The auditor shall inform FSIS and organization officials in writing of all audit findings, including any observations of missed stuns and/or animals regaining sensibility following stunning, upon completion of the audit during the exit interview.

^{1/}Religious harvest (Kosher and Halal) shall be exempt from the AMS auditing of Core Criteria 1: Effective Stunning.

320 INITIAL AUDIT

321 Initial audit must be performed prior to award of contracts.

330 AUDIT FAILURE

331 If an audit is failed for any of the Core Criteria, the organization is not eligible to provide product until such a time that corrective and preventative actions are approved by the [Food Safety and Commodity Specification \(FSCS\) Division](#), implemented and proven effective.

340 AUDIT FREQUENCY AND STATUS

341 STANDARD - Until four (4) consecutive successfully passed audits are attained, an audit must be conducted within 3 months of the previous audit.

342 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 [FSCS Division](#), implemented and proven effective. This schedule will be for a period of time until four (4) successive audits are found to meet the passing requirements noted in **SECTION 310 – AUDIT FORMAT**; at which time audits shall be conducted on the STANDARD basis.

343 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.

344 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.

345 FOR-CAUSE – Any official enforcement actions issued by FSIS for missed stuns or for an animal regaining sensibility following stunning shall result in an immediate for-cause animal handling and welfare audit by AMS. Subsequent audit frequency will be determined by results of the AMS audit, as described above.

400 FSCS Division

401 The [FSCS Division](#) can declare an organization's Animal Handling and Welfare Program out of compliance at any time.

402 The organization shall immediately notify the [FSCS Division](#) when any animal handling and welfare official enforcement action is issued by FSIS.