

**FEDERAL PURCHASE PROGRAM  
SPECIFICATION (FPPS) FOR DELI-  
STYLE TURKEY BREAST  
PRODUCTS**

Agricultural Marketing Service (AMS)  
Livestock and Poultry (LP) Program  
Standards and Specifications Division (SSD)  
Room 3932 S-Bldg, Phone: (202) 690-3148

Supersedes: FPPS for September 2017 – changes from previous requirements in blue

**Effective: April 2020**

**100 ITEM DESCRIPTION**

- 110 Deli-Style Turkey Breast – Frozen, fully cooked deli-style turkey breast, produced from non-basted, ready-to-cook chunked and formed **boneless, skinless** turkey breast meat. Each deli turkey breast shall be vacuum packaged in a shrinkable oxygen and moisture proof bag or casing, and be packed as:
  - 110.1 100884 – Eight (8) 4 to 6-pound deli turkey breasts per fiberboard shipping container.  
A purchase unit shall total 40,000 pounds.
  - 110.2 100121 – Four (4) 9 to 11-pound deli turkey breasts per fiberboard shipping container. A purchase unit shall total 40,000 pounds.
  - 110.3 110554 (Sliced) – **Eight (8) 5-pound packages of thinly sliced (not shaved), shingle layered turkey breast meat packed into shipping containers with a net weight of 40 pounds.** A purchase unit shall total 40,000 pounds.
  - 110.4 110903 (Sliced) – **Twenty (20) 2-pound packages of thinly sliced (not shaved), shingle layered turkey breast meat packed into shipping containers with a net weight of 40 pounds.** A purchase unit shall total 40,000 pounds.
- 120 Deli-Style Smoked Turkey Breast – Frozen fully cooked deli-style smoked turkey breast, produced from non-basted, ready-to-cook chunked and formed turkey breast meat. Each smoked turkey breast shall be vacuum packaged in a shrinkable oxygen and moisture-proof bag or casing, and be packed as:
  - 120.1 100122 – Four (4) 9 to 11-pound deli smoked turkey breasts per fiberboard shipping container. A purchase unit shall total 40,000 pounds.
  - 120.2 110910 (Sliced) – **Eight (8) 5-pound packages of thinly sliced (not shaved), shingle layered turkey breast meat packed into shipping containers with a net weight of 40 pounds.** A purchase unit shall total 40,000 pounds.

120.3 110904 (Sliced) –Twenty (20) 2-pound packages of thinly sliced (not shaved), shingle layered turkey breast meat packed into shipping containers with a net weight of 40 pounds. A purchase unit shall total 40,000 pounds.

## 200 APPLICABLE DOCUMENTS

210 The following documents are incorporated as part of this USDA, AMS, [SSD FPPS – Deli-Style Turkey Breast Products – April 2020](#):

210.1 AMS/LP/Quality Assessment Division (QAD) Policies and Procedures.

210.2 Poultry Products Inspection Regulations (9 CFR § 381).

210.3 Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 CFR § 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*, 9 CFR § 381.170 to 172).

210.4 [AMS Master Solicitation for Commodity Procurements – Domestic Programs \(MSCP-D\)](#).

## 300 CHECKLIST OF REQUIREMENTS

310 [Domestic Products – Refer to the current AMS MSCP-D](#).

320 [Food Defense – Refer to the current AMS MSCP-D](#).

## 400 HARVESTING

410 All harvesting activities shall comply with all applicable Food Safety and Inspection Service (FSIS) regulations and requirements, including 9 CFR § 381, and shall be done under FSIS inspection.

420 Humane Handling – All poultry shall be humanely handled in accordance with FSIS Directive 6100.3.

## 500 PROCESSING

510 All processing activities shall comply with all applicable FSIS regulations and requirements, including 9 CFR § 381, and shall be done under FSIS inspection.

511 [Date Processed](#) – The commodity shall not be processed more than 90 calendar days prior to the first date of the delivery period [for each sales order](#).

512 Lot Definition – A lot is the amount of packaged commodity produced during a processing shift.

520 Performance Standards – Product shall be produced under FSIS pathogen reduction standards, as specified in 9 CFR § 381.

- 521 Inspection for contract and FPPS Compliance shall be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 CFR § 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*). The AMS Grader shall be responsible for certification of compliance with the requirements of this FPPS for ready-to-cook turkey carcasses and parts; preparation, formulation, and fabrication of turkey breast; smoking (as applicable), cooking and cooling deli turkey breast; slicing/dicing deli turkey breast; packaging and packing; freezing; labeling and marking; sampling; net weight and checkloading.
- 522 AMS Certification – USDA/AMS, LP Program’s QAD field office or the Director of QAD, LP Program, AMS, USDA, Room 3953-S, STOP 0258, 1400 Independence Avenue, SW, Washington, DC 20250-0258, telephone (202) 690-3147.
- 523 All steps in the manufacturing process shall be under the direct supervision of an AMS Grader and as outlined in QAD Policies and Procedures [for quality and compliance with product requirements](#). The AMS Grader may also select samples for laboratory analyses or inspect the commodity at any point including transit and after delivery to point of destination.
- 530 [Deli-Style Turkey Breast Meat](#)
- 531 [The commodity shall be produced from boneless, skinless turkey breast meat from non-basted, ready-to-cook young turkeys in accordance with AMS part 70.202.](#)
- 531.1 [All skin shall be removed from each part or meat portion. Only skin used in processing and formulation shall be permitted.](#)
- 532 Frozen meat may be used when:
- 532.1 produced from freshly harvested [young](#) turkeys;
- 532.2 packaged to protect against quality deterioration during frozen storage and identified so the time in storage and the class, kind, and specific deboned turkey product can be determined;
- 532.3 held not more than 180 days in frozen storage; and
- 532.4 product shows no evidence of thawing and refreezing or freezer deterioration. After tempering, the meat shall be used to produce the finished cooked commodity within 48 hours. The temperature of the meat shall not exceed 40°F (4.4°C) during the tempering process.
- 533 Other than the final freezing process for finished, packaged commodity, the commodity shall not be derived from turkey meat and skin that has been frozen more than one time.
- 534 Turkey from Other Plants – [Chilled or frozen](#) turkey carcasses and parts may be

transferred or obtained from other processing plants provided it:

- 534.1 has been processed, handled, and identified in accordance with this FPPS; and
- 534.2 complies with the non-basted, organoleptic, and other applicable requirements of this FPPS as evidenced by USDA certification. USDA certification may occur either at the plant of origin or at the receiving plant.
- 535 Type, class, and specific name of the product, part, boneless part, or meat; date harvested and date placed in frozen storage; and the USDA-assigned plant number shall be shown on each shipping container.
- 536 The chilled turkey and turkey carcasses and parts shall maintain an internal product temperature between 26°F (-3.3°C) and 40°F (4.4°C) during transit, from plant origin to destination.
- 540 **Meat Time Requirements**
- 541 **Deli-Style Turkey Breast and Deli-Style Smoked Turkey Breast (100884, 100121 and 100122)** – The chilled commodity shall be processed, packaged, packed, and placed in a freezer within 7 calendar days after the date of harvest.
  - 541.1 Within this 7-day timeframe the turkey meat and skin shall be fabricated into the cooked commodity within 72 hours after size reduction.
- 542 **For sliced commodity (110554, 110903, 110910 and 110904)** – The chilled commodity shall be processed, packed in heat and moisture barrier proof casing, sliced, packaged, packed and placed in a freezer within 10 days after the date of harvest.
- 543 **Maximum Temperature** – The temperature of the meat and skin shall not exceed 55 °F (12.8 °C) at any time during preparation or processing into the commodity.
- 544 **Cooling Requirements** – Meat and skin which are not used in the commodity on a continuous basis shall 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).
  - 544.1 **Cooling Medium** – Cooling methods and media (e.g., use of carbon dioxide (CO<sub>2</sub>), dry ice or liquid nitrogen (N<sub>2</sub>)) may be used to maintain the temperature of meat or skin.
  - 544.2 Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat or parts shall not be incorporated into the commodity. Liquid associated with normal product purge is acceptable.
- 550 **Processing Requirements for Meat and Skin**
- 551 Boneless, skinless breast meat and skin, in the amounts specified, shall be used to

prepare the raw turkey portion (meat block) of the commodity:

- 551.1 Breasts – Boneless, skinless, outer pectoral whole, half, or quartered breasts shall be used in the commodity.
- 551.2 Optional (Tenderloins) – Whole or half tenderloins with tendons removed may be used in the commodity.
- 551.3 Optional (Breast Trim) – Boneless breast meat that is trimmed or removed from the turkey breast or tenderloin during the boning and trimming process, otherwise known hereafter as breast trim, may be used in the commodity. Skin shall be removed from the breast trim prior to use in the formula.
- 551.4 Optional (Skin) – Skin covering the crop area and the neck skin up to the whisker may be included if the fatty blubber, spongy fat, and membranes have been removed from these areas.

552 Meat Block – The total amount of size-reduced breast meat and skin (meat block) shall represent not less than 90 percent of the total weight of the formula.

552.1 The total size-reduced meat block shall consist of the following:

Boneless skinless breasts -	<i>no less than 81 percent;</i>
Tenderloins, tendons removed -	<i>no more than 9 percent;</i>
Breast trim -	<i>no more than 10 percent; and</i>
Skin -	<i>no more than 5 percent.</i>

552.2 If the amount of optional products (tenderloins, breast trim and/or skin) is decreased or eliminated from the specified meat block, the minimum percentage (or maximum percentage, as applicable) of boneless, skinless breast meat and tenderloins shall be increased proportionally to the decrease in percentage of the optional product.

552.2 Unacceptable Meat – Mechanically separated turkey or turkey wing meat.

### 553 Organoleptic Requirements and Defects for Meat and Skin

553.1 Organoleptic Requirements – Boneless skinless parts, breast meat, breast trim, and skin shall be examined on a continuous basis for organoleptic requirements shown in Table 1. Any product that does not comply with the organoleptic requirements shall be rejected for use under this FPPS.

553.2 **Meat and Skin Defects** – A sample of 30 pieces of each boneless skinless meat component, 30 pieces of skin, and 2 pounds of breast trim (as applicable) shall be drawn and examined for the defects, shown in Table 1, before it is used in the formula. The frequency of sampling and the number of defects allowed shall be those outlined in QAD’s Sample Plan Level 1 (SPL-1). If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents shall be rejected.

- 554 Processing and Size Reduction – The boneless, skinless breasts and tenderloins with tendons removed (optional ingredient) shall be reduced in size through a plate with openings that are not less than 2 inches in one dimension.
- 554.1 Trim meat – Breast trim shall be ground through a plate with holes no less than 0.125 inch (1/8 inch) in diameter; or reduced through a desinewer plate or screen with holes 0.0591 inch to 0.0787 inch in diameter.
- 554.1.1 Additionally, provided the applicable dimension requirements are met, the plate, screen, or equipment may be designed to extract and discharge bone, bone-like material, cartilage, etc., simultaneously with size reduction. The system shall provide a continuous flow of discharge material during size-reduction. The discharge material shall not be used in the commodity produced under this FPPS.
- 554.2 Skin – Skin shall be emulsified or may be ground through a plate with holes that are no greater than 0.125 inch (1/8 inch) in diameter.
- 555 Defects – Boneless skinless parts, breast meat, breast trim, and skin shall be examined for defects on a sampling interval basis. Breast trim shall be examined in accordance with one of the following:
- 555.1 Breast trim that is size-reduced using equipment designed to extract and discharge bone, bone-like material, cartilage (gristle), cartilage-like material, or hard tendinous material, shall be examined for such material after size reduction only, or
- 555.2 Breast trim that is ground or desinewed using equipment that is designed to extract and discharge the material listed above shall be examined for the defects in Table 1 prior to size reduction only as stated below.
- 555.3 Regardless of the size-reduction system used, breast trim shall be examined for skin, blood clots, and discolorations prior to size reduction.
- 555.4 Regardless of the kind and number of defects (within Table 1) found, any sample with bone or bone-like material greater than 0.40 inch shall be cause for the rejection of the product the sample represents.
- 555.5 If the number of bone defects exceeds the maximum for the “target” level, or results in a rejection, the frequency of sampling for bone defects shall be increased to 30 pieces of each boneless skinless meat component, 30 pieces of skin, and/or 2 pounds of breast trim (as applicable) drawn twice each sampling interval until the cumulative number of bone defects reverts back to a “target” level.
- 555.6 If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents shall be rejected.
- 557 Organoleptic Requirements and Defects for Size-Reduced Breast Trim
- 557.1 **Organoleptic Requirements** – The size-reduced breast trim shall be examined in the fresh state on a continuous basis for the organoleptic requirements listed in Table 2

prior to formulation. If the product does not comply with the organoleptic requirements, it shall be rejected for use under this FPPS.

557.2 When an extraction/collection system is used in conjunction with size-reduction, a 2-pound sample of size-reduced breast trim shall be drawn and examined in the fresh state for the defect requirements listed in Table 2 prior to formulation.

557.3 If the sample of size-reduced meat contains bone or bone-like material, or has more meat defects (listed in Table 2) than the maximum tolerance for SPL-2, the product the sample represents shall be rejected for use under this FPPS.

557.4 Temperature Requirements – Size-reduced meat and skin that is not used in the commodity on a continuous basis shall be cooled by using cooling methods or media (e.g., use of CO<sub>2</sub> or N<sub>2</sub>) that lower the internal product temperature to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C). Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat, trim, or skin shall not be incorporated into the size-reduced product. Liquid associated with normal product purge is acceptable. No frozen or previously frozen size-reduced meat, trim, or skin may be used in the commodity.

## 560 Processing Sequence and Formulation

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

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

### 561.1.1 DELI-STYLE TURKEY BREAST PRODUCTS

	<u>Percent of Total by Weight</u>
Size-Reduced Meat Block (minimum)	90.00
Other Ingredients:	total shall not exceed 10 percent
Water/Ice (maximum)	6.75
Salt (maximum)	1.50
Sugar	0.75 - 1.00
Binder	0.50 - 1.00
Sodium/Potassium Phosphate (maximum)	0.50
Sodium/Potassium Lactate or Diacetate (maximum)	3.50
<b>(Soy and gluten are not allowed)</b>	
Total	100.00

### 561.1.2 DELI-STYLE SMOKED TURKEY BREAST PRODUCTS

	<u>Percent of Total by Weight</u>
Size-Reduced Meat Block (minimum)	90.00

Other Ingredients (total must not exceed):	10.00
Water/Ice (maximum)	7.60
Salt	1.25 - 1.40
Binder	0.50 - 1.00
Sugar	0.60 - 0.75
Sodium/Potassium Phosphate (maximum)	0.50
Approved cure accelerator, i.e., Sodium Erythorbate or Sodium Ascorbate	0.04
Sodium Nitrite	0.01
Sodium/Potassium Lactate or Diacetate (maximum)	3.50
<b>(Soy and gluten are not allowed)</b>	
Total	100.00

- 561.2 **Sodium Requirement** – The finished, cooked products shall contain no more than 600 mg sodium per 100 g based on actual analysis of the product as evidenced by the Nutrition Facts panel.
- 561.3 **Crediting and Serving Size** – Cooked product shall credit as a minimum 2 ounce equivalents meat/meat alternate per 2.90 ounce to 3.25 ounce serving.
- 561.4 The size-reduced meat block shall consist of breast meat, and as optional ingredients: tenderloins, breast trim, and skin. The total amount of other (added) ingredients shall not exceed 10 percent.
- 561.5 Binder shall consist of carrageenan (up to 0.50 percent of the total formula), modified starch(s) (up to 1 percent of the total formula), or a combination of the carrageenan and modified starch(s) (up to 0.50 percent carrageenan, total of combined binders not to exceed 1 percent).
- 561.6 Sugar may be sucrose, brown sugar, dextrose, or a combination thereof.
- 561.7 If sodium/potassium lactate or diacetate are used in any combination thereof for either commodity, the water and/or ice range percentages shall be adjusted accordingly.
- 561.8 Dry ingredients may be mixed with water to form a brine solution prior to the addition of meat. As an option to forming a brine solution, dry ingredients may be added directly to the meat portion and thoroughly mixed.
- 561.9 If liquid smoke flavoring is added to the formulation, the percentages for salt and sugar may be adjusted (reduced) to include this ingredient.
- 562 Processing aids (e.g., anticaking agents, anti-dusting agents, or other manufacturing aids (as present in salt, sugar, etc.)) are allowed. If processing aids are used, the ingredients and amounts of ingredients listed in the formulation shall remain the same.
- 563 Mixing – The brine solution shall be incorporated into the size-reduced meat block by mixing/blending, or tumbling or massaging with or without vacuum. If the option



of adding dry ingredients directly with the meat and skin portion is used, batches of meat and skin, dry ingredients, and water/ice shall be thoroughly mixed (by mixing/blending, or tumbling or massaging with or without vacuum) to ensure even distribution of ingredients throughout the batch.

564 Stuffing into Casings

564.1 After blending, the formulated batches of ingredients shall be stuffed into a cook-in film bag, pouch, plastic casing, moisture proof casing, standard fibrous casing, or smoke impregnated casing, as applicable for the commodity.

564.2 In no case shall the stuffing of the formulated batches of ingredients into casings be delayed longer than 48 hours or will the formulated batches be held at an ambient temperature higher than 40 °F (4.4 °C) or lower than 26 °F (-3.3 °C).

565 Smoking – For smoked product, stuffed casings of formulated product shall be smoked. Liquid smoke flavoring and smoke impregnated casings may be used. The processor shall inform the AMS Grader of the smoking method being used, and appropriately label that method on each commodity label.

566 Cooking – The commodity shall be smoked/cooked to an internal product temperature of 160 °F (71.1 °C) or higher for deli turkey breast, and 155 °F (68.3 °C) or higher for smoked turkey breast. Cooking methods and product temperature shall be monitored by FSIS.

566.1 All finished product shall meet the organoleptic requirements listed in Table 3.

567 Cooling – After cooking, the commodity shall be cooled to an internal product temperature of 40°F (4.4°C) or lower. Cooling methods and procedures shall be in compliance with FSIS directives and guidelines for cooked products.

568 Slicing – For sliced commodity, the commodity shall be removed from casing, and thinly sliced (not shaved), **have no spongy (porous texture) appearance**, after cooling and prior to repackaging and freezing.

569 Freezing – Packaged commodity shall be placed in a freezer within 48 hours of packing. The commodity shall be frozen by lowering the internal product temperature to 10°F (-17.8°C) or lower within 72 hours from the time of entering the freezer. If the commodity is not placed in a freezer immediately after packing, the product shall be held at a temperature not higher than 36°F (2.2°C) and not lower than 26°F (-3.3°C). When packaged product is held at a temperature below 26°F (-3.3°C), the commodity shall be considered to be in a freezer and subject to the 72 hour freezing requirement which begins at the end of the shift the commodity enters the 26°F (-3.3°C) or lower facility.

570 **Reworked Commodity – Commodity which is fractured (separated into two or more pieces); has cuts; has more internal or external defects than the maximum tolerances allowed; or does not meet the weight requirements may be reworked (defects removed) and incorporated into formulated batches of the applicable**

product provided:

- 570.1 The temperature of the product has not exceeded an internal product temperature of 40 °F (4.4 °C) and has been maintained at that temperature or lower;
- 570.2 The product is reworked within 72 hours from the end of the shift it was packaged;
- 570.3 The product is ground through a plate with holes 0.125 inch (1/8 inch) in diameter;
- 570.4 The product is incorporated at a maximum of 2 percent of the formulated batch, and
- 570.5 The product is added to formulated product that will undergo the same cooking/smoking processes as applicable.

580 Metal Detection – The commodity shall be examined by a metal detection device capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips, metal fragments from cutting equipment, and pieces of metal according to QAD policies and procedures.

581 As an alternate method, the formulated product may be examined by an in-line metal detection device installed in the mechanical stuffing or forming system before cooking and/or smoking. If the alternate metal detection method (in-line) is used and casings are later cut to meet the physical requirements, the product shall also be examined by a metal detection device prior to or after it is placed in the bag or casing.

582 Commodity found to be contaminated with metal shall be handled in accordance with FSIS procedures. Other procedures for the examination of the commodity shall be approved by the Director of [SSD](#) in writing.

## 600 **PACKAGING AND PACKING**

610 The contractor shall assure that all packaging, packing, labeling, closure, marking, and palletization comply with the National Motor Freight Regulations and FSIS regulations and the requirements listed below.

620 [Packing – Product shall be packed in 4 to 6-pound, 9 to 11-pound, 2-pound sliced or 5-pound sliced packages.](#)

630 Packaging – All packaging and packing materials shall be clean and in new condition, [shall](#) not impart objectionable odors or flavors to the commodity, shall be safe (cannot adulterate product or be injurious to health) for use in contact with food products, and shall be tamper-evident. Tamper-evident is defined as packaging and packing materials with one or more indicators of barriers to entry, which, if breached or missing, can reasonably be expected to provide visible evidence that tampering has occurred. All packaging material shall comply with FSIS regulations (9 CFR § 381.144(c)).

631 Films, Bags, and Casings – Shall be made of water-proof film with oxygen barrier

properties; be heat-shrinkable; and shall protect the product from dehydration, freezer burn, quality deterioration or contamination during the conditions of use.

- 631.1 When fibrous casings are used, the casing shall be removed from the commodity after the smoking (as applicable), cooking, and cooling processes, just prior to packaging.
- 631.2 The commodity shall be packaged in a heat shrinkable oxygen- and water-proof film, bag, or casing, as appropriate. The excess air shall be removed from each film, bag, or casing. The film, bag, or casing shall be shrunk to fit tightly against the surface of the commodity.
- 631.3 After the air is removed, the film bags or casings shall be hermetically heat sealed to ensure a vacuum closure and to prevent product dehydration and quality deterioration. Metal wire ties, paper-coated wire ties, or staples shall not be used for sealing films, bags, or casings.
- 640 Shipping Containers – Shipping containers shall:
  - 640.1 Be good commercial fiberboard containers that are acceptable by common or other carrier for safe transport to point of destination,
  - 640.2 Be of such size to pack the commodity without slack filling or bulging,
  - 640.3 Withstand the stresses of handling, shipping, stacking, and storage, and
  - 640.4 Be closed by commercially accepted methods and materials. Steel or wire straps shall not be used for final closure.
- 641 Staples shall not be used for final closure of shipping containers. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. Staples may be used to manufacture and to assemble the fiberboard shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.

## **700 LABELING**

- 710 CN Labeling information or a Product Formulation Statement demonstrating product contribution to the National School Lunch Program meal pattern requirements is required. For more information on the CN Labeling Program, see the section for Food Manufacturers/Industry on the FNS website:

<http://www.fns.usda.gov/cnlabeling/child-nutrition-cn-labeling-program>

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

- 730 Commercial Labeling Requirements
- 731 Each [individual package \(110903 and 110904\)](#) and shipping container shall be commercially labeled in accordance with FSIS requirements. Labeling shall be approved by FSIS prior to acceptance for use under this FPPS. Individual packages shall comply with retail consumer labeling requirements and must meet Section 4A52.211-4 of the MSCP-D.
- 731.1 [For 2-pounds sliced commodity \(110903 and 110904\), labels shall be adhered directly on individual package or printed label.](#)
- 732 Commercial Labels shall be the processor's own commercial label.
- 733 Traceable Product – The processor shall establish a product identification and record system that clearly links product by place and time of manufacture to specific USDA contracts and destinations. When the company uses the same commercial label for the product certified as complying with this FPPS and commercial product, the identification system shall differentiate between USDA and non-USDA products. An alpha numeric code may be used for information that is in addition to FSIS labeling requirements. The required product identification and record system, including codes, shall be reviewed by USDA/AMS before production begins for the contract(s).
- 734 Nutrition Facts, Ingredients, and Allergen Statements on [individual packages \(110903 and 110904\)](#) or shipping containers ([110554, 100884, 110910, 100121, and 100122](#)) – Nutrition Facts shall be provided. The ingredient statement, even for single ingredient foods, shall be included as a statement separate from the name of the product, e.g. Ingredients: \_\_\_\_\_. The allergen statement shall be provided in the format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains \_\_\_\_\_. For additional guidance refer to the Compliance Guidance at:  
  
<http://www.fsis.usda.gov/wps/wcm/connect/f9cbb0e9-6b4d-4132-ae27-53e0b52e840e/Allergens-Ingredient.pdf?MOD=AJPERES>
- 740 USDA Labeling Requirements
- 741 When USDA labeling is used, any deviation from the labeling requirements in this FPPS shall be approved by the Contracting Officer, in writing, prior to start of production. Labeling and marking of the product shall be in accordance with this FPPS.
- 742 Labeling and marking information shall be water-fast, non-smearing, of a contrasting color, clear, and readable.
- 743 USDA-Labeled Shipping Containers Requirements
- 743.1 Labeling and marking information shall be preprinted, stamped, or stenciled on each

shipping container; or printed on a self-adhesive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 1 – 5.

743.2 Nutrition Facts, Ingredients and Allergen statements on [individual packages \(110903 and 110904\)](#) or shipping containers ([110554, 100884, 110910, 100121, and 100122](#)) – Nutrition Facts shall be provided. The ingredient statement, even for single ingredient foods, shall be included as a statement separate from the name of the product, e.g. Ingredients: \_\_\_\_\_. The allergen statement shall be provided in the format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains \_\_\_\_\_.

743.3 Universal Product Code (UPC) Bar

743.3.1 A 14-digit UPC code for deli-style turkey breast products shall be as follows:

743.3.1.1 Material Code 100884 – 1 07 15001 00884 5

743.3.1.2 Material Code 100121 – 1 07 15001 00121 1

743.3.1.3 Material Code 110554 – 1 07 15001 10554 4

743.3.1.4 Material Code 110903 – 1 07 15001 10903 0

743.3.2 14-digit UPC code for deli-style smoked turkey breast products:

743.3.2.1 Material Code 100122 – 1 07 15001 00122 8

743.3.2.2 Material Code 110910 – 1 07 15001 10910 8

743.3.2.3 Material Code 110904 – 1 07 15001 10904 7

743.3.3 The UPC code shall be placed in the lower right-hand corner of the principal display panel of each shipping container.

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

750 Unacceptable Labeling:

751 commercial labels that do not have a processor traceability system and code;

752 commercial labeling traceability coding and systems that have not been reviewed by a representative of USDA/AMS/LP/QAD;

753 distributor [commercial labels](#);

754 two or more different commercial or USDA labels in the same purchase unit;

760 Free Along Side (FAS) Vessel Deliveries

- 761 FAS vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Sales Order/Item Number. The address shall be clearly printed on at least two sides of each pallet.
- 800 FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY**
- 810 Packaging Defects – Packages in a delivery unit shall be examined for defects that affect protection, expose product, or permit dehydration or freezer burn, or quality deterioration during storage, such as tears, holes, or improperly sealed packages.
- 820 Packing Defects – Shipping containers in a delivery unit shall be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers (7 CFR § 42).
- 830 Tolerance for Defects – If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the applicable QAD sample plan, the delivery unit shall be rejected.
- 840 Net Weight – Net weight for deli turkey breasts shall be determined at origin [in accordance with QAD's policies and procedures](#).
- 841 Delivery Unit – [A purchase or delivery unit shall consist of 4 to 6-pound, 9 to 11-pound, 2-pound sliced and 5-pound sliced packages and shall total 40,000 pounds net, or multiples thereof.](#)
- 842 Test Weighing Procedures
- 842.1 The tare weight of all packing materials shall be determined by weighing a representative sample of all packaging components such as plastic-film bags, clips, and fiberboard containers.
- 842.2 Weight variations – A weight variation of minus 1 percent (39,600 pounds) is permitted on each delivery unit. USDA shall pay the contractor only for the amount of commodity delivered within the required weight range. Any delivery unit weighing less than 39,600 pounds net shall be rejected.
- 844 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, QAD, LP Program (or their designee), shall determine that the facilities and procedures are in accordance with the applicable LP Program's instructions for this FPPS.
- 850 Loading and Shipping Frozen Commodity
- 851 Visual Inspection – Frozen commodity showing any evidence of thawing, refreezing, or freezer deterioration shall be rejected for use under this FPPS.
- 852 Internal Product Temperature

- 852.1 Frozen – Commodity shall be 2 °F (-16.7 °C) or lower at time of loading. Delivery units with internal product temperatures exceeding 2 °F (-16.7 °C) and up to 5 °F (-15 °C) shall be tentatively rejected. Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2 °F (-16.7 °C) or lower and reoffered one time only. Delivery units exceeding 5 °F (-15 °C) or delivery units that have been tentatively rejected and exceed 2° F (-16.7°C) when reoffered shall be rejected for use under this FPPS.
- 852.2 Optional Temperature Verification – The contractor may request an alternate method utilizing product temperature-sensing devices. If this option is selected, a Federal-State supervisor shall determine that the facilities, equipment, procedures, and the contractors' current level of freezing compliance are in accordance with the established guidelines outlined in the applicable LP Program's instructions for this FPPS.
- 860 Inspection and Checkloading
- 861 Requirements – Inspection for contract compliance shall be made by a USDA representative, in accordance with 7 CFR § 70, FSIS regulations, and this FPPS, at site of processing, both during and after processing and packaging. Inspection records shall be complete and made available to USDA, as requested, to assure contract compliance.
- 862 Procedures – The inspection and checkloading shall be performed by the AMS Grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest QA Division field office or the Director of QAD, LP Program, AMS, USDA, 1400 Independence Avenue, Room 3953-S, STOP 0258, Washington, DC 20250-0258, telephone (202) 690-3147.
- 862.1 The quality, quantity, weight, packaging, packing, and checkloading of the commodity shall be evidenced by certificates issued by the AMS Grader. Contractor shall not ship the commodity unless informed by the AMS Grader that the designated commodity to be shipped meets the requirements of the AMS [MSCP-D](#), Solicitation, and this FPPS.

## **900 PALLETIZED UNIT LOADS**

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

## **1000 SHIPMENT AND DELIVERY**

- 1010 Shipment and Delivery, including Loading and Sealing, Delivery Notifications and Split Deliveries – Refer to the current AMS MSCP-D.
- 1011 In addition, the contractor shall adhere to the following provisions:
- 1011.1 Each shipping container shall be identified with a USDA Contract Compliance stamp with the applicable certificate number. An AMS Grader, or other authorized personnel under the supervision of the AMS Grader, shall 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.
- 1011.2 As an alternative to stamping, the contractor may preprint the stamp on the shipping container or label. Prior approval by QAD is required before using this alternative method.
- 1012 A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading shall accompany each shipment.

## **1100 DESTINATION EXAMINATION**

- 1110 The cost of a destination examination, before or after delivery, by an AMS Grader on accepted product will be for the account of USDA. Costs for destination examinations of rejected delivery units shall be for the account of the contractor. The USDA origin AMS Grader shall make arrangements for destination examination prior to delivery.
- 1111 Commodity Requirements – Before acceptance by consignee, the commodity may be examined by an AMS 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.
- 1112 Temperature – The commodity shall arrive at destination at an average internal product temperature not to exceed 10 °F (-12.2 °C) with no individual temperature exceeding 15 °F (-9.4 °C) when shipped, during transit, and when received at the destination plant. When any sample exceeds 15°F (-9.4°C) the purchase unit shall be rejected for use under this FPPS.

## **1200 PRODUCT ASSURANCE AND COMPLAINT RESOLUTION**

- 1210 Product Assurance – The Contractor shall guarantee that the product complies with all FPPS requirements and provisions set forth in the FPPS, AMS MSCP-D, and Solicitation.
- 1211 Waiver Requests – Contractor shall submit all waiver requests directly to the Commodity Procurements Program (CPP) Contracting Officer for review and determination. Full list of CPP contacts can be found at:

<https://www.ams.usda.gov/selling-food/cp-contacts>



1220 Complaint Resolution – Customer complaint resolution procedures shall be the responsibility of the Contractor. These procedures shall include: a point of contact, investigation steps, and intent to cooperate with AMS, and product replacement or monetary compensation. The procedures shall be used to resolve product complaints from recipient agencies or AMS.

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

	<b>Criteria</b>
<b>Organoleptic Requirements:</b>	<b>Meat shall not:</b> (a) be rancid; have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign or off-odors; contain foreign materials (e.g., glass, paper, rubber, plastic, metal); and have a bright color; and (b) show evidence of mishandling or deterioration; or dehydration or freezer burn or thawing and refreezing.
	<b>Defects</b>
<b>Boneless, Skinless Meat and Trim:</b> <b>Bone:</b>	<b>Bone or bone-like material</b> greater than 0.40 inch (1.02 cm). <b>Bone or bone-like material</b> less than or equal to 0.40 inch (1.02 cm).
<b>Discoloration:</b>	<b>Any moderate discolorations.</b>  <b>Lightly shaded discolorations</b> exceeding an area equivalent to the area of a circle having a diameter of 0.50 inch (1.27 cm). Slight discolorations are permitted, provided the discoloration does not detract from the overall appearance of the meat.
<b>Other:</b>	<b>Cartilage</b> (gristle), hard tendons or tendinous material, or blood clots.  <b>Skin exceeding</b> an aggregate area equivalent to the area of a circle with a diameter of 0.50 inch (1.27 cm).
<b>Skin:</b>	<b>Any moderate discolorations.</b>
<b>Discoloration:</b>	<b>Lightly shaded discolorations</b> exceeding an area equivalent to the area of a circle having the diameter of 1.50 inches (3.81 cm). Slight discolorations are permitted on the skin, regardless of area, provided the discoloration does not detract from the appearance.
<b>Other:</b>	<b>Feathers</b> and blemishes. <b>Fatty blubber</b> , spongy fat, and membranes from the crop area.
<b>Breasts:</b>	<b>Whole breast</b> with less than one-fourth of the meat.
<b>Tenderloins:</b>	<b>Tenderloin</b> with tendon or less than one-half of the meat.

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

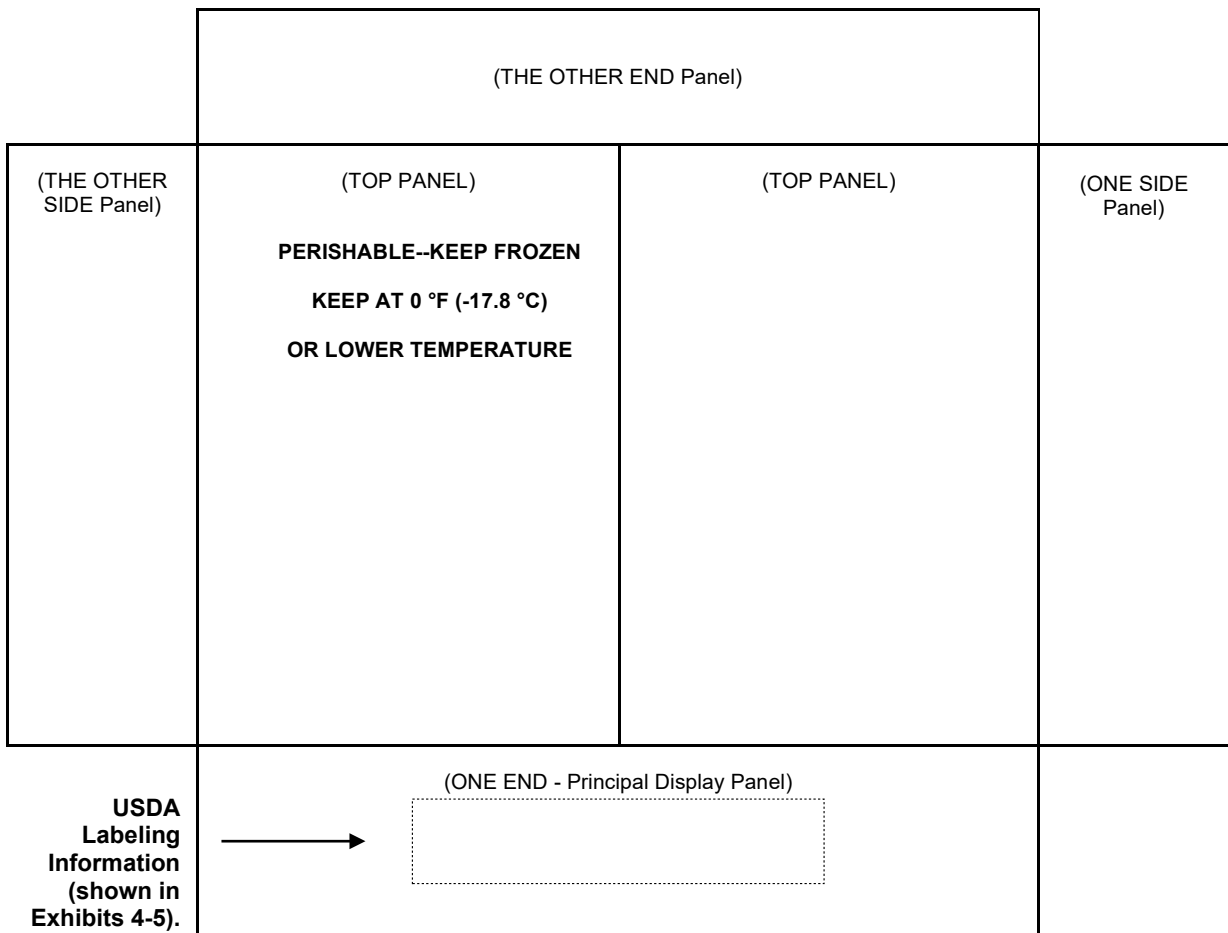
<b>Organoleptic Requirements:</b>	<b>Meat shall:</b> (a) not be rancid; not have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine, or other foreign and off-odors; not contain foreign materials (e.g., glass, paper, rubber, metal, plastic, wood); or show evidence of mishandling or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

**Table 3. Organoleptic Requirements and Defects for Finished Deli-Style Turkey Breast**

<b>Organoleptic Requirements:</b>	<b>Finished product shall:</b> (a) not be rancid; not have a <b>metallic, overcooked, burnt, scorched, bitter, oxidized, stale, fruity, beany, oily, soapy</b> , or other foreign or off-odors; not contain foreign materials (e.g., glass, paper, rubber, metal, plastic); and (b) not show evidence of mishandling or deterioration; or dehydration or freezer burn or thawing and refreezing.
<b>Exterior: (10 products examined)</b>	<b>Defects</b>
	<p><b>Individual major surface voids</b> (including air voids, fat pockets, and purge pockets) exceeding an aggregate area equivalent to the area of a circle with the diameter of 0.75 inch (1.91 cm). The depth of a void or pocket shall be no greater than 0.50 inch (1.27 cm).</p> <p>Unobtrusive purge is allowed; however, pocket and voids holding purge, fat, or air shall not exceed the aggregate diameter of 0.75 inch (1.91 cm).</p> <p><b>The deli breast shows evidence of excessive heating</b> (burnt or scorched).</p> <p><b>Individual product that does not weigh</b> 4 to 6-pounds (1.18 to 2.72 kg), or 9 to 11-pounds (4.08 to 4.99 kg) each.</p>
<p><b>Interior: (2 products examined)</b> Product shall be cut (widthwise) in three approximately equal pieces.</p>	<p><b>VOIDS, gelatin, or fat pockets</b> on the sliced surfaces that exceed an aggregate area per surface equivalent to the area of a circle with the diameter of 0.75 inch (1.91 cm).</p>



**EXHIBIT 1  
USDA-Labeled Shipping Containers**

**Marking Information:** Shipping containers may be marked substantially as shown below. Detailed USDA labeling information is provided in Exhibits 4 and 5. Markings shall be legibly preprinted, stamped, stenciled on containers, or printed on a self-adhesive label and applied to containers. The USDA symbol, **EXHIBIT 6**, 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 shall be printed on the “TOP PANEL” or principal display panel. The processor’s name and address shall indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints. ***The Handling Information and Nutrition Facts Label (on the principal display panel) is required on shipping containers of commodity weighing 4 to 6-pounds (1.18 to 2.72 kg).***



**EXHIBIT 2**  
**USDA Label Information for Deli-Style Turkey Breast**

Marking Information: USDA labeling information shall be printed on the principal display panel of each shipping container as provided in EXHIBIT 1. Markings shall be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied or to containers. The size and number of packages and net weight shall be completed. The UPC 14-digit 12/5 code (see 746.3 for appropriate code), symbol and code, must be shown in the lower right-hand corner of the principal display panel. The USDA symbol, **EXHIBIT 6**, 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 shall be printed on the “TOP PANEL” or principal display panel. The processor’s name and address shall indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.

	
<h2 style="margin: 0;">FROZEN FULLY COOKED DELI-STYLE TURKEY BREAST</h2>	
Ingredients:  (Food Allergen Statement, Shall Be Placed Here)	Required Nutrition Facts Label Shall Be Placed Here
Processor’s Name, Address, and Phone	
<h3 style="margin: 0;">KEEP FROZEN</h3>	
____ Pound Packages ____ Packages Net Weight ____ LBS. (____ KG)	DATE PACKED <u>Month, Day, and Year</u>  UPC Symbol and Code

**EXHIBIT 3**  
**USDA Label Information for Deli-Style Smoked Turkey Breast**

Marking Information: USDA labeling information shall be printed on the principal display panel of each shipping container as provided in EXHIBIT 1. Markings shall be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. <sup>1</sup>The identification of *smoking method(s)* used below is provided only as an example. The processor shall designate the applicable smoking method used on each label and the labeling must be approved by FSIS. The size and number of packages and net weight shall be completed. The UPC 14-digit 12/5 code (see 746.7 for appropriate code), symbol and code, shall be shown in the lower right-hand corner of the principal display panel. The USDA symbol, **EXHIBIT 6**, must be a minimum of 2.25 inches (5.72 cm) in height and shall be printed on the "TOP PANEL" or principal display panel. The processor's name, address, and phone number shall be printed on the "TOP PANEL" or principal display panel. The processor's name and address may indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.



**FROZEN FULLY COOKED  
DELI-STYLE  
SMOKED TURKEY BREAST**  
**Smoke Flavor Added (as applicable)<sup>1</sup>**

Ingredients:  
(Food Allergen Statement,  
Shall Be Placed Here)

Processor's  
Name, Address, and Phone

Required  
Nutrition Facts Label  
Shall Be Placed Here

**KEEP FROZEN**



\_\_\_ Pound Packages  
\_\_\_ Packages Net Weight  
\_\_\_ LBS. (\_\_\_ KG)

DATE PACKED Month, Day, and Year

UPC Symbol and Code

**EXHIBIT 4**  
**USDA Label Information for Sliced Deli-Style Turkey Breast**

Marking Information: USDA labeling information shall be printed on the principal display panel of each shipping container as provided in EXHIBIT 1. Markings shall be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied or to containers. The size and number of packages and net weight shall be completed. The UPC 14-digit 12/5 code (see 746.9 for appropriate code), symbol and code, shall be shown in the lower right-hand corner of the principal display panel. The USDA symbol, **EXHIBIT 6**, shall 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 shall be printed on the "TOP PANEL" or principal display panel. The processor's name and address shall indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.

	
<h2 style="margin: 0;">FROZEN FULLY COOKED SLICED DELI-STYLE TURKEY BREAST</h2>	
Ingredients:  (Food Allergen Statement, Shall Be Placed Here)	Required Nutrition Facts Label Shall Be Placed Here
Processor's Name, Address, and Phone	
<h3 style="margin: 0;">KEEP FROZEN</h3>	
____ Pound Packages ____ Packages Net Weight ____ LBS. (____ KG)	DATE PACKED <u>Month, Day, and Year</u>  UPC Symbol and Code

**EXHIBIT 5**  
**USDA Label Information for Deli-Style Smoked Sliced Turkey Breast**

Marking Information: USDA labeling information shall be printed on the principal display panel of each shipping container as provided in EXHIBIT 1. Markings shall be legibly preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. <sup>1</sup>The identification of *smoking method(s)* used below is provided only as an example. The processor shall designate the applicable smoking method used on each label and the labeling must be approved by FSIS. The size and number of packages and net weight shall be completed. The UPC 14-digit 12/5 code (see 746.7 for appropriate code), symbol and code, shall be shown in the lower right-hand corner of the principal display panel. The USDA symbol, **EXHIBIT 6**, must be a minimum of 2.25 inches (5.72 cm) in height and shall be printed on the "TOP PANEL" or principal display panel. The processor's name, address, and phone number shall be printed on the "TOP PANEL" or principal display panel. The processor's name and address may indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.



**FROZEN FULLY COOKED  
DELI-STYLE  
SMOKED SLICED TURKEY BREAST**  
**Smoke Flavor Added (as applicable)<sup>1</sup>**

Ingredients:  
(Food Allergen Statement,  
Shall Be Placed Here)

Processor's  
Name, Address, and Phone

Required  
Nutrition Facts Label  
Shall Be Placed Here

**KEEP FROZEN**

\_\_\_ Pound Packages  
\_\_\_ Packages Net Weight  
\_\_\_ LBS. (\_\_\_ KG)

DATE PACKED Month, Day, and Year

UPC Symbol and Code