



PATCH # 073

DOCUMENT: Canned Ripe Olive Inspection Instructions, January 1997

REMARKS: Approved Equivalent Methods for Measuring Sodium Chloride in Olive Brine

The salt meter method for measuring sodium chloride in olive brine has been approved for use. Page 3.22, Section B, Number 2 will be revised to read as follows:

2. Flavor

The factor of flavor (organoleptic) is to be scored as a prerequisite for each sample unit. Grade A and B must have a good flavor. Flavor may be affected by improper processing procedures. Canned olives may acquire a metallic flavor due to the length of time the product has been canned. Since there may be a flavor variation in the olives within a container, several olives from each line check sample should be tasted for flavor. Salt determination will be made on all lots.

Dual Star meters have been approved for use in making salt determinations on olive brine.

To make NaCl solution:

1.6560 grams of Sodium Chloride (NaCl) to 1000 mL distilled water. Mix well.

Set up the meter and electrode as in the instruction books.

To check the slope, see page 4 of the User Guide for the electrode:

- 100 mL water,
- add 2 mL ISA,
- add 1 mL sodium chloride solution—mix
- Measure.
- meter will read “Ready”.
- Record reading
- Add 10 mL NaCl solution.
- Measure.
- meter will read “Ready”.

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- Record reading.
- Subtract second reading from the first reading. It should be 54---60. (temp at 25 C)

Process for using a Dual Star salt meter measuring for salt in olive brine.

- Into a tall 200 mL beaker--100 mL NaCl solution.
- Add 2 mL Ionic strength adjuster (ISA)
- Place beaker on stirrer and put in electrode
- Turn on stirrer
- Turn power on meter
- Use channel setup during the Start up procedures
- Wait until meter reads “Ready”, then
Add 10 mL of olive brine to the NaCl solution, press start
- When meter reads “Ready” record reading
- On the following table: under the “ ΔE monov.” column find the reading from the meter.
- Use the “25°C” column to find the corresponding value.
- Multiply this by 0.1.
- Multiply by 1.6487.
- This gives the % salt
- Convert the % salt to °salometer from Appendix G of this Manual

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Sample addition table for an added volume one-tenth the standard solution volume. Slopes (in units of mv per decade) in the column headings are for monovalent or gas-sensing electrodes. For divalent electrodes, double the observed electrode slope before using the table.

ΔE monov.	ΔE div.	15°C (57.2)	20°C (58.2)	25°C (59.2)	30°C (60.1)	ΔE monov.	ΔE div.	15°C (57.2)	20°C (58.2)	25°C (59.2)	30°C (60.1)
5.0	2.5	3.4552	3.4091	3.3646	3.3217	18.0	9.0	12.719	12.440	12.173	11.918
5.2	2.6	3.5641	3.5157	3.4691	3.4241	18.5	9.3	13.181	12.888	12.609	12.341
5.4	2.7	3.6739	3.6232	3.5744	3.5274	19.0	9.5	13.653	13.346	13.053	12.773
5.6	2.8	3.7845	3.7315	3.6805	3.6314	19.5	9.8	14.135	13.813	13.506	13.214
5.8	2.9	3.8960	3.8407	3.7875	3.7362	20.0	10.0	14.626	14.289	13.969	13.663
6.0	3.0	4.0085	3.9508	3.8953	3.8418	20.5	10.3	15.127	14.775	14.440	14.120
6.2	3.1	4.1218	4.0618	4.0039	3.9483	21.0	10.5	15.638	15.271	14.920	14.586
6.4	3.2	4.2361	4.1736	4.1134	4.0555	21.5	10.8	16.160	15.776	15.410	15.062
6.6	3.3	4.3513	4.2863	4.2238	4.1636	22.0	11.0	16.692	16.292	15.910	15.546
6.8	3.4	4.4674	4.3999	4.3350	4.2725	22.5	11.3	17.236	16.817	16.419	16.040
7.0	3.5	4.5845	4.5144	4.4471	4.3822	23.0	11.5	17.790	17.354	16.939	16.544
7.2	3.6	4.7025	4.6299	4.5600	4.4928	23.5	11.8	18.355	17.901	17.469	17.057
7.4	3.7	4.8215	4.7462	4.6739	4.6043	24.0	12.0	18.933	18.459	18.009	17.580
7.6	3.8	4.9414	4.8635	4.7886	4.7166	24.5	12.3	19.521	19.028	18.559	18.113
7.8	3.9	5.0623	4.9817	4.9043	4.8297	25.0	12.5	20.122	19.609	19.121	18.657
8.0	4.0	5.1842	5.1009	5.0208	4.9438	25.5	12.8	20.735	20.201	19.694	19.211
8.2	4.1	5.3070	5.2209	5.1382	5.0587	26.0	13.0	21.361	20.805	20.277	19.776
8.4	4.2	5.4309	5.3420	5.2566	5.1745	26.5	13.3	21.999	21.421	20.873	20.351
8.6	4.3	5.5557	5.4640	5.3759	5.2911	27.0	13.5	22.650	22.050	21.480	20.938
8.8	4.4	5.6816	5.5870	5.4961	5.4087	27.5	13.8	23.315	22.691	22.099	21.536
9.0	4.5	5.8085	5.7110	5.6173	5.5272	28.0	14.0	23.993	23.344	22.730	22.146
9.2	4.6	5.9364	5.8359	5.7394	5.6466	28.5	14.3	24.684	24.011	23.373	22.768
9.4	4.7	6.0653	5.9618	5.8624	5.7669	29.0	14.5	25.390	24.692	24.029	23.401
9.6	4.8	6.1953	6.0888	5.9865	5.8881	29.5	14.8	26.111	25.386	24.699	24.047
9.8	4.9	6.3264	6.2167	6.1115	6.0103	30.0	15.0	26.846	26.093	25.301	24.705
10.0	5.0	6.4585	6.3457	6.2374	6.1334	31.0	15.5	28.361	27.551	26.786	26.060
10.2	5.1	6.5916	6.4757	6.3644	6.2575	32.0	16.0	29.938	29.069	28.247	27.468
10.4	5.2	6.7259	6.6067	6.4923	6.3825	33.0	16.5	31.580	30.647	29.765	28.931
10.6	5.3	6.8612	6.7388	6.6213	6.5085	34.0	17.0	33.290	32.289	31.344	30.451
10.8	5.4	6.9977	6.8719	6.7512	6.6354	35.0	17.5	35.070	33.998	32.986	32.030
11.0	5.5	7.1352	7.0061	6.8822	6.7633	36.0	18.0	36.923	35.775	34.693	33.671
11.2	5.6	7.2739	7.1413	7.0142	6.8922	37.0	18.5	38.852	37.625	36.468	35.376
11.4	5.7	7.4136	7.2777	7.1473	7.0221	38.0	19.0	40.861	39.549	38.313	37.148
11.6	5.8	7.5545	7.4151	7.2813	7.1530	39.0	19.5	42.952	41.551	40.232	38.989
11.8	5.9	7.6966	7.5536	7.4164	7.2849	40.0	20.0	45.129	43.633	42.227	40.901
12.0	6.0	7.8398	7.6932	7.5526	7.4178	41.0	20.5	47.396	45.800	44.301	42.889
12.2	6.1	7.9841	7.8339	7.6899	7.5517	42.0	21.0	49.756	48.055	46.457	44.953
12.4	6.2	8.1296	7.9757	7.8282	7.6867	43.0	21.5	52.213	50.400	48.699	47.099
12.6	6.3	8.2763	8.1187	7.9676	7.8227	44.0	22.0	54.771	52.841	51.030	49.328
12.8	6.4	8.4242	8.2627	8.1081	7.9597	45.0	22.5	57.434	55.379	53.453	51.645
13.0	6.5	8.5733	8.4080	8.2496	8.0978	46.0	23.0	60.207	58.021	55.973	54.051
13.2	6.6	8.7236	8.5544	8.3923	8.2370	47.0	23.5	63.094	60.769	58.593	56.552
13.4	6.7	8.8751	8.7019	8.5361	8.3772	48.0	24.0	66.099	63.628	61.317	59.151
13.6	6.8	9.0278	8.8507	8.6811	8.5185	49.0	24.5	69.228	66.603	64.149	61.850
13.8	6.9	9.1817	9.0006	8.8271	8.6609	50.0	25.0	72.486	69.698	67.093	64.656
14.0	7.0	9.3370	9.1517	8.9743	8.8044	51.0	25.5	75.877	72.918	70.155	67.570
14.2	7.1	9.4934	9.3040	9.1227	8.9490	52.0	26.0	79.408	76.268	73.338	70.599
14.4	7.2	9.6512	9.4575	9.2722	9.0947	53.0	26.5	83.084	79.753	76.647	73.746
14.6	7.3	9.8102	9.6123	9.4229	9.2415	54.0	27.0	86.912	83.379	80.088	77.015
14.8	7.4	9.9704	9.7687	9.5748	9.3895	55.0	27.5	90.897	87.152	83.665	80.412
15.0	7.5	10.132	9.9255	9.7278	9.5386	56.0	28.0	95.045	91.077	87.385	83.942
15.5	7.8	10.542	10.324	10.116	9.9164	57.0	28.5	99.364	95.161	91.252	87.610
16.0	8.0	10.960	10.731	10.511	10.302	58.0	29.0	103.86	99.409	95.273	91.421
16.5	8.3	11.387	11.145	10.915	10.694	59.0	29.5	108.54	103.83	99.453	95.381
17.0	8.5	11.822	11.568	11.326	11.094	60.0	30.0	113.42	108.43	103.80	99.495
17.5	8.8	12.266	12.000	11.745	11.502						

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United States
Department of
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Agricultural
Marketing
Service

Fruit and
Vegetable
Division

Processed
Products
Branch

Grading Manual for Canned Ripe Olives

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SECTION 1
GENERAL INFORMATION

I. General

A. Purpose

These instructions are designed to furnish technical information to guide inspectors when inspecting and certifying olives. They provide background information on producing areas, total production figures, varieties, processing procedures, and packaging.

They also provide procedures which inspectors shall follow when assigned to perform inspections under Olive Marketing Order No. 932.

B. Scope of Application

These instructions are designed primarily to cover inspection of olives in California to determine compliance with Olive Marketing Order No. 932. However, much of this instruction is equally applicable to inspection of olives, irrespective of point of processing, and which are not regulated by the order.

II. WHERE INSPECTION IS TO BE MADE

A. Under Olive Marketing Order

Inspections under the Olive Marketing Order shall be made at any plant of a handler where he processes olives and at which the handler has made available facilities for in-line inspection which are satisfactory to the inspection service and the committee.

B. Other Than Marketing Order

Inspection Services may be furnished in accordance with the terms and conditions specified in the Regulations and Branch policy, as with any other processed product.

III. WHEN INSPECTION MAY BE DECLINED

- A. If satisfactory in-line facilities are not available.
- B. If abuse, intimidations, or threats of bodily harm are made against the inspector.
- C. If undue interference is made with the inspection operation.

III. WHEN INSPECTION MAY BE DECLINED (continued)

- D. If the inspection service has been notified by State or Federal Regulatory Authorities that the lot being tendered for inspection was prepared, stored, or handled under insanitary conditions, rendering such lot in violation of State or Federal laws and regulations.
- E. For non-payment of inspection fees.
- F. When the product is not properly identifiable by code or other marks.
- G. If the product is not accessible for adequate sampling.
- H. For any other reason cited in the Regulations Governing Inspection and Certification of Processed Fruits and Vegetables, and Related Products, as a basis for rejecting an application for inspection.

IV. INSPECTION EQUIPMENT, METHODS OF TESTS & REPORTING FORMS

The inspector shall use equipment, methods of tests, and reporting forms as directed by his supervisor and which are adequate for determining the grade, size and condition of the olives and for any other related services as approved by the Branch.

V. PRODUCTION

A. Importance

The olive is firmly established as one of California's important specialty crops with a ten year average of about 70,000 tons produced annually. Olives are an alternate year bearing crop, thus production varies from 25,000 tons to 150,000 tons. The only other state growing olives commercially is Arizona, with an annual production of about 100 tons. Thus, California dominates the domestic scene, though it produces only one percent of the world crop.

Practically all of the olives produced in California are canned ripe olives and green-ripe olives. Olives crushed for oil and Spanish green olives are other major market outlets. Minor quantities are processed as Greek style olives, Sicilian style olives, and canned tree-ripened olives. Small quantities are sold fresh for home processing.

V. PRODUCTION (continued)

The olives produced and processed in California are sold throughout the United States and to a minor extent throughout the world markets. Approximately one-half of such olives are sold in markets within the State of California.

B. Utilization of the Olive Crop

In 1981-82, of the 43,000 tons of olives produced, 37,800 tons were canned and 5,200 tons were used for miscellaneous products, including Spanish-green olives, and fresh utilization.

C. Producing Areas in California

Conditions for olive production are particularly satisfactory in the interior valleys of Central California, and in the surrounding foothills. Almost two-thirds of the acreage is in Butte, Tehama and Tulare Counties.

These three counties form the nuclei of two major producing areas located in South San Joaquin and North Sacramento Valleys.

About 40 percent of the olive acreage is located in five counties of the South San Joaquin District. These are Tulare, Fresno, Madera, Kings and Kern Counties.

Five counties in the Northern Sacramento Valley, contain 38 percent of the acreage. These are Butte, Tehama, Glenn, Shasta and Yuba.

The remaining 22 percent of the acreage is scattered among 24 of the remaining counties.

New acreage is being planted throughout the state. Heavy concentration is in Tulare County and the West Side of the Lower San Joaquin Valley.

Over the past years olive acreage has tended to concentrate in the major producing areas. The acreage has also changed in varietal composition. The average bearing acreage falls between 34,000 and 35,000 acres. In 1981 there were over 1,200 non-bearing acres.

D. Varieties and Types of Olives

Numerous olive varieties are cultivated in other countries, and most may be grown successfully in California.

However, 98 percent of the State's acreage is planted in five varieties which have proved most profitable. These are: Mission, Manzanillo, Sevillano, Ascolano, and Barouni. Mission and Manzanillo are the leading varieties, representing three-quarters of the total production. Next in order are Sevillano, Ascolano, and Barouni.

Varieties vary widely in fruit size, oil content, flesh/pit ratio, maturity dates, tree growth, productiveness, ease of handling, and in other respects. Growers, therefore, select varieties to meet the needs of available and potential markets.

MANZANILLO

Origin and Acreage

Manzanillo is a native of Spain, where for many years it has been grown as one of the leading table varieties. Large quantities are now grown and processed there in brine for export as fermented-green olives. This variety can also be found in Portugal, France, Italy, Palestine, Australia, Argentina, and Chile.

In 1875 it was brought into California from Spain and was soon found to be one of the best varieties imported from the Mediterranean countries.

In 1980 Manzanillo constituted 21,422 of the 37,494 acres of bearing olives in California, or about 61% of the total bearing acres.

The Fruit

It is cherry-shaped, larger and fleshier than the Mission. The fruit has a high oil content and is easy to process. It matures early enough to avoid frost damage. It bears singly--rarely in twos or threes--on variably sized short or long peduncles (stems). The fruit is tough in texture, uniform in shape--a slight or broad oval--and medium in size. The base is round or hollow, often slightly depressed on two sides; the stem-end cavity is prominent, and the apex round. The surface is spotted regularly with tiny, whitish lenticels. These become less pronounced toward maturity, when the fruit becomes velvet black.

Statistics on crop and acreage taken from "California Olive Industry Statistics - 1980-81 of California Olive Committee."

Uses of the Fruit

This variety is adaptable to several processing methods. It is used largely in the production of green and canned ripe olives. Some fruits, however, are processed as Spanish-green fermented pickles. By December, Manzanillo usually contain enough oil--18 to 20 percent of the fresh weight--to warrant their use for oil extraction. Pickling, however, is usually more profitable. It is used in Spain for green pickling and is very popular as a stuffed green olive.

MISSION

Origin and Acreage

Mission was introduced into California by seeds brought from San Blas, Mexico, in 1769, and planted at Mission San Diego by Junipero Serra and by Don Jose de Galves. The trees were soon in production at all the missions along the California coast. As agricultural development of the state began, commercial olive orchards were planted, the nursery stock for which was grown from the cuttings secured from the various missions. By 1875, the Mission variety predominated in the 11,500 bearing olive trees in California, and until the late 1940's, it was the most widely planted olive in the state.

The Mission variety is now third in importance behind Manzanillo and Sevillano.

In 1980 Mission variety constituted 4,315 of the 37,494 acres of the bearing olives in California.

Butte County is the major contributor of Mission acreage, next is the Corning district. In Tulare County, many of the Mission orchards have been grafted to the Manzanillo variety.

The Fruit

It is of medium size and oblong in shape with a pronounced point at the blossom end. The fruit has a high oil content, a low flesh-pit ratio, and is easy to process. It is subject to freezing injury because of late maturity.

Mission are uniformly high in quality but are handicapped by their size. Few fruits of the "Extra Large" or larger size are produced. To meet the present demand for large olives, other varieties must be used.

The Fruit (continued)

Several strains of Mission are grown in California. Each differs from the other, chiefly in fruit characteristics.

Uses of the Fruit

The Mission variety is relatively easy to handle during processing and results in a product of high quality and uniformity. It is used in the production of black-ripe and green-ripe olives and for the Greek style, salt-cure process.

An appreciable percentage of the crop is used for oil extraction. Undersized and frost damaged fruits of this variety may be salvaged for this purpose. The oil content of Mission is the highest of all the commercial varieties. Expressed as a percentage of the fresh weight, it averages 20 to 24 percent, differing somewhat according to locality and perhaps with strains in the variety.

SEVILLANO

Origin and Acreage

Sevillano derives its name from Sevilla, the province in Spain where it originated. It is grown there in large quantities, which are exported as Spanish-green fermented olives. This variety is also grown commercially in France, Palestine, Argentina, Portugal, Algeria, Chile, and Australia.

Sevillano was brought into California about 1885. When the emphasis of the California olive industry shifted in 1910 from oil to pickling, this variety was widely used in grafting trees of the small-fruit oil types, especially in the Corning area. Sevillano now comprises 75 percent of the bearing olive acreage in that region. It is not widely planted in Butte, Sacramento, or Tulare Counties, constituting only about 5 percent of the bearing acreage of olives in those counties. In 1980 the Sevillano variety constituted 8,789 of the 37,494 acres of the bearing olives in California.

The Fruit

Sevillano olives are the largest in size of any variety grown in California and are about three times as heavy as the Mission or Manzanillo. Although the fruit has a lower quality, a premium price is paid because of its large size. This variety is rarely crushed because of its low oil content and its desirability for canning. It is the most important variety used in Spain for green pickling. There are several known strains differing principally in fruit and pit characteristics.

Uses of the Fruit

Most packers consider this variety more difficult to process and the quality somewhat lower than either Mission or Manzanillo. If harvested at the proper degree of ripeness (at an earlier stage than for the two varieties mentioned), a very acceptable product can be made.

Sevillano's chief use is as canned ripe olives--and to a lesser extent as green fermented olives (Spanish and Sicilian types). Because of its relatively low oil content, very little of the crop is processed for oil.

ASCOLANO

Origin and Acreage

Ascolano was brought into California from Italy about 1885. It is one of the standard Italian pickling olives, though it is not widely planted in any other olive producing countries except Argentina. Some small acreages are found in Palestine and Chile.

About 700 acres were producing in California in 1948, constituting approximately 3 percent of the state's total bearing acreage. The most extensive plantings are in the San Joaquin Valley; Kings County has 250 acres and Tulare, 145. Only 83 acres are reported in Butte County, 38 in Sacramento County, and scattered trees in the Corning area. In 1980 the Ascolano variety constituted 1,135 of the 37,494 acres of the bearing olives in California.

The Fruit

The Ascolano also has large fruit. It has a high flesh-pit ratio and produces a fine table olive. The fruit is susceptible to bruising during harvest and processing.

Uses of the Fruit

Ascolano is well suited for canned ripe olives. It is not adapted to green pickling because "salt shrivel" is severe during fermentation and the fruit becomes almost white after fermentation. Occasionally this variety is used for oil extraction but is not crushed often because of higher prices for canning use.

BAROUNI

Origin and Acreage

One of the standard table olives in Tunisia, North Africa, Barouni was introduced into California in 1905 by the U.S. Department of Agriculture. Other olive producing countries do not grow it extensively. It is the most recent variety to be planted on a commercial scale in California. It was widely planted throughout the state, particularly in Butte County, about 1920 and 1925.

California has about 340 acres of this variety, a third of the acreage being in Butte County. The remainder of the acreage is in small plantings throughout the State. New plantings of Barouni are being made in California.

The Fruit

The Barouni variety bears well each year. The fruit is almost as large as the Ascolano. The fruit has a low flesh-pit ratio, is difficult to process, and yields a product of lower quality. This variety comprises a large portion of fresh shipments. Fresh shipping is the major outlet for the variety.

Use of the Fruit

This variety is difficult to process satisfactorily. An appreciable quantity, however, is canned ripe. A large percentage (500 to 700 tons) is shipped fresh to Eastern cities, for home-processing. Barouni is difficult to process as Spanish-green because of the reddish color that sometimes develops near the pit and because of its tough and woody texture after processing. Because of its relatively low oil content --13 to 18 percent -- it is of very little value for oil extraction.

OBLIZA

This variety has medium sized fruit. It resembles the Mission variety in shape and size. However, the pit is of different shape. It processes similar to the Mission variety and is used for canning. The tonnage of this variety is small.

VI. HANDLING OPERATIONS

A. Receiving

Mission and Manzanillo olives are at the optimum stage of maturity for canning ripe when the color of the fruit has become straw color. Fruit that has arrived at the jet-black stage will soften in the process and that which is too green in color yields a tough product of poor flavor. Sevillano and Ascolano olives are picked at a less mature stage since they soften severely during processing if the fruit shows much color when picked.

In the early producing areas in California, the picking season begins about September 15th, and in favorable seasons may last until the first of December.

Harvested olives are delivered to the processing plant of a handler, generally weighed, and then passed over cleaning and size-grading equipment to remove the trash and separate the olives according to predetermined size classifications.

B. Sizing

Each lot of natural condition olives delivered to a handler for use in the production of packaged olives, will be size graded under the supervision of the Federal-State Inspection Service. The certification will show quantities, by weight, in each size designation, and the quantity of olives classified as culls by the handler.

In most canneries the olives are graded for size before they are placed in the storage or processing vats, usually with a grader that consists of moving diverging steel cables.

The unit for designation of the different size grades is in millimeters. The largest size designation in diameter exceeds 26 mm, and the smallest size normally used for canning is 16 mm in diameter. Olives smaller than this are used for Spanish Type, oil, and other products.

After size-grading, the olives are channeled to the various uses. The smallest olives that have no value are discarded.

Some sizes are excluded from being packed as canned ripe olives by the Marketing Order. These sizes may be processed as Spanish-green olives or along with defective fruit, which the processor does not intend to market as packaged olives, may be diverted to non canning purposes.

C. Storage

Olives that are to be processed into ripe olives may be placed in processing vats immediately, but more than often are stored in large redwood vats or plastic or fiberglass tanks, in brine or salt free solution, pending processing at a later date.

D. Cull Olives

Until such time as the Secretary of Agriculture defines "culls", handlers will classify and report the quantity of olives considered as "culls".

Each handler, under the supervision of the Federal-State Inspection Service, or the Processed Products Branch will dispose of the "culls" in accordance with Marketing Order Regulations. Disposition will be other than canned ripe olives.

E. Processing of Black-Ripe Olives

Oxidation

As needed, the olives are transferred from the storage vats to processing vats for a period of 5 to 14 days where they are immersed in several dilute lye solutions, and continually exposed to air pumped through the solution; since exposure to oxygen is necessary to the development of the dark brown to black color typical of the "ripe" style of olives. Ferrous Gluconate is sometimes added to the processing brine or to the canning brine to set the dark color of the olives. Fruit that is to be packaged as "green-ripe" olives is processed in a manner similar to that of "ripe" olives except that the fruit is placed in the processing vats immediately after size-grading and is protected from exposure to air so as to maintain the green color of the fruit.

The "tree-ripened" style of olives are harvested at more advanced state of maturity and are processed in a similar manner to green-ripe olives. This style is not covered by the U.S. standards and presently is excluded from the Order.

Lye Treatment

Prior to the last lye treatment, the olives are run over a "needle board" to facilitate the lye penetration. The last lye solution is used for the purpose of destroying the bitterness, resulting in a better flavor. Therefore, it is customary to allow the last lye solution to penetrate to the pit of the fruit. Following the last lye treatment the olives are leached with water until they no longer contain either sodium hydroxide or bitterness. During leaching of the lye, care must be taken to prevent fermentation and softening. Color is most permanent during retorting if the olives are washed until the pH value is about 7.5. After all of the lye has been removed from the fruit, it is sometimes stored in a brine of about 2 to 3 percent salt.

Pitting and Sorting

From 70 to 80 percent of the total quantity of olives that are processed into the various types of ripe olives are pitted prior to packing.

Filling

The cans are filled by weight in much the same manner as other fruits. A hot brine of 2-1/2 to 3-1/2 percent salt is added. The brine is added boiling hot, in most cases, from an ordinary fruit syruper or from an open pipe. Occasionally the brine is added cold in the same manner as described above.

About 50 percent of the ripe olive pack is in 300 x 407 size containers. Smaller size containers are used for about 2 percent of the pack, and No. 10 can size for the remainder. This pattern represents a change from former years. The use of No. 10 has increased. The cans are lined with a protective enamel in order to prevent bleaching of the color after canning.

Closing, Sterilization and Casing

The cans are sealed by means of a double-seaming machine (usually steam-flow or vacuum seamer) and are then sterilized in steam pressure retorts at 240° F. for 60 minutes. This time and temperature of processing render the olives thoroughly sterile. The recent trend for packers is the use of continuous cookers. This type of operation has started a revolution in the olive industry. It has increased production and reduced labor cost to the packers considerably. After cooking and cooling, the cans are labeled and cased by any of the usual commercial methods.

F. Processing of Green Olives

As with black-ripe type, olives intended for Spanish-green are treated with lye to remove the bitter principle. The lye solution is allowed to penetrate to about one-half to two-thirds of the way to the pit. If the lye solution is too strong or too prolonged, all of the bitterness is removed. By removing the lye solution before it has completely reached the pits, a small amount of untreated bitter flesh remains and imparts a pleasing flavor to the olive. The lye is removed from the olives by several changes of water.

The olives are stored in barrels in a brine of about 11 percent salt in which lactic acid fermentation develops in much the same manner as in dill pickles.

The barrels are kept completely filled with the brine and sealed except for a small vent for escape of gas. When gas production ceases, the barrels are sealed. The pH value must be maintained below 4.0 for good keeping of the barreled olives.

The processed fruit is passed over sorting belts and is carefully graded for color and quality. The olives may or may not be size graded again at this stage.

The olives are packed in glass or barrels, in fresh brine of about 7 percent salt.

Pasteurization is done on olives during processing at 170 to 175° F. for 30 minutes. The heating must be done very carefully in order that the flesh of the olives will not be broken by contact with the jets of steam or by too violent agitation. One heating of this sort is usually sufficient to check fermentation and softening.

If the salt concentration is too low or the acidity insufficient, bacterial softening is very apt to occur. At the first sign of such spoilage the brine should be acidified with 0.5 percent lactic acid or 0.25 percent acetic acid.

G. Processing of Other Olives

Greek Style Olives, or Oil Cured Olives

Properly matured olives which have been cured by contact with dry salt, and after proper curing have been coated with olive oil; or packed in vinegar and brine. Almost the entire pack consists of the Mission variety.

Sicilian Style Olives

Sound green olives fermented in brine and packed with garlic, peppers and spices. Their production comes almost entirely from surplus Sevillano olives.

Greek and Sicilian style olives are sold both in glass or in bulk at the retail level.

Olive Products

Next in importance to the whole and pitted styles of ripe olives, are sliced, segmented, and chopped ripe olives. A few canners pack a small volume of halved olives -- i.e., pitted olives which are cut lengthwise. Finally as a salvage outlet, the large pieces broken during the pitting operation are packed as broken pitted olives.

VII. FOOD AND DRUG REQUIREMENTS

Federal

Olives are subject to the same general requirements as are all foodstuffs, namely, they must be packed under sanitary conditions, must not be adulterated, or contaminated with decay, insects, or filth or any deleterious substance, and must be truthfully labeled.

State

The State Board of Health of California inspects the Olive processing plants frequently and requires that every cannery retain a temperature chart of each lot of olives sterilized. Also the cans of olives must be given an identifying mark in the form of an embossed code.

The controlling legislation for size-grade designations for canned ripe olives is the California Ripe Olive Standardization Act of 1931, with subsequent amendments. USDA Standards reflect the size-grade enacted into state law.

The state law recognizes 7 designations for size-grades: Small, Medium, Large, Extra Large, Jumbo, Colossal and Super Colossal.

"Mixed Sizes" are no longer allowed under the Marketing Order.

The Marketing Order established two additional limited usage sizes: Petite and Sub-Petite.

VIII. HANDLING DISPUTES

A. When Results Are Questioned and Certificate Has Not Been Issued:

1. Action by Inspector

The inspector shall promptly contact his immediate supervisor. The original sample shall be reviewed by the supervisor with the inspector and the results shall be recorded on the work sheet and certification made of the lot. If the applicant or handler is still dissatisfied or if there is disagreement between the inspector and his immediate supervisor, the Officer-in-Charge shall be contacted to review the sample. There may be instances where the Officer-in-Charge will contact higher supervisory levels prior to rendering a decision, particularly if there is any doubt on interpretation of grade factors.

In the absence of the immediate supervisor, the next level of supervision shall be contacted. In all instances, the original sample shall be reviewed with the inspector.

2. Action by Supervisors

Supervisors, if uncertain as to correct interpretation, should contact the Officer-in-Charge. If there is still a question on procedure or grade interpretation, the Officer-in-Charge should contact the Regional Director for advice. Whenever possible it is preferable to settle disputes without calling on the Regional Director. However, no supervisor should hesitate to contact the Regional Director for assistance, particularly where time is of the essence. When it is determined that additional samples are necessary, they shall be drawn by the supervisor. All samples shall be reviewed with the inspector.

As soon as a conclusion is reached as to grade, the inspector should certify the product in the usual manner. If there continues to be a question over the final grade as certified, the inspector (or supervisor) shall recommend to the interested party that he request an appeal inspection.

3. Action by Officer-in-Charge

The Officer-in-Charge, in the absence of other supervisors, shall review samples with the inspector as outlined above. He shall maintain a close working relationship with the supervisors in obtaining accuracy on procedures and grade interpretations. Except in the case of a request for an appeal inspection, he shall refer direct packer inquiry to subordinate supervisors, if one is assigned, who will contact the inspector to review the inspection.

B. When Dispute Arises After Certification has been Completed

1. Action by Inspector

When results are questioned by an interested party, the inspector shall recommend the appeal procedure and promptly notify his supervisor.

2. Action by Supervisor

The supervisor shall, upon receipt of "Request for Appeal Inspection," promptly notify the Officer-in-Charge and follow instructions for Appeal Inspections.

3. Action by the Officer-in-Charge

The Officer-in-Charge shall contact the Regional office for assignment of the inspectors or supervisors who will conduct the appeal. He will participate in the appeal, if assigned, following procedures outlined in these instructions for canned olives.

4. Documentation of Inspection Records

Particular attention shall be given to proper documentation of all inspection records; that is, any certification shall be supported by properly completed request for certification (when used), score sheet and other work papers.

IX. MARKETING AGREEMENTS AND ORDERS

Marketing Agreements and Orders are authorized under the Agricultural Marketing Agreement Act of 1937. Briefly stated a Marketing Agreement involves handlers while a Marketing Order involves growers. Both are intended to serve the same purpose -- to regulate the marketing of a crop so that returns to the producers are improved. Thus marketing agreements and marketing orders are usually found together.

This particular marketing agreement and order (No. 932) pertains to olives grown in California.

Incoming inspection of olives brought to handlers for processing is under the supervision of the Fresh Products Branch. Olives will be certified by the Federal-State inspectors as to weight by sizes and the quantity classified as "culls" by the handlers.

Inspection and certification of processed olives is under the supervision of the Processed Products Branch. Olives will be certified as to grade and size.

Sizing of olives receives particular attention because of price differentials. Size of the olives affects the return to the grower. The price received by the handler is also affected by the size of the processed product as marketed. Therefore, sizing is important to all concerned and is regulated in the order.

The California Olive Committee, consisting of eight "handler" members and eight "producer" members, handles details of the administration of the order. The committee may be increased by one public member who is not a producer or handler. Both inspection services perform their services under a Memorandum of Understanding with the COC. Reports and records as to acquisition, sales, uses and shipments of olives are maintained by the Committee.

Enforcement of the regulations is primarily the job of the Federal Government, but the Advisory Committee under the order is responsible for investigating and reporting complaints of violation.

This is a program by the industry and for the industry. The cooperation of all the parties concerned is necessary to make it successful.

SECTION 2
SIZE REQUIREMENT TO MEET THE ORDER

I. General

Canned ripe olives (whole or pitted), other than those of the "tree ripened" type, shall conform to the size designation of a "single size" and shall be of a size not smaller than the following applicable minimum size requirements:

- Group I - (Extra Large Size) Ascolano, Barouni, and Saint Agostino varieties.
- Group I - (Extra Large "C") Sevillano and other than above mentioned varieties.
- Group II - (Small Size) Mission and Manzanillo and any other varieties except Obliza.
- Group II - (Medium Size) Obliza variety.

The requirements for size to meet the Marketing Order is explained more fully as outlined in these instructions.

II. SIZE COMPLIANCE UNDER THE MARKETING ORDER

A. Size Certification by the Incoming Inspection Service

1. In crop years when the Secretary authorizes the use of limited size olives for limited use styles, the Marketing Order allows size certification of limited size olives by the Incoming Inspection Service without an outgoing inspection for size.
2. In crop years when the Secretary does not authorize the use of limited size olives for limited use styles, any lot of minimum canning size olives can be size certified by the Incoming Inspection Service without an outgoing inspection for size.
3. As long as Marketing order sizes are in effect, a handler may elect to have any lot of canning size olives size certified by the Incoming Inspection Service also, and later use these olives in the production of packaged olives for whole, pitted, or limited use styles without an outgoing inspection for size designation, provided it met the requirements of an established size certification procedure.

4. When inspected by the Incoming Inspection Service, Olives must be within the average count range in Table I contained herein for the varietal group and meet such further mid point or acceptable count requirements for the average count range in each size.

TABLE I
AVERAGE COUNT RANGES (per pound)

SIZE DESIGNATION	VARIETY GROUP 1		VARIETY GROUP 2	
	except Ascolano Barouni St. Agostino	Ascolano Barouni St. Agostino	Obliza	except Obliza
Small	N/A	N/A	N/A	128-140
Medium	N/A	N/A	106-127	106-127
Large	N/A	N/A	91-105	91-105
Extra Large	65-75	65-90	65-90	65-90
Jumbo	47-60	47-60	47-60	47-60
Colossal	33-46	33-46	33-46	33-46
Super Colossal	32 or less	32 or less	32 or less	32 or less

N/A - Not Applicable

5. The olive handler has the responsibility to inform the Processed Products Inspector of the progress of size-certified olives, and each size certified lot must be kept intact, identified properly, and under surveillance of the Inspection Service. The USDA inspector must be notified prior to the removal of fruit under a yellow HOLD tag.

In order for the size certification of the olives to carry through to the finished product, the handler may not change the size of the olives at anytime during processing and canning.

CALIFORNIA OLIVE COMMITTEE
 INCOMING INSPECTION REQUIREMENTS
 2010-2011

U.S. Standards & Marketing Order Sizes		Acceptable Count Ranges and Mid-Points											
		(Per Pound)											
Size Designation	Avg Count Range Per Pound	Variety Group 1				Variety Group 2							
		Sevillano		Ascolano**		Obliza		Mission/Manzanillo*					
		Acceptable Count Range	Mid Point	Acceptable Count Range	Mid Point	Acceptable Count Range	Mid Point	Acceptable Count Range	Mid Point				
Undersize	226-up	Undersize 106 - UP		Undersize 181 - Up		Undersize 181 - Up		Undersize 206 - Up					
Sub-Petite	181-225							181-205	193				
Petite	141-180							158-174	166	158-174	Ltd 166	158-174	166
Small	128-140							132-138	Ltd 135	136-140	Ltd 138	132-138	135
Medium	106-127							110-122	116	110-122	116	110-122	116
Large	91-105	91-105	98	91-105	98	95-101	98	91-105	98				
Extra-Large Sev "L"	76-90	82-90	Ltd 86	--	--	--	--	--	--				
Extra-Large	65-90	--	--	67-85	72-80	65-88	72-80	65-88	72-80				
Extra-Large Sev "C"	65-75	67-73	70	--	--	--	--	--	--				
Jumbo	47-60	47-60	47-60	47-60	47-60	47-60	47-60	47-60	47-60				
Colossal	33-46	33-46	33-46	33-46	33-46	33-46	33-46	33-46	33-46				
Super Colossal	32 or less	32 or less	32 or less	32 or less	32 or less	32 or less	32 or less	32 or less	32 or less				

* Manzanillo includes Haas

** Ascolano includes St. Agostino and Barouni

 Undersize
 Limited Sizes

CALIFORNIA OLIVE COMMITTEE
 OUTGOING INSPECTION REQUIREMENTS
 2010-2011

SIZE REQUIREMENTS AND PERCENTAGE TOLERANCES							
Size Designation	SEVILLANO		ASCOLANO*		OBLIZA		MISSION/ MANZANILLO**
Undersize	Undersize		Undersize		Undersize		Undersize
Sub-Petite	Undersize						L
Petite			L 35% less than 1/ 180 lb.		L 35% less than 1/ 180 lb.		C
Small							C 128-140
Medium					C 106-127		C 106-127
Large	L 35% less than 1/ 105 lb.	C 91-105		C 91-105		C 91-105	All Sizes 5 % less than 1/ 140 lb.
Extra Large			65-90	65-90		65-90	
Extra Large	C 65-75		All sizes 5 %		All sizes 5 %		
Jumbo	47-60	All sizes 5 %	47-60	47-60		47-60	
Colossal	33-46	less than	33-46	33-46		33-46	
Super Colossal	32 or less	1/ 75 lb.	32 or less	32 or less		32 or less	
	Tolerance (by count) 35% under 1/ 75 but not more than 10% under 1/ 86		Tolerance (by count) 35% under 1/ 105 but not more than 10% under 1/ 113		Tolerance (by count) 35% under 1/ 127 but not more than 7% under 1/ 138		Tolerance (by count) 35% under 1/ 140 but not more than 7% under 1/ 166

* Ascolano includes St. Agostino and Barouni

** Includes Haas variety

L LIMITED USE SIZE and PERCENTAGE TOLERANCES

C Tolerances apply to MINIMUM WHOLE OR PITTED CANNING SIZE:
 Sevillano- Extra Large "C"; Ascolano- Large; Obliza- Medium; Mission/Manzanillo- Small

**SECTION 3
INSPECTION PROCEDURE**

I. GENERAL

Unless otherwise specified, processed (or packed) olives certified as meeting the regulations of the Marketing Order shall meet modified minimum quality requirements for specified styles of canned olives of the ripe type as contained in Section 932.149, (Tables 1, 2, 3, and 4 of this Section).

Imports of canned ripe olives will conform with Section No. 932.149 as well. (Tables 1, 2, 3, and 4 of this Section).

II. GRADE REQUIREMENTS UNDER THE ORDER

- A. Terms used in this section shall have the same meaning as are given to the respective terms in the current U.S. Standards for Grades of Canned Ripe Olives (7 CFR Part 52).

III. SIZE REQUIREMENTS UNDER ORDER

- A. A handler may satisfy these requirements by requesting from the Federal State Inspection Service, a size certification of the olives when natural condition olives are delivered to his receiving station.
- B. Canned whole and pitted ripe olives, other than those of the "tree-ripened" type, shall conform to the size designation of "single size" and meet the requirements as set forth in the U.S. Standards for Grades of Canned Ripe Olives.
- C. Canned ripe olives of the "tree-ripened" type and green olives are currently exempt from the provisions of the order. The committee has adopted a rule to provide for the exemption of tree-ripened type as follows:

TABLE 1 - WHOLE AND PITTED STYLE
(Defects by count per 50 olives)

FLAVOR	Reasonably good; no "off" flavor
FLAVOR (Green Ripe Type)	Free from objectionable flavors of any kind
SALOMETER	Acceptable Range in degrees: 3.0 to 14.0
COLOR	Reasonably uniform with not less than 60% having a color equal or darker than the USDA Composite Color Standard for Ripe Type
CHARACTER	Not more than 5 soft units or 2 excessively soft units
UNIFORMITY OF SIZE	60%, by visual inspection, of the most uniform in size. The diameter of the largest does not exceed the smallest by more than 4mm.
DEFECTS	
Pitter Damage (Pitted Style Only)	15
Major Blemishes	5
Major Wrinkles	5
Pits and Pit Fragments (Pitted Style Only)	Not more than 1.3 % average by count
Major Stems	Not more than 3
HEVM	Not more than 1 unit per sample.
Mutilated	Not more than 3
Mechanical Damage	Not more than 5
Split Pits or Misshapen	Not more than 5

TABLE 2 - SLICED, SEGMENTED (WEDGED), AND HALVED STYLES
(Defects by count per 255 grams)

FLAVOR	Reasonably good; no "off" flavor
SALOMETER	Acceptable Range in degrees: 3.0 to 14.0
COLOR	Reasonably uniform with no units lighter than the USDA Composite Color Standard for Ripe Type
CHARACTER	Not more than 13 grams excessively soft
DEFECTS	
Pits and Pit Fragments	Average of not more than 1 by count per 300 grams
Major Stems	Not more than 3
HEVM	Not more than 2 units per sample
Broken Pieces and End Caps	Not more than 125 grams by weight

TABLE 3 - CHOPPED STYLE
(Defects by count per 255 grams)

FLAVOR	Reasonably good; no "off" flavor
SALOMETER	Acceptable Range in degrees: 3.0 to 14.0
COLOR	Reasonably uniform with no units lighter than the USDA Composite Color Standard for Ripe Type
DEFECTS	
Pits and Pit Fragments	Average of not more than 1 by count per 300 grams
Major Stems	Not more than 3
HEVM	Not more than 2 units per sample

TABLE 4 - BROKEN PITTED STYLE
 (Defects by count per 255 grams)

FLAVOR	Reasonably good; no "off" flavor
SALOMETER	Acceptable Range in degrees: 3.0 to 14.0
COLOR	Reasonably uniform with no units lighter than the USDA Composite Color Standard for Ripe Type
CHARACTER	Not more than 13 grams excessively soft
DEFECTS	
Pits and Pit Fragments	Average of not more than 1 by count per 300 grams
Major Stems	Not more than 3
HEVM	Not more than 2 units per sample

1. Section 932.109 Canned Ripe Olives of the Tree-Ripened Type

(a) "Canned ripe olives of the tree-ripened type" means packaged olives, not oxidized in processing, that are prepared from a lot of natural condition olives of advanced maturity which, when offered for inspection:

(1) Range in color from pinkish red, with some greenish cast, to black; and

(2) Have not more than 10 percent, by count, of "off-color" olives ("off-color" means those olives whose greenish cast covers more than 50 percent of the surface of the individual olives.)

2. Section 932.152 Outgoing Regulations Amended

(a) Examination of certain olives received for use in the production of canned ripe olives of the tree-ripened type.

(1) Pursant to 932.51(b), whenever a handler receives a lot of natural condition olives solely for use in the production of canned ripe olives of the tree-ripened type, he shall, at the time of receipt, notify the committee or the Inspection Service of the lot so received which shall than be subject to examination by the committee or by the Inspection Service, if so designated by the committee, to assure that the olives in such lot comply with the specifications set forth in 932.109. Each such

handler shall identify all such lots of natural condition olives and keep them separated and apart from all other olives received. Such identification and separation shall be maintained throughout the processing and production of such olives as canned ripe olives of the tree-ripened type.

3. Olives to be canned as tree-ripened must meet the requirements of tree-ripened type (see I.E.1 above) and be designated as such by the handler at the time of receiving, prior to being placed into storage. The classification or designation of olives as tree-ripened type under the marketing order cannot be made after the olives have been placed into storage.

As tree-ripened type olives must be kept "separate and apart from all other olives received" the Federal State Inspection Service, which performs all incoming olive inspection, will place a Red Hold Card (Red Tag) on all tanks designated as tree-ripened type olives. As each tank is filled or completed, the Federal State Inspector will issue a speed-letter to the Processed Products Inspector; the Q.C. Inspector; and to the handler. Each speed-letter will contain the following information:

Date:
 Variety:
 Quantity: (actual or estimated weight)
 Tank Number: (storage location)
 Hold Card Number:

NOTE: The speed-letter may also have listed on it the quantity of culls, undersize, and limited usage present when the olives were placed in storage. Disposition credit may be given toward the handlers obligation according to this information if the olives are disposed of to a non-ripe olive outlet such as Sicilians, Greeks, oil, etc...

The hold card is to follow the olives through processing. The handler must notify the Inspection Service prior to moving the olives.

If and when the olives are packaged as "tree-ripened" the Processed Products Inspector will date the reply section of the speed-letter, write "Canned as Tree-ripened," and sign it (See Appendix I for an example). Send the now completed speed-letter to the COC Office. Also, keep an up to date ledger on the disposition of all tanks designated as tree-ripened.

Since tree-ripened type olives are a canned ripe olive, they cannot be used per se to fulfill a disposition outlet towards a handlers obligation. Disposition credit can only be given on sort-out fruit if canned as "tree-ripened" or on that portion designated as culls, undersize, and/or limited usage by the Federal State Inspector as reported on a speed-letter. If the olives are designated as tree-ripened and disposed of as other than tree-ripened, record the appropriate disposition in your disposition ledger, and in the reply section of the speed-letter. FILE the completed speed-letter, DO NOT MAIL to the COC office.

The same procedures can be used in maintaining surveillance of tanks of non-designated styles (i.e., Sicilian, Greek, etc.), limited usage, undersize, and culls which have had hold cards and speed-letters prepared and issued.

Lots of tree-ripened olives do not have to be offered for outgoing inspection.

IV. DEFINITION

A. Identification of "Lot"

Each lot of processed olives offered for inspection must be identified in order that it may be properly inspected and certified.

Tanks of olives for pitting and tanks of pitted olives may be identified with COC HOLD cards.

The code marks on a container are the only practical means of associating the container with corresponding inspection records.

A coding system must identify plant, year, product, batch or day code and include any other information required by the packer. Metal containers are normally coded by embossing the canner's end of the container.

B. Definition of "Lot"

"Lot", for the purpose of inspection and certification other than under the Marketing Agreement, shall be as defined in the "Regulations Governing the Inspection and Certification of Processed Fruits and Vegetables and Related Products."

"Lot" for the purpose of outgoing (Processed) inspection and certification under the Marketing Agreement for California Olives is defined as follows:

Inspection and Certification Lot (Under the Order)

Any number of containers of the same size and type which contain olives of the same type, style, size and quality level which are packed during a basic grading period.

Certification Lot (Not Under the Order)

All, any portion of, or combination of inspection lots identified by code.

C. Basic Grading Period

A period of production not to exceed 24 hours. A shift may be designated as the basic grading period for quality determination.

D. Sample Unit Size

For determining quality, the sample unit size consists of 50 units of whole or pitted, 100 units of halved and 9 ounces (255 g) of all other styles.

E. Line Check Sample Unit

Product drawn from the container or processing line at a point beyond which no further quality changes will occur prior to cooking.

F. Finished Product Sample Unit

Finished product sample unit is taken from a container that has been completely processed (including cooking and cooling).

G. Common Source

The common source is a location at the head or origin of multiple lines beyond which no further quality or size changes will occur prior to cooking. Samples drawn at the origin or at any one of the multiple lines will represent all of the lines. If there are line personnel or mechanical devices that influence the quality or size of the product on one of the multiple lines, this line must be sampled individually beyond the point of this influence, and the line is not considered as represented by the common source sampling.

H. Definition of Types of Canned Ripe Olives

Canned ripe olives are processed as two distinct types.

1. Ripe Type - "Ripe Type" olives are those which have been treated and oxidized in processing to produce a typical dark brown to black color.
2. Green-ripe Type - "Green-ripe type" olives are those which have not been oxidized in processing; which range in color from yellow-green, green-yellow, or other greenish casts; and which may be mottled.

I. Definition of Styles of Canned Ripe Olives

1. Whole - "Whole" olives are those which have not been pitted.
2. Pitted - "Pitted" olives are those from which the pits have been removed.
3. Halved - "Halved" olives are pitted olives in which each olive is cut lengthwise into two approximately equal parts.
4. Segmented - "Segmented" olives are pitted olives in which each olive is cut lengthwise into three or more approximately equal parts.
5. Sliced - "Sliced" olives consist of parallel slices of fairly uniform thickness prepared from pitted olives.

6. Chopped - "Chopped" olives are random-size cut pieces or cut bits prepared from pitted olives and which are practically free from identifiable units of pit caps, end slices, or slices, ("practically free" means not more than 5 percent, by weight, of the units). (See J-3).

This definition precludes the packing of "broken slices" or "nuggets" as such. It is intended that broken slices, small end slices and pit caps (nuggets) must be run through a chopper to comply with this style.

7. Broken Pitted - "Broken Pitted" olives consist substantially of large pieces that may have been broken in pitting but have not been sliced or cut. Large pieces are also pitted olives with a portion of the flesh and skin missing in excess of normal pitting.

Only the above styles may be packed under the order. Mixed styles are not acceptable.

J. Determination of Style

1. Sliced

A sample unit will be designated as "Sliced Style" provided at least one-half (1/2) by weight of the units are slices. (Consider as a slice if 3/4ths or more of an apparent slice is present). The remaining one-half of the units may be broken slices, end slices, poorly cut units and/or pieces of slices.

A lot will be considered as complying with the style of "Sliced" if the number of sample units which fail the requirement for individual containers does not exceed the applicable acceptance number indicated in the single sampling plan of the regulations. The "style deviants" are not to be combined with deviants that affect quality.

Lots that fail the style of sliced fail the Marketing Order requirements and cannot be shipped. Therefore, keep management advised if their product is borderline so that the product can be diverted and chopped or sorted so as to meet.

The sample size for style determination on this product will be nine (9) ounces (255 g).

2. Broken Pitted

A lot of pitted olives may be designated as "broken pitted" if an average of one-third ($1/3$) or more, by weight, of the units present in the sample are broken or pieces of olives.

Lots of olives that fail the style of "broken pitted" or "pitted" fail the requirements of the Marketing Order and cannot be shipped. Therefore, keep management advised of borderline lots so that steps can be taken to meet the requirements.

The sample size for style determination on this product will be nine (9) ounces (255g).

3. Chopped

Interpret practically free from identifiable units of pit caps, end slices, or slices to mean that the sample unit may contain not more than 5 percent by weight of these items. Score whole pit caps, whole end slices (more than $1/2$ the size of an average slice) and slices when $3/4$ ths or more of an apparent slice is present.

A lot will be considered as complying with the style of chopped if the number of sample units which fail the requirements for individual containers does not exceed the applicable acceptance number indicated in the single sampling plan in the regulations. The "style" deviants are not to be combined with other "quality deviants."

The sample size for style determination on this product will be nine (9) ounces (255 g).

4. Segmented

A sample unit will be designated as "Segmented Style" provided sixty (60) percent or more by weight of the units are segments.

The sample size for style determination of this product will be nine (9) ounces (255 g).

V. INSPECTION PROCEDURE**A. Arranging Samples and Recording Information**

Record complete codes and identification marks as shown on container in the proper space on the score sheet. Use care not to overlook a space or symbol because these may have a very important meaning in the processor's code.

Remove the label to determine if any coding has been done on the sides of the container.

If the marks are wholly or partially illegible, describe and record as "illegible" or "partially illegible" or "indistinct."

The following information must also be recorded on line-check and cut-out worksheets for all processed lots of olives inspected pursuant to the Marketing Order.

1. Name of Plant
2. USDA or Fed State sized
3. Size of Fruit (if applicable)
4. Type
5. Style
6. Declared Drained Weight
7. Can Size
8. Time sample taken
9. Code
10. Vacuum - in inches (after can has cooled)
11. Fill or Drained Weight
12. Count per pound (Unpitted Style Only)

V. **INSPECTION PROCEDURE (continued)**

B. **Instructions on use of Canned Ripe Olives in-Line Sheets.**

1. Use Form FV-375 for chopped, sliced and segmented styles, FV-376 for whole, pitted and broken pitted styles, and Appendix J of this section.
2. Use a separate score sheet for each item.
3. Fill in the heading.
4. Determine and record the information for each sample unit. (Enter defects by number and not percentage).
5. In the column, MO LIMIT, use the symbol M for Meets and F for Fails Marketing Order requirements.
6. Circle any factor that fails the requirements and notify the designated plant personnel.
7. Determine whether or not the item meets Marketing Order requirements at the end of the shift.
8. Determine the Lot Grade of the item according to the U.S. Standards and record the reason for downgrading below Grade A (except for broken pitted) and/or for failing to meet the requirements.
9. On all meeting items attach the in-line score sheet, for the item to the Inspector's copy of the Pack and Certification Report for the day of pack.
10. On all failing items, record on the score sheet, the Pack and Certification Report number and the page and line numbers of the Pack and Certification Report on which the item is certified; attach the score sheet and place in a pending file.

The score sheet will be held in the pending file, and any reinspection score sheets until the item meets or is disposed of.

When the item meets on reinspection, is reprocessed, or is disposed of, attach all worksheets and score sheets to the Inspector's file copy of the Pack and Certification Report on which the final reinspection, and/or disposition is reported.

C. Vacuum Readings

1. Canned olives are commercially processed so as to provide a vacuum. While there are no specific vacuum requirements in the Marketing Order, the canned olives should conform to good commercial practice and be packed with a vacuum.
2. Take the vacuum readings on cooled cans selected for certification testing.
3. Record on the score sheets.
4. If zero vacuums are encountered, notify the plant management so that corrective action may be taken.
5. If the incidence of zero vacuums persists, consult your supervisor immediately.
6. Report vacuums in the prescribed manner if formal commercial certification is required. Consult File Code 128-A-20 for guidance.
7. Be alert to particular vacuum requirements in federal procurement programs. For example, military requirements on canned subsistence items specify a sample size of 8 with no zero vacuum.

D. Fill of Containers

It is generally assumed in the canning industry that a container must be filled to not less than 90 percent of its total capacity. This requirement can be taken to mean that the net headspace of the container should not be greater than 10 percent of its internal height. It is possible, therefore, to compute the maximum gross headspace which is allowed in each size container.

The practical method for the determination of a fill such as "not less than 90 percent of the capacity of the container" is by means of the headspace gauge. The headspace allowance of 10 percent (or for a 90 percent fill) for most can sizes is shown in File Code 130-A-10. The formula for calculating headspace is listed in File Code 130-A-10.

E. Drained Weight

The minimum drained weight recommendations for the various applicable styles in the U.S. standards are not incorporated in the grade of the finished product since drained weight, as such, is not a factor of quality for the purposes of these grades.

The minimum drained weights are based on equalization of the product 30 days or more after the product has been canned.

Method for determining drained weight. The drained weight of canned ripe olives is determined by emptying the contents of the container upon a U.S. Standard No. 8 circular sieve of proper diameter containing eight meshes to the inch [2.3 mm (0.0937 inch) +3 percent, square openings] so as to distribute the product evenly over the sieve. Without shifting the product, incline the sieve at an angle of 17 degrees to 20 degrees to facilitate drainage and allow to drain for two minutes. The weight of drained olives is the weight of the sieve and product less the weight of the dry sieve. A sieve 20 cm (8 inches) in diameter is used for containers with total contents of 1.5 kg (3.3 lbs) and less, and a sieve 30 cm (12 inches) in diameter is used for containers with total contents greater than 1.5 kg (3.3 lbs).

1. Sampling Rate for Drained Weight

Sampling rate for drained weight shall be a minimum of 1/3 of the single sampling plan, provided all weights are equal to or above packer's or declared drained weight.

If one or more of the weights are below the packer's or declared drained weight (weight declared on packer's label), proceed to drain the number required by the single sampling plan.

2. Guide for Good Commercial Practice for Recommended Minimum Drained Weight

Lots will be considered as complying with requirements of good commercial practice with respect to drained weight under the following conditions:

- (a) The average of all containers meets the declared, required or recommended minimum.
- (b) There shall be no unreasonable shortage in any individual container.

- (c) If range for good commercial practice is exceeded, see File Code 165-A-27.

3. Determination of "Unreasonable Shortage"

- (a) On No. 2-1/2 can size or smaller, no container may be more than 20 percent below the recommended or required minimum.
- (b) On containers larger than No. 2-1/2 can size, no container may be more than 10 percent below the recommended or required minimum.

F. Fill Weights

The factor of fill weight in canned ripe olives may be used in lieu of drained weight. The minimum fill weight recommendations for the various applicable styles are based on drained weight requirements. Fill weights are not incorporated in the grade of the finished product since fill weight as such is not a factor of quality for the purposes of these grades.

Method of ascertaining Fill Weight - The fill weight of canned ripe olives for the applicable styles is determined in accordance with the U.S. Standards for Inspection by Variables and U.S. Standards for Determination of Fill Weights. File Code 140-A-1 and 140-A-3.

G. Net Contents

The label weight for canned ripe olives except chopped is declared as drained weight. On chopped style, the label weight is either net contents or net drained weight.

VI. SAMPLING FOR QUALITY

A. General

Sampling rates for processed fruits and vegetables are set forth in Branch regulations. In process (on-line) sampling, acceptance and segregation procedures for quality factors are contained in File Code 120-A-4.

B. Packer Contact

In-plant inspection is done during the process of preparation and packaging and on the packed product. In this case, when significant changes in quality are noted, responsible plant personnel should be notified immediately and packing operations kept under close observation until brought back into intended grade. If the product drops to a lower grade, the plant may want to keep a portion of the production physically separated and properly identified from other lots.

Notify the packer immediately if the olives being packed are failing to meet the order. Set up a procedure whereby such notification shall be in writing to show (a) the time, (b) the reason the olives are failing to meet the order and (3) name of person to whom notice was given. This written notification shall be made in duplicate and the inspector shall retain the carbon copy.

C. Sources of Samples

In order to verify compliance with the U.S. grade requirements of the item, sample units may be line checks or finished product, or any combination of both. If finished product sample units are drawn solely to verify line check grading and flavor, they will not be used in this acceptance criteria unless line check sample units do not meet the required rate (see D below).

Line check sample units may be drawn from a common source or from individual lines, depending on circumstances and plant procedures.

D. Sampling Rate

Any production, or portions of production, of an item that is acceptable by this criteria must be represented by at least the number of sample units as required by the single sampling plans in the Regulations, or by their equivalent double or time sampling plans in Appendix A, attached. The sampling rate and plan should be predetermined in advance of production so as to result in at least the minimum required for the estimated total production for the basic grading period. A higher rate is desirable as it minimizes resampling in the event of segregation. The predetermined total number of sample units required, divided by the estimated production time, gives the average time interval between sampling. Sample units should not be drawn with clocklike regularity. However, the rate should not be varied in a manner to bias the overall sample with a disproportionate number of sample units from portions of production that appear to be of a higher or lower quality than the balance of the item. The rate may be varied with volume of production.

VII. SAMPLING PLANS

Five types of sampling plans are used by USDA in plants (see Appendix A attached):

- A. Normal Single Sampling Plans.
- B. Tightened Single Sampling Plans.
- C. Increased Single Sampling Plans.
- D. Double Sampling Plans.
- E. Time Sampling Plans.

Usually normal single sampling plans are used to determine acceptance of inspection lots that are known to be variable in quality. Time sampling plans, on the other hand, are used for products that are consistently produced without deviants; and double sampling plans may be used for certain items where reduced sampling is considered desirable (such as re-pack).

Tightened and increased sampling plans are used to determine acceptance of certification lots that are predesignated portions of inspection lots, or to determine acceptance of any portion of a failing inspection lot.

Which sampling plan to use for an item must be decided prior to the start of production in a basic grading period. Switching from one plan to another after acceptance sampling has started for the shift is not permitted. Using single sampling plans to determine acceptance of portions of inspected lots rejected under other sampling plans is permitted as indicated in this instruction.

VIII. ACCEPTANCE CRITERIA

See Appendix A for definitions.

A. Acceptance Based on Single Sampling Plans.

Acceptance of an item based on the single sampling plan is determined in the following manner:

1. An inspection lot is acceptable under the normal sampling plan if:
 - (a) (n) at least meets the minimum required for the applicable lot size range in the Regulations, and

- (b) Deviants do not exceed (c) for the applicable normal single sampling plan in Appendix A, attached, and lot does not contain worse than a deviant.
 - (c) There are no runs (three or more consecutive sample units of production). Verification or supplemental sample units drawn without regard to the order of production are not considered as part of a run.
2. A portion of a failing inspection lot is acceptable as a certification lot under the single sampling plans if:
- (a) It is consecutive production;
 - (b) No deviant in the portion forms a run (see 1c above) with other deviants within the inspection lot;
 - (c) The portion is separately identified by sub-code from any unacceptable production; and
 - (d) The lot meets applicable tightened or increased sampling plans criteria for applicable lot size.

8. Acceptance Based on Double Sampling Plans

Determination of acceptance of an item under the double sampling plan is made in the following manner:

1. An inspection lot is acceptable under the double sampling plan if:
- (a) (n1) at least meets the minimum required in Appendix A, attached, for the double plan corresponding to the single plan required for the applicable lot size range in the Regulations;
 - (b) There are no deviants, or in lieu of (a) and (b) if deviants exceed 0 but are less than (r) corresponding to (n1) for applicable double plan in Appendix A, attached;
 - (c) Additional sample units meet the minimum required to reach (nt) in Appendix A, attached, for the double plan corresponding to the single plan required for the applicable lot size range in the Regulations; and
 - (d) The number of deviants do not equal or exceed (r) corresponding to (nt) for the applicable double plan in Appendix A, attached.

2. A portion of a failing inspection lot is acceptable as a certification lot under the double sampling plan if:
 - (a) It is consecutive production;
 - (b) The portion is separately identified by sub-code from any unacceptable production;
 - (c) (n) at least meets minimum required for the applicable lot size range in the Regulations;
 - (d) Deviants do not exceed (c) for the applicable tightened single sampling plan in Appendix A, attached, or in lieu of (c) and (d).
 - (e) (n) at least meets the minimum required for the next higher than applicable lot size range in the Regulations; and
 - (f) Deviants do not exceed (c) for the applicable increase single sampling plan in Appendix A, attached.

Portions of inspection lots that cannot be accepted as certification lots by the criteria above, cannot be resampled for acceptance except under appeal inspection.

C. Acceptance Based on Time Sampling Plan for Non-Homogeneous Products

At the end of each shift the items will be evaluated regardless of the number of sample units examined based on the following:

1. An inspection lot is acceptable under the time sampling plan if:
 - (a) Deviants do not exceed the number permitted in Appendix A, for the number of sample units examined and there are no "worse" than a deviant sample units; and
 - (b) There are no runs (three or more consecutive sample units are deviants).
2. A portion of a failing inspection lot is acceptable as a certification lot under the time sampling plan if:

- (a) It is consecutive production;
- (b) The portion is separately identified by sub-code from any unacceptable production;
- (c) (n) at least meets minimum required for the applicable lot size range in the Regulations;
- (d) Deviants do not exceed (c) for the tightened single sampling plan in Appendix A;
- (e) No deviant in a subcode forms a run with other deviants in the inspection lot;
 - (1) Subsequent production (following a failure of run criteria) is sampled at the next higher time frequency rate;
 - (2) Previous production (prior to failure of run criteria) meets the deviant rate for tightened single sampling plan in Appendix A; and
- (f) Production associated with a failure caused by "worse" than a deviant meets the criteria in File Code 165-A-27 "Worse Than A Deviant".

D. Pockets of Lower Quality Production

On the incidence of the third deviant in a run, all production is rejected back to and including that represented by the first deviant in the run. All similarly identified production must also be rejected unless separately identified by sub-code and shown to be acceptable.

E. Recording Sample Data

Sample data is recorded on approved score sheets in the order of production. Each score sheet should cover a single item for the entire basic grading period. There may be instances in which two or more labels are being packed from the same item. In such instances a single master score sheet should be maintained on the entire item, rather than separate score sheets for each label or brand. Carbon copies of the master score sheet may be made and filed with the certificates issued against each brand. This, of course, can be done only if the item remains the same.

If the item changes because of quality changes, or if the production is segregated into different quality levels, separate score sheets must be prepared for each lot of different quality. In these instances the production is no longer a single item but becomes two or more items.

Copies of the master score sheet may be given to the plant or other financially interested party upon request. However, do not attempt to separate sample units on the master score sheet and relate such sample units to a particular buyer's label. Here again, this assumes that all of the production covered by the master score sheet is of a single item and consequently a single quality level.

Inspectors will note that deviants cannot be removed from the master score sheet for an item when the portion (pallet, buggy, etc.) from which it was drawn is taken out of the lot. Nor can a deviant be disregarded or erased from the records based on the examination of two or more additional sample units drawn from the period of production in which the deviant occurred. Lateral samples, however, may be taken and the results reported to plant management; but the lateral samples should not be considered in evaluating the quality of the item.

Sampling rates should be predetermined so as to provide sufficient sample units off the line without the need to resort to "cooler cutting" or "warehouse sampling" in order to meet the minimum requirement. This, of course, does not preclude drawing additional containers when insufficient line checks are taken. Sample units may also be selected and marked for later "cooler cutting" at the same point where line checks are selected. A space can be left on the score sheet for such sample units and they can be integrated later at the proper point in the order of production.

In addition to line checks at least one finished product sample (completely cooked and cooled) must be drawn for each item each hour or one-half of the single sampling plan number, whichever is less. These are considered "verification samples" and are examined to be sure that handling practices or unusual conditions between line checks and canning have not adversely affected the product. These samples are also to be tasted for flavor. Most off-flavors can be detected at this time. Whenever verification samples indicate a change of quality, the lot must be completely reinspected and the line checks disregarded before certification.

The procedure provides that an item is declared a new item only when there is a real and substantial change in raw product or quality control efforts. A change in specification may or may not require a change in item. The inspector will need to evaluate the specifications involved to determine if an item change is in order. It is not intended to unduly restrict the applicant in changing items; however, it is intended that announced changes in the item be associated with real and substantial changes in raw product or quality control efforts. It is not permissible to review the score sheets at the end of a shift and make retroactive changes in the item.

F. Common Source Sampling

Sample units for inspection may be drawn from a common source or from individual lines depending upon circumstances and plant procedures.

A common source is that location on a line, or multiple lines, at which no further quality changes will occur in the end item, except as might be attributed to improper heat processing or improper storage. Any line personnel or mechanical equipment that might influence the overall quality that is exclusive with one line or that follows the point of sampling, would disallow that line(s) from representing the common source.

G. Sample Selection

The following general principles will apply to sample selection:

1. Sample units may be "line checks" or "finished product" checks or both.
2. Random sampling at irregular intervals shall be observed; frequency shall be changed to conform to volume.
3. If "common source" sampling is being observed:
 - (a) Samples may be drawn directly from the common source or from the filling lines.
 - (b) If drawn from lines, only one line should be sampled at a time; however, lines should be alternated during a given production period.
 - (c) Individual sample units must be representative of all lines included in the common source.

IX. QUALITY EVALUATION

A. Select standard sample unit size for applicable style.

B. Grade Factors Not Rated by Score Points

1. Uniformity of size (styles of whole and pitted only).

Grade A - The variation in diameters does not exceed 4 mm, and of the 90 percent, by count, most uniform in size, the diameter of the largest does not exceed the diameter of the smallest by more than 3 mm.

Grade B - The variation in diameters does not exceed 8 mm, and of the 80 percent, by count, most uniform in size, the diameter of the largest does not exceed the diameter of the smallest by more than 4 mm.

Grade C - 60 percent, by count, of the most uniform in size, the diameter of the largest does not exceed the diameter of the smallest by more than 4 mm.

Substandard is the quality of canned ripe olives of any style that fails to meet the applicable requirements for U.S. Grade C.

The factor of uniformity of size is strictly a prerequisite factor. No deviant rate can be applied to a prerequisite factor and the lot grade will be no higher than the lowest prerequisite grade of any sample unit in the lot.

2. Flavor

The factor of flavor (organoleptic) is to be scored as a prerequisite for each sample unit. Grade A and B must have a good flavor. Grade C olives must have at least reasonably good flavor. Flavor may be affected by improper processing procedures. Canned olives may acquire a metallic flavor due to the length of time the product has been canned. Since there may be a flavor variation in the olives within a container, several olives from each line check and cooked sample should be tasted for flavor. Salt determination shall be made on all lots.

In order to preclude holding numerous lots unnecessarily, the committee has asked us to use the following guideline in scoring flavor:

For Good Flavor - Allow 10 percent of the units to be of reasonably good flavor with no off flavored units.

For Reasonably Good Flavor - Slightly lacking in distinctive characteristic flavor and no off flavor.

However, hold for panel checking all lots that contain any units with repugnant flavor and lots that you consider borderline in meeting reasonably good flavor.

- (a) "Good flavor" in ripe type means a distinctive flavor characteristic of ripe type olives (including that of properly spiced olives) which have been properly prepared and processed and which are free from objectionable flavor of any kind.

Salometer range 5.0° to 12.0°.

- (b) "Good flavor" in green-ripe type means a distinctive mellow flavor characteristic of green-ripe type olives which have been properly prepared and processed and which are free from objectionable flavors of any kind.

Salometer range 5.0° to 12.0°.

- (c) Reasonably good flavor. "Reasonably good flavor" in either ripe type or green-ripe type (including that of properly spiced olives) means that the flavor may be slightly lacking in distinctive characteristic flavor for the respective type but the olives are free from objectionable flavors of any kind.

Salometer range 3.0° to 14.0°.

Flavor is a very important factor. We must be alert in helping the industry to keep off-flavors from reaching the consumer. All line-check sample units and at least one cooked and cooled sample unit for each item each hour or one-half the single sampling rate shall be tasted for flavor. Select those olives to be tasted that are most likely to be poor flavor, such as dark or soapy centers and soft or sun shriveled olives. Taste at least two olives from each sample unit.

Any lot that contains or appears to contain objectionable flavors shall be held for checking by a panel of inspectors in the field office.

In lieu of a lot grade, insert "Held for Flavor Evaluation" in the remarks column and report as such on the COC-4.

Draw 5 sets of 6 random samples (or 5 No. 10 cans) from each questionable lot. Immediately send one set to the Fresno, Stockton, and Regional Offices. Include a copy of the score sheet with the sample and ask for flavor evaluation. Lots shall not be checked for flavor evaluation by the panel prior to 24 hours after pack. Hold the balance of the samples for later review as necessary.

The results of the panel flavor evaluation are to guide the Inspector in Charge in making a final decision. The Inspector in Charge has the authority and should assign the final grade to the lot in question.

Olives that fail the salometer range fail flavor requirements. Exception is made for special "High Brine" packs in No. 10 cans which have prior committee approval.

The salometer readings are normally taken within an hour after canning to check the salt content (flavor) of the canned olives and they may vary from readings taken 24 or more hours later. Thought should be given to equalization factors between the salt brine packing media and the olives. This factor will vary considerably between olive styles (whole, pitted, sliced, etc.), olive sizes, and the different handling practices of the various packers. Any built-in factors used to adjust the salometer readings should be thoroughly checked and considered before being applied. On borderline lots or codes, additional samples should be drawn and checked approximately 24 hours after canning to verify the original salometer readings.

NOTE:

ANY OBJECTIONABLE OR POOR FLAVOR (TASTE) OTHER THAN SALOMETER READING WILL CAUSE THE LOT TO FAIL AND BE DISPOSED OF ACCORDINGLY. FLAVOR IS CHARACTERIZED BY DESCRIPTIVE TERMS SUCH AS BUT NOT LIMITED TO TOO SOAPY, HIGHLY MEDICINAL, TOO BITTER, EXCESSIVELY MUSTY, ETC. THE SINGLE SAMPLING DEVIANT RATE IS APPLICABLE ONLY ON SALOMETER READINGS BELOW 3 DEGREES SALOMETER AND ABOVE 14 DEGREES SALOMETER.

Deviant for flavor are permitted only for sample units that fail the salometer ranges. Repacking of failing lots is permitted only on these lots which exceed the salometer ranges. Olives which fail to meet reasonably good flavor for any other reason must be disposed of under the supervision of the Committee or the Inspection Service.

An appeal inspection may be requested on failing lots. If an appeal inspection is requested, contact your supervisor. The Regional Office will assign the review panel to perform the appeal inspection. The results of the appeal inspection are final.

X. GRADE FACTORS WHICH ARE SCORED

A. Color.

Ripe-type - The colors of canned ripe olives may range from brown to black. Aside from varietal characteristics the color of canned ripe olives may be affected by maturity, processing and handling.

The evaluation of color should be determined approximately between two and five minutes after the olives are removed from the container and is based upon the uniformity of the exterior color or general appearance as to color of the olives within the container. The evaluation of color in "halved" style is based on the uncut surfaces. Color of segmented, sliced and chopped style olives is based on color of olives as a mass.

The color of ripe olives is ascertained by comparison with the color comparators.

Green-Ripe Type - Normal color for green-ripe olives is yellow-green, green-yellow, or other greenish casts, any of which may have a mottled appearance that is typical of green-ripe olives. Off-color means dark brown, dark purple or black olives.

1. Grade A - Canned ripe olives that have a good color may be given a score of 27 to 30 points. "Good color" has the following meanings with respect to the applicable type and style.

(a) Ripe-Type.

Whole; pitted; halved styles. The olives or units have a practically uniform black or dark brown color. Not less than 90 percent, by count, of the olives or units have a color equal to or darker than the minimum color standard for U.S. Grade A.

Segmented; sliced; chopped styles. The general color impression of the olives as a mass is normal and typical of these styles prepared from olives with good color.

(b) Green-Ripe Type.

The general color appearance of the olives shall be normal. Not less than 90 percent, by count, shall be practically uniform in such normal color for the type, and no off-color olives may be present.

2. Grade B - If the canned ripe olives have a reasonably good color, a score of 24 to 26 points may be given. "Reasonably good color" has the following meanings with respect to the applicable type and style:

(a) Ripe-Type.

Whole; pitted; halved styles. The olives or units have a reasonably uniform black, dark brown or reddish-brown color. Not less than 80 percent, by count, of the olives or units have a color equal to or darker than the minimum Color Standard for U.S. "Grades B and C."

Segmented; sliced; chopped styles. The general color impression of the olives as a mass is normal and typical of these styles prepared from olives with reasonably good color.

(b) Green-Ripe Type.

The general color appearance of the olives shall be normal. Not less than 80 percent, by count, shall be reasonably uniform in such normal color for the type, and no off-color olives may be present.

3. Grade C - If the ripe olives have a fairly good color, a score of 21 to 23 points may be given. Canned ripe olives that fall into this classification shall not be graded above U.S. Grade C regardless of the total score for the product (this is a limiting rule). "Fairly good color" has the following meanings with respect to the applicable type and style:

(a) Ripe-Type.

Whole; pitted; halved styles. The olives or units have a fairly uniform black, dark brown or reddish-brown color. Not less than 60 percent, by count, of the olives or units have a color equal to or darker than U.S. Color Standards for Canned Ripe Olives for U.S. "Grades B and C."

Segmented; sliced; chopped styles. The general color impression of the olives as a mass is normal and typical of these styles prepared from olives of fairly good color.

Broken pitted style. The general color impression of the olives as a mass is normal and may be variable, but is typical of this style prepared from olives of good, reasonably good, or fairly good color.

(b) Green-Ripe Type.

The general color impression of the olives shall be normal but may vary markedly for the type. Not more than 10 percent, by count, of off-color olives may be present.

4. Substandard (SStd.). Canned ripe olives that are abnormal in color for any reason or that fail to meet the requirements of paragraph (3) of this section may be given a score of 0 to 20 points and shall not be graded above Substandard, regardless of the total score for the product (this is a limiting rule).

UNDER THE MARKETING ORDER FOR GREEN-RIPE TYPE, COLOR IS EXEMPT INDEFINITELY.

B. Defects

Defects which affect the quality of canned ripe olives are of several different types. EACH TYPE IS CAREFULLY DEFINED IN THE STANDARD. TOLERANCES AND ALLOWANCES ARE LISTED IN APPENDIX C, D, E AND F OF THIS SECTION. The purpose of this instruction is to clarify definitions under the marketing order, and not to repeat all the information contained in the U.S. Standards.

Procedure of Determining the Score for Defects

Use the Defect Guides in Appendixes B, C, D and E for standard sample unit size, defect allowances and score points.

Harmless extraneous material and stems are based on individual sample units. Pit material is based on an average for the entire lot.

1. Harmless Extraneous Material

Determine the extent to which any harmless extraneous material present affects the appearance or eating quality of the product. This is done by observation, keeping in mind that under proper conditions of manufacture almost all of such material would be eliminated by washers and shakers.

2. Pit Material

Pit material is classified as follows:

- (a) "Pit" means any whole pit 2 mm or longer (excluding whole style) whether loose, partially attached or attached to the flesh.
- (b) "Piece of Pit" or fragments of pit means portion of pit 2 mm or longer in pitted, halved, segmented, sliced, broken pitted or chopped styles.

Procedure to determine "fragments of pit" or "pieces of pit" on all samples of chopped olives. The sample size shall be 2 ounces of product. Either of the two following procedures may be used:

- (1) Place 9 ounces of product in a large deep grading pan and add a sufficient (about one inch in depth) amount of 7° salometer salt solution to float the olive material. Stir the olives then tilt the pan and slowly decant the major portion of the olive material. The fragments of pits and stems will accumulate in the corner of the pan. Check the material that is left in the pan for fragments of pits and stems.
- (2) Place a large, deep grading pan in sink at an angle of approximately 20 degrees (2-211 X 200 cans placed under one end of the pan should suffice). Fill the grading pan with HOT water from a faucet over the highest elevation of the grading pan. Adjust the water flow so that a rolling effect is achieved by the water in the lower section of the pan.

Add one-half of the sample just to the side of the incoming HOT water. This will allow the incoming water to evenly distribute and float the sample. Repeat using the remaining half of the sample. Any pit fragments and stems present will remain in the bottom of the pan.

3. Blemishes

(a) Ripe-Type.

Blemishes are dark colored surface marks which may or may not penetrate into the flesh, which singly or in the aggregate, materially affect the appearance or eating quality of the olives.

Classify all the units which are blemished in accordance with the definitions in the standards.

Contact points, light green colored areas in dark ripe, caused by lack of agitation during processing will be scored as minor blemishes.

(b) Green-Ripe Type

UNDER THE MARKETING ORDER BLEMISHES ARE EXEMPT INDEFINITELY. Defects other than blemishes are scored the same as in ripe type.

(1) Insignificant Blemishes

Light brown to dark brown surface areas and pale gray bruised surface areas that are less than the area of a circle 6 mm in diameter and which do not materially affect the appearance of the unit are not considered "defects".

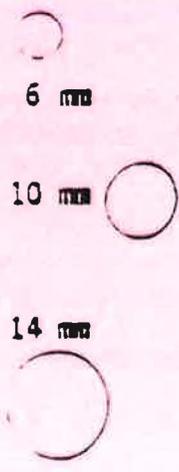
(2) Minor Blemishes

Minor blemishes are surface marks which may or may not penetrate into the flesh and which individually or collectively materially affect the appearance of the unit.

- a. Light brown to black surface areas which, singly or in combination of three or less affected areas on the unit, exceed in the aggregate the area of a circle 6 mm in diameter but do not exceed in the aggregate the area of a circle 10 mm in diameter; or
- b. Single black surface areas that do not exceed the area of a circle 6 mm in diameter but which singly materially affect but not seriously the appearance of the unit.

(3) Major Blemishes

Major blemishes include units affected by surface marks, bruises and other similar injuries, discoloration, or other abnormalities to the following degree:



- a. Dark brown to black surface areas singly or in combination of three or less affected areas on a unit, exceed in the aggregate the area of a circle 10 mm in diameter, but do not exceed the area of a circle 14 mm in diameter; or
- b. Single black surface areas that exceed the area of a circle 6 mm in diameter, but do not exceed the area of a circle 10 mm in diameter;
- c. Any blemish whether or not specifically defined or mentioned in this sub-paragraph which seriously affects the appearance of the unit but not the eating quality of the unit.

(4) Severe Blemishes

Severe blemishes include units affected by surface marks, bruises, and other similar injuries, discoloration, or other abnormalities to the following degree:

- a. Dark brown to black surface areas singly or in combination of three or less areas on a unit, exceed in the aggregate the area of a circle 14 mm in diameter.
- b. Single black surface area that exceeds the area of a circle 10 mm in diameter.
- c. Any blemish, whether or not specifically defined herein, which renders the olive inedible.

4. Wrinkles

Wrinkles are grooves 0.5 mm in width.

Minor wrinkles are wrinkles which collectively do not more than materially affect the appearance of the unit, and the aggregate of wrinkles cover more than one quarter (1/4) but not more than one half (1/2) of the total area of the unit.

Major wrinkles are wrinkles which collectively more than materially affect the appearance of the unit, and the aggregate of wrinkles cover more than one half (1/2) of the total area of the unit.

5. Mutilated

In Whole and pitted style means an olive that is seriously torn or damaged and that such affected area exceeds that of a circle 6 mm (.25 inch) in diameter; and in the style of pitted the damage by pitting machine or other means, means that the entire pit cavity is exposed or the appearance of the olive is seriously affected. Aggregate the pieces to equal an average size whole unit for determining the percent by count.

6. Mechanical Damage

Score Mechanical Damage when an area of approximately 3 mm (.13 inch) to 6 mm (.25 inch) is affected. Allow no more than 5 units whole and pitted, 10 units halved, under the Marketing Order.

7. Broken Pieces

Broken pieces are scored in both Sliced and Segmented Styles. Refer to pages 3.7 & 3.8 of this section for information regarding procedures.

8. Defects not Specifically Mentioned

White, powdery looking residues on the surface of some olives, caused by the addition of excessive amounts of calcium chloride to the process, should be considered under defects when they affect the appearance or edibility of the sample on an overall basis of slightly, materially, or seriously.

C. Character

The factor of character refers to the firmness, tenderness and texture characteristic for the variety and type. The condition of the epidermal layer is also considered.

Definitions

"Slip Skin" - Refers to epidermal tissue that has become loosened and/or detached from the underlying flesh of the olive. Score only when area affected is equal to or greater than that of a circle 6 mm (.25 inch) in diameter. Score the same as soft units.

"Soft" - Units lacking the firmness that is characteristic for a particular variety.

"Excessively Soft" - Units shall be considered excessively soft when the olives appear to be spongy or watery. Units that have the apparent shape of whole units, but appear to have disintegrated flesh and water texture shall be considered excessively soft. In addition, a unit shall be considered excessively soft if the pit can be felt when applying moderate pressure.

Refer to character scoring guide in this section for allowances.

Canned olives of the "ripe type" of the styles of whole, pitted and broken pitted must meet the character requirements for U.S. Grade B classification. All other styles must meet the character requirements for U.S. Grade C classification.

IN-PLANT SAMPLING PLANS

Normal Single Sampling Plans	n	3	6	13	21	29	38	48	60
	c	0	1	2	3	4	5	6	7
Tightened Single Sampling Plans	n	-	6	13	21	29	38	48	60
	c	-	0	1	2	3	4	5	6
Increased Single Sampling Plans	n	6	13	21	29	38	48	60	72
	c	1	2	3	4	5	6	7	8
Double Sampling Plans	n1		<u>4</u>	<u>7</u>	<u>10</u>	<u>12</u>	<u>14</u>	<u>16</u>	<u>18</u>
			0 2	0 3	0 4	0 4	0 4	0 4	0 5
	nt		<u>7</u>	<u>14</u>	<u>22</u>	<u>30</u>	<u>45</u>	<u>55</u>	<u>70</u>
			1 2	2 3	3 4	4 5	6 7	7 8	8 9
* Time * Sampling * Plans	n	1 - 3	4 - 8	9 - 15	16 - 24	25 - 32	33 - 43	44 - 53	54 - 65
	c	0	1	2	3	4	5	6	7

(n) = Number of sample units. When the number of sample units representing an item or a portion of item being considered for acceptance is between two indicated sample sizes, use (c) for the lower (n).

(c) = The number of deviants permitted for the associated (n).

(n1) = The number of sample units required in the first step of the Double Sample Plan.

(nt) = The total number of sample units required (including n1) in the Double Sample Plan when the deviants in (n1) exceed 0 but not equal to (r).

(r) = The number of deviants that requires rejection of samples of associated size (n1) c- (nt).

* Once acceptance sampling for an item has been initiated in a basic grading period, switching from Single to Double to Time Sampling Plans and vice versa, is not permitted.

U.S. SCORING GUIDE FOR SIZE, COLOR AND CHARACTER

PREREQUISITE GRADE WHOLE AND PITTED STYLES												
Grade	A				Limiting Rule B			Limiting Rule C			Limiting Rule SSTD	
	Maximum Variation	None may vary more than 4 mm				None may vary more than 8 mm			--			--
	10% more than 3 mm But less than 4 mm				20% more than 4 mm But less than 8 mm			40% more than 4 mm			Fails C	
COLOR SCORING WHOLE, PITTED, AND HALVED STYLES												
Grade	A				B			Limiting Rule C			Limiting Rule SSTD	
	Score points	30	29	28	27	26	25	24	23	22	21	20 - 0
Color	Lighter than Minimum A Comparator				Lighter than Minimum B-C Comparator			Lighter than Minimum B-C Comparator				
Based on number by count, not equal to or darker than comparator for "Ripe Type"	0	2	3	5	6	8	10	13	15	20	Over 20	
	Practically Uniform				Reasonably Uniform			Fairly Uniform			Fails C	
(Based on uncut surfaces only)												
SEGMENTED, SLICED AND CHOPPED STYLES												
Color based on appearance in mass	Practically uniform in color. Prepared from olives of good color.				Reasonably uniform in color. Prepared from olives of reasonably good color.			Fairly uniform in color. Prepared from olives of fairly good color.			Poor or abnormal color	
BROKEN PITTED STYLE												
								Practically, Reasonably, or Fairly uniform			Poor or abnormal color	
CHARACTER SCORING												
Character-Grade	A				Limiting Rule B			Limiting Rule C			Limiting Rule SSTD	
	Score Points	30	29	28	27	26	25	24	23	22	21	20 - 0
Soft Ex. Soft 1/	Whole, Pitted Styles—Max by Count—Halved—Allowance Double											
	0	1	1	2	3	4	5					--
	0	0	0	0	1	2	2					
Soft Ex. Soft 1/	All Other Styles (Except Chopped) Max. b:											
	0	4	8	13	17	22	26					F A I L S
	0	0	0	0	4	8	13					
Chopped Style												
	Practically uniform in texture				Reasonably uniform in texture							

1/ Total of 10% by count or by weight combination of soft and excessively soft with not more than 5% by count or by weight excessively soft included in the 10%.

DEFECTS SCORING GUIDE FOR OLIVES

WHOLE AND PITTED STYLES

DEFECT GRADE	A					B LIMITING RULE				C LIMITING RULE		
	40	39	38	37	36	35	34	33	32	31	30	29
SCORE POINTS	40	39	38	37	36	35	34	33	32	31	30	29
DEFECT SAMPLE SIZE (50 OLIVES) DEFECTS BY COUNT	PRACTICALLY FREE FROM DEFECTS					REASONABLY FREE FROM DEFECTS				FAIRLY FREE FROM DEFECTS		
TOTAL MINOR & MAJOR BLEMSHES, MINOR & MAJOR WRINKLES, AND MUTILATED Provided:	(DEFECTS BY COUNT PER 50 OLIVES)											
MAJOR BLEMSHES & MAJOR WRINKLES, do not exceed -----	1	2	3	4	5	6	7	8	10	NO LIMIT		
MUTILATED MAJOR BLEMSHES & MAJOR WRINKLES do not exceed -----	0	0	0	1	2	3	4	5	5	6	8	10
MUTILATED do not exceed -----	0	0	0	1	1	2	2	2	2	3	4	5
MECHANICAL DAMAGE	0	0	0	1	2	3	4	5	5	6	7	8
PITTER & PLUNGER DAMAGE, CROSS PITTER, AND BLOW OUTS (PITTED STYLE ONLY)	1	2	3	4	5	6	7	8	10	11	12	13
OBVIOUS SPLIT-PIT OR MISSHAPEN TOTAL MINOR & MAJOR STEMS	0	0	1	2	2	3	4	5	5	NO LIMIT		
STEMS	0	0	1	2	2	3	3	3	3	4	4	4
MAJOR STEMS (OVER 4 MM)	0	0	0	0	1	1	1	1	1	2	2	2
HEM OR EVM PITS OR PIT FRAGMENTS (2 mm or longer)	PITTED STYLE - AVERAGE OF 1.3% PITS AND/OR PIT FRAGMENTS BY COUNT											
SEVERE BLEMSHES (GREEN RIPE ONLY) DEFECTS NOT SPECIFICALLY MENTIONED (INSIGNIFICANT DEFECTS, WHITE RESIDUE, AND ETC.)	0	0	0	0	0	0	0	0	0	1	2	3
	NOT MORE THAN SLIGHTLY AFFECT THE APPEARANCE OR EDIBILITY					NOT MORE THAN MATERIALLY AFFECT APPEARANCE OR EDIBILITY				NOT MORE THAN SERIOUSLY AFFECT APPEARANCE OR EDIBILITY		

3.35

DEFECTS SCORING GUIDE FOR SLICED STYLE
SAMPLE SIZE 255 GRAMS (9 OUNCES)

DEFECT GRADE	A					B LIMITING RULE				C LIMITING RULE				SSTD LIMITING RULE
	40	39	38	37	36	35	34	33	32	31	30	29	28	
SCORE POINTS	40	39	38	37	36	35	34	33	32	31	30	29	28	27 - 0
HEM OR EVM	0	0	0	0	1	2	2	2	2	2	2	2	2	FAILS C
STEMS MAJOR (OVER 4MM) BROKEN PIECES - PIECES LESS THAN 3/4 OF AN APPARENT SLICE; END SLICE LESS THAN 1/2 THE SIZE OF AN AVERAGE SLICE; PARTLY CUT SLICES	0	0	0	0	1	2	2	2	2	3	3	3	3	
	0	6g	12g	19g	26g	32g	38g	44g	51g	70g	89g	108g	125g	
ANY OTHER DEFECTS NOT SPECIFICALLY MENTIONED	NOT MORE THAN SLIGHTLY AFFECT APPEARANCE OR EDIBILITY					NOT MORE THAN MATERIALLY AFFECT APPEARANCE OR EDIBILITY				NOT MORE THAN SERIOUSLY AFFECT APPEARANCE OR EDIBILITY				
PIT OR PIT FRAGMENTS (2 mm or longer)	AVERAGE OF 1.3 PITS AND/OR PIT FRAGMENTS PER 300 GRAMS													

DEFECTS SCORING GUIDE FOR CHOPPED STYLE
SAMPLE SIZE 255 GRAMS (9 OUNCES)

DEFECT GRADE	A					B LIMITING RULE				C LIMITING RULE				SSTD LIMITING RULE
	40	39	38	37	36	35	34	33	32	31	30	29	28	
SCORE POINTS	40	39	38	37	36	35	34	33	32	31	30	29	28	27 - 0
HEM OR EVM	0	0	0	0	1	2	2	2	2	2	2	2	2	FAILS C
STEM MAJOR (OVER 4 MM)	0	0	0	0	1	2	2	2	2	3	3	3	3	
ANY OTHER DEFECTS NOT SPECIFICALLY MENTIONED	NOT MORE THAN SLIGHTLY AFFECT APPEARANCE OR EDIBILITY					NOT MORE THAN MATERIALLY AFFECT APPEARANCE OR EDIBILITY				NOT MORE THAN SERIOUSLY AFFECT APPEARANCE OR EDIBILITY				
PIT OR PIT FRAGMENTS (1 mm or longer)	AVERAGE OF 1.3 . . . AND/OR FRAGMENTS PER 300 GRAMS													

DEFECTS SCORING GUIDE FOR SEGMENTED AND BROKEN PITTED STYLES
SAMPLE SIZE 255 GRAMS (9 OUNCES)

DEFECT GRADE	A					B				C				SS/TI	
						LIMITING RULE				LIMITING RULE				LIMITING	
SCORE POINTS	40	39	38	37	36	35	34	33	32	31	30	29	28	27 - 0	
BROKEN PIECES - PIECES LESS THAN 3/4 OF AN APPARENT SEGMENT POORLY CUT UNIT (INCOMPLETELY CUT UNIT OR IRREGULARLY CUT UNIT)	SEGMENTED														
	BY WEIGHT														
	0	6g	12g	19g	26g	32g	38g	44g	51g	63g	76g	89g	125g	FAILS	
MAJOR STEMS (OVER 4 MM)	0	0	0	0	1	2	2	2	2	3	3	3	3	FAILS	
BLEMISHES TOTAL -----	5g	10g	15g	20g	26g	32g	38g	44g	51g	--	--	--	--		
WRINKLES MAJOR -----	0	3g	6g	9g	13g	16g	19g	22g	26g	35g	45g	55g	65g	FAILS	
H.E.M. - HARMLESS EXTRANEIOUS MATERIAL	1					2				2				FAILS	
ANY OTHER DEFECTS NOT SPECIFICALLY MENTIONED	NOT MORE THAN SLIGHTLY AFFECT APPEARANCE OR EDIBILITY					NOT MORE THAN MATERIALLY AFFECT APPEARANCE OR EDIBILITY				NOT MORE THAN SERIOUSLY AFFECT APPEARANCE OR EDIBILITY					
PIT OR PIT FRAGMENTS (2 MM OR LONGER)	AVERAGE OF 1.3 PITS AND/OR PIT FRAGMENTS PER 300 GRAMS														
	BROKEN PITTED														
SCORE POINTS											31	30	29	28	27 - 0
MAJOR STEMS - OVER 4 MM											1	2	3	4	FAILS
H.E.M. - HARMLESS EXTRANEIOUS MATERIAL											2				FAILS
PIT OR PIT FRAGMENTS (2 MM OR LONGER)	AVERAGE OF 1.3 PITS AND/OR PIT FRAGMENTS PER 300 GRAMS														
ANY OTHER DEFECTS NOT SPECIFICALLY MENTIONED											NOT MORE THAN SERIOUSLY AFFECT APPEARANCE OR EDIBILITY				
MAJOR BLEMISHES & WRINKLES											32	38	44	51	FAILS
											grams	grams	grams	grams	

2.37

APPENDIX F

OLIVE MARKETING ORDER DEFECT LIMITS

Canned Olive
January 1997

	Whole per 50 olives	Pitted per 50 olives	Halved per 255 g (9oz)	Segmented per 255 g (9oz)	Sliced per 255 g (9oz)	Chopped per 255 g (9oz)	Brok Pitt. per 2' (9o
HEVM, HEM, or EVM	1	1	2	2	Fairly free	Fairly free	2
Stems:							
Minor and major stems included	--	--	--	--	--	--	--
Major stems	3	3	3	3	3	3	3
Minor and major blemishes, minor and major wrinkles and mutilated	10	10	No limit	Fairly free	Fairly free	Fairly free	No 1
Provided major blemishes major wrinkles do not exceed	5	5	--	--	--	--	--
Further provided: Mutilated do not exceed	3	3	--	--	--	--	--
Broken pieces and poorly cut units	--	--	--	Fairly free	Fairly free	--	--
Mechanical damage	5	5	--	--	--	--	--
Blowouts, cross- pitted, plunger and damage	--	15	--	--	--	--	--
Obvious split-pit or misshapen	5	--	--	--	--	--	--
Severe blemishes (green-ripe type only)	0	0	5	--	--	--	--

1/ Major blemishes only.

APPENDIX G

CONVERSION TABLE

DEGREE SALOMETER TO PERCENT SALT AT 60°F.

° SALOMETER	% SALT
1	.264
2	.53
3	.79
4	1.06
5	1.32
6	1.58
7	1.85
8	2.11
9	2.38
10	2.64
11	2.90
12	3.17
13	3.43
14	3.70
15	3.96
16	4.22
17	4.49
18	4.75
19	5.02
20	5.28
21	5.54
22	5.81
23	6.07
24	6.34
25	6.60

APPENDIX H

CORRECTIONS FOR SALOMETER READINGS WHEN DETERMINED
AT TEMPERATURES OTHER THAN 60°F

TEMPERATURES

SALOMETER READINGS

°F	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20
55	0	.1	.1	.1	.1	.1	.2	.2	.2	.2	.3	.3	.3	.3	.3	.3	.3	.3	.3	.3
56	0	0	.1	.1	.1	.1	.1	.1	.2	.2	.2	.2	.2	.2	.2	.2	.2	.2	.2	.3
57	0	0	0	.1	.1	.1	.1	.1	.1	.1	.2	.2	.2	.2	.2	.2	.2	.2	.2	.2
58	0	0	0	0	0	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1
59	0	0	0	0	0	0	0	0	0	0	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1

TO BE ADDED TO READING

61	0	0	0	0	0	0	0	0	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1
62	0	0	0	0	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1	.1	.2	.2	.2	.2
63	0	0	.1	.1	.1	.1	.1	.1	.2	.2	.2	.2	.2	.2	.2	.2	.2	.2	.2	.2
64	0	0	.1	.1	.1	.1	.2	.2	.2	.2	.3	.3	.3	.3	.3	.3	.3	.3	.3	.3
65	0	.1	.1	.1	.2	.2	.2	.2	.3	.3	.3	.3	.3	.3	.3	.4	.4	.4	.4	.4
66	0	.1	.1	.1	.2	.2	.3	.3	.3	.4	.4	.4	.4	.4	.4	.4	.5	.5	.5	.5
67	0	.1	.1	.2	.2	.3	.3	.3	.4	.4	.4	.4	.5	.5	.5	.5	.5	.5	.6	.6
68	0	.1	.1	.2	.2	.3	.3	.4	.4	.5	.5	.5	.5	.6	.6	.6	.6	.6	.6	.7
69	.1	.1	.2	.2	.3	.3	.4	.4	.5	.5	.6	.6	.6	.6	.6	.7	.7	.7	.7	.7
70	.1	.1	.2	.2	.3	.4	.4	.5	.5	.6	.6	.6	.6	.7	.7	.7	.8	.8	.8	.8
71	.1	.1	.2	.3	.3	.4	.5	.5	.6	.7	.7	.7	.7	.8	.8	.8	.8	.9	.9	.9
72	.1	.1	.2	.3	.4	.4	.5	.6	.6	.7	.7	.8	.8	.8	.9	.9	.9	.9	1.0	1.0
73	.1	.2	.2	.3	.4	.5	.5	.6	.7	.8	.8	.8	.9	.9	.9	.9	1.0	1.0	1.0	1.1
74	.1	.2	.3	.3	.4	.5	.6	.7	.7	.8	.9	.9	.9	1.0	1.0	1.0	1.1	1.1	1.1	1.1
75	.1	.2	.3	.4	.5	.5	.6	.7	.8	.9	.9	1.0	1.0	1.0	1.1	1.1	1.1	1.1	1.2	1.2
76	.1	.2	.3	.4	.5	.6	.7	.8	.9	1.0	1.0	1.0	1.1	1.1	1.1	1.2	1.2	1.2	1.3	1.3
77	.1	.2	.3	.4	.5	.6	.7	.8	.9	1.0	1.1	1.1	1.1	1.2	1.2	1.2	1.3	1.3	1.4	1.4
78	.1	.2	.3	.4	.5	.6	.7	.9	1.0	1.1	1.1	1.2	1.2	1.2	1.3	1.3	1.4	1.4	1.4	1.5
79	.1	.2	.3	.5	.6	.7	.8	.9	1.0	1.1	1.2	1.2	1.3	1.3	1.3	1.4	1.4	1.5	1.5	1.6
80	.1	.2	.4	.5	.6	.7	.8	1.0	1.1	1.2	1.3	1.3	1.3	1.4	1.4	1.5	1.5	1.6	1.6	1.6
81	.1	.3	.4	.5	.6	.8	.9	1.0	1.1	1.3	1.3	1.3	1.4	1.4	1.5	1.5	1.6	1.6	1.7	1.7
82	.1	.3	.4	.5	.7	.8	.9	1.1	1.2	1.3	1.4	1.4	1.5	1.5	1.6	1.6	1.7	1.7	1.8	1.8
83	.1	.3	.4	.5	.7	.8	1.0	1.1	1.2	1.4	1.4	1.5	1.5	1.6	1.6	1.7	1.7	1.8	1.8	1.9
84	.1	.3	.4	.6	.7	.9	1.0	1.2	1.3	1.4	1.5	1.5	1.6	1.7	1.7	1.8	1.8	1.9	1.9	2.0
85	.1	.3	.5	.6	.8	.9	1.1	1.2	1.3	1.5	1.6	1.6	1.7	1.7	1.8	1.8	1.9	2.0	2.0	2.1
86	.1	.3	.5	.6	.8	.9	1.1	1.2	1.4	1.6	1.6	1.7	1.7	1.8	1.8	1.9	1.9	2.0	2.1	2.1
87	.2	.3	.5	.6	.8	1.0	1.1	1.3	1.4	1.6	1.7	1.7	1.8	1.9	1.9	2.0	2.0	2.1	2.2	2.2
88	.2	.3	.5	.7	.8	1.0	1.2	1.3	1.5	1.7	1.7	1.8	1.9	1.9	2.0	2.0	2.1	2.2	2.2	2.3
89	.2	.3	.5	.7	.9	1.0	1.2	1.4	1.5	1.7	1.8	1.9	1.9	2.0	2.1	2.1	2.2	2.3	2.3	2.4
90	.2	.4	.5	.7	.9	1.1	1.3	1.4	1.6	1.8	1.8	1.9	2.0	2.1	2.1	2.2	2.2	2.3	2.4	2.5

January 1997

TO Ball Packing Co
311 No. Unit
Sangus, Calif.

FROM

California Olive Committee
516 No. Fulton Street
Fresno, California 93728

SUBJECT

MESSAGE

DATE 10-15 1984

Variety: Manz.

Quantity: 412# (EST)

Tank: 287 (RT 1427) //

Tree Ripened

SIGNED

J. J. Jones

REPLY

DATE 11-3 1984

CARRIED as "tree-ripened"

// RT = Red Tag

SIGNED

B. F. Sims, USDA

RETAIN WHITE COPY RETURN YELLOW COPY

SPEED LETTER

OAC-M

NO. 1427

(3)

H O L D

DATE 10-15-84

CODE Tank: 287-412# (Est)

STYLE AND TYPE Tree Ripened

INSPECTOR J. J. Jones

**To be Removed By
USDA Inspector**

SECTION 4
RECORDS AND REPORTS

I. GENERAL

All forms are subject to review by supervisors and other Department officials, and must be legible, neat and complete. Review and prepare reports with care to assure correctness in all details and in order to expedite processing of the records. It is important that all Records and Reports be issued and sent to intended destinations with a minimum of delay.

II. PACK AND CERTIFICATION REPORT FOR CANNED RIPE OLIVES

A. Handler Entries

The handler shall furnish the inspector-in-charge with the original and three (3) copies of the Pack & Certification Report for Canned Ripe Olives (COC-4) following each day of canning. The handler will fill in the heading with the company name and address, page number, and the date packed. For each item packed he will list the variety; the style of pack; the fruit size -- in the case of tree-ripened and green-ripe types, the size and type will be listed together; the numerical can and case size (24-300x407); the container code(s); and the number of cases packed -- to the nearest case. The handler will also fill in the total cases packed. And, a responsible company official will sign the certification statement and state his title.

If more than 10 cases of previously certified items are recanned, this fact should be noted on the COC-4 by the handler.

The Pack and Certification Report pages should be NUMBERED CONSECUTIVELY for each crop year beginning with product packaged on or after August 1 of each year. More than one page per day may be necessary at some plants. Each page used must be numbered. Example: Plant A may issue page No. 1 on the first day of pack. On the second day of pack if 2 pages are necessary they should be numbered 2 and 3.

B. Inspector Review

The inspector will check this report including the page numbers for correctness and will make sure that the handler's certification statement is signed by a responsible company official. If any apparent errors are noted, he will report them to the handler for correction.

C. Inspection Entries

1. Designation of Grade

Record the grade according to U.S. Standards or pass/fail, any pertinent symbol designations (See Appendix B) and the reason for grading an item lower than Grade A -- except for broken pitted style -- for all meeting items in the remarks column of the COC-4. Include in parenthesis following "defects", the type of defect encountered, such as: stems, blemishes, wrinkles, etc.

The original page of the Pack and Certification Report (COC-4) is for the California Olive Committee. (THE DISTRIBUTION OF THIS REPORT IS THE INSPECTORS RESPONSIBILITY) (See distribution)

If an item is designated as "Tree-ripened type": circle the number of cases packed, write "Tree-Ripened" in the remarks column, and subtract the number of cases of tree-ripened packed from the TOTAL CASES PACKED as indicated near the bottom of the page. (Also, complete the corresponding speed-letter which represents the tree-ripened which was canned and forward it to the COC office with the weekly mail).

If an item FAILS the marketing order, it is only necessary to enter "FAILS" in the remarks column. The reason for the product failing will be listed in the certification statement.

2. Certification of Meeting and Failing Lots

The certification statement appears at the bottom of the Pack and Certification Report. Upon receipt of the previous day's Pack and Certification Report from the handler, the inspector will certify the previous day's pack. List all meeting items by line number in the space provided. Example No. 1 covers meeting items.

Example No. 1

Line Number 1 thru 4, 6 and 8 thru 12 listed above etc.

Failing lots shall be listed in the space provided above the meeting certification statement. List all line numbers which fail followed by the reason for failing and the word "and".

Example No. 2

Line numbers 5 and 7 fail account character (and/or size) and.

D. Inspection and Disposition of Failing Lots

Reinspected lots must always be entered on the current day's Pack and Certification Report.

Each time a reinspection is performed, even though the grade and/or size have not changed, the lot must be entered on the report. All of the headings should be filled in. Include the cases inspected under the cases packed column. If no charge is to be made, as in the case disposition without additional inspection, circle the number of cases inspected.

Whenever reinspections or dispositions are reported on a Pack and Certification Report, the number of cases should be included in the cases packed column. Total the cases packed column (do not include circled amounts), and write the new total to the right of the total cases packed. This figure will be used for billing purposes. Drop down a space or two below the regular listed items and write in the item as follows:

1. Lots that Meet on Reinspection

Example:

Inspection of previously failed lot page 5 line 5 dated September 25, 1970.

XWAP

Mission, Whole, Small, 24/300, 25, 126, B defects (stems)

Include the certification of this item in the certification statement by inclusion of the line number with the meeting lots.

2. Lots that Fail on Reinspection

List the same as for meeting lots, above. Include the certification statement by inclusion of the line number, and failing statement in the space provided above the certification statement.

3. Lots that Fail on reinspection and are disposed of on the same day. Include a disposition statement.

Example:

Inspection and Disposition - previously failed page 5 line 5, September 9, 1970.

Mission, Whole, Small, 24/300, ^{XWAP} 26, 126, Fails size

Cans opened, olive pitted and packed as chopped. Included in line 6 above.

4. Disposition of previously inspected lots

If a previously inspected item is disposed of without additional inspection, use the following heading and disposition statement.

Disposition - previously failed page 5 line 3, September 9, 1970.

Mission, Whole, Small 24/300 ^{XWAR} 26, (132), Fails size.

Cans opened, olives disposed of to oil.

or

Cans opened, olives pitted and packed as sliced. Included in line 2 above.

E. Distribution of Pack and Certification Report

The inspector is responsible for the proper distribution of the Pack and Certification Report. Care must be taken to assure that the COC and field office copies are mailed on Monday (in no event later than Tuesday) following the week the inspection was performed.

Original - Each week mail directly to:

California Olive Committee
1903 North Fine #102
Fresno, California 93727

1st Copy - Deliver to the Handler - Daily

2nd Copy - Area Office - Weekly

3rd Copy - Inspector's File (Attach score sheets and worksheets)

III. OTHER REPORTS

The inspector shall maintain such other reports as directed by the Area Office.

IV. DISPOSITION OF FAILING LOTS

Failing lots may be reprocessed under the supervision of the inspection service, disposed of for olive oil production, given to charity, or destroyed.

If the product is on "Hold for Further Evaluation" account failing flavor or sanitation reasons, contact your supervisor.

If the handler wishes to donate failing product to charity, he must first make a written application to and obtain approval from the Administrative Committee prior to disposition. The application should contain the following information:

1. Name and address of the handler and the charitable organization.
2. The physical location of the charitable organization's facilities.
3. The quantity -- in cases, variety, size, can size, and can code of the olives.
4. A certification from the charitable organization that the olives will be used by the organization and will not be sold.

V. DISPOSITION OF NON-CANNING AND LIMITED USAGE SIZE OLIVES

The handler has an obligation for non-canning (undersize and culls) and limited usage size olives. This obligation is equal to the weight of undersize, handler designated culls, and limited usage size olives that he receives. They must be disposed of to authorized outlets under the supervision of the inspection service. The undersize and cull olives must be disposed of as other than canned ripe olives. The limited usage size olives may be used in the production of halved, quartered, segmented, sliced, or chopped style canned ripe olives or may be disposed of as other than canned ripe olives.

A handler must first attempt to meet any deficit in his undersize obligation of a variety by disposing of an equal quantity of undersize olives in that same variety. If a deficit in his undersize obligation still exists, the handler may use any variety undersize obligation. If at the completion of the processing season there is yet a deficit in his undersize obligation, the handler may, with the consent or at the demand of the COC, satisfy his undersize obligation by disposing of an equal quantity of olives of any variety, of any size larger than undersize, and of a quality better than culls.

He must first attempt to meet any deficit in his cull obligation of a variety by disposing of an equal quantity of cull olives in that same variety. If a deficit in his cull obligation still exists, the handler may use any variety of culls to satisfy any other variety cull obligation. If, at the completion of the processing season there is yet a deficit in his cull obligation, the handler may, with the consent or at the demand of the COC, satisfy his cull obligation by disposing of an equal quantity of olives of any variety, of any size larger than undersize, and of a quality better than culls.

A handler must first attempt to meet his limited usage size obligation of a variety by using in authorized production or by disposing of an equal quantity of limited usage size olives of that same variety. If a deficit in his limited usage size obligation exists at the end of the season, the handler may use any variety of limited usage olives to satisfy any other variety limited usage obligation. If, at the completion of the processing season, there is yet a deficit in his limited usage size obligation, the handler may, with the consent or at the demand of the COC, satisfy his limited usage size obligation by disposing of or using in authorized production an equal quantity of olives of any variety, or any size larger than limited usage size and of a quality better than culls.

A. Undersize Olives

If the handler requests that olives being disposed of be used to satisfy his undersize obligation, the inspector must verify that the olives meet undersize requirements.

Non-canning olives, undersize, are olives that are at least fairly uniform in size and have a count per pound in the non-canning range for the variety or are any olives that individually weigh less than the specified weight for the limited usage size for the variety.

If the olives are not at least fairly uniform in size or if the olives do not count in the non-canning range, a sample of at least 100 ounces of these olives must be run over the sample grader. The percentage of olives of the sample that fall into the baffle set to count in the non-canning range for the variety is applied to the lot from which the sample is drawn. If no sample grader is present, use the sample rate and sample size described in Section II. The percentage by count of the olives that individually weigh less than the specified weight for the limited usage size for the variety is applied to the lot from which the sample is drawn.

B. Culls

If the handler requests that olives being disposed of be used to satisfy his cull obligation, the inspector must determine that the olives being submitted meet cull requirements.

The obligation for culls is equal to the amount of handler designated culls at the time of receiving. It is not intended that poor packing practices or processing errors be used to meet this obligation. Floor sweepings or spoiled tanks of olives cannot be certified as culls on the COC-5.

C. Limited Usage Size Olives

When the handler requests obligation credit for his limited usage size olives, the inspector must determine that the olives being submitted meet the limited usage size requirements (See Section 2; II,4,(b) for these requirements). This determination may be completed by the Incoming (Federal-State) Inspector during receiving or by the Outgoing (Processed Products) Inspector during canning operations. In either case the handler must offer or present the limited usage size olives to the inspection service in such a manner that an accurate estimate or actual weight of the olives can be determined prior to being placed into storage or used in the production of limited usage products. (When estimated weights are used, the inspector must verify the weight of enough containers to satisfy himself that the estimates are close.)

During receiving the incoming inspector generally determines whether or not submitted olives meet the requirements of the limited usage size. These olives are either placed in storage for future use or diverted directly into processing as a canned ripe olive. In either case the incoming inspector will attach a Red Hold Card (Red Tag) to either the storage tank or processing vat and prepare a speed-letter indicating the date, variety, size classification or the words "Limited Usage," actual or estimated weight, storage tank or processing vat number, and the Hold Card number; distributing copies to the handler and outgoing inspector. (See Section 3; I,E,3 for similar procedures used in the handling of tree-ripened olives.) The outgoing inspector should, upon receipt of the speed-letter, record all necessary information in his disposition ledger as an aid in future surveillance of the limited usage size olives in storage.

During receiving, the incoming inspection service will handle the surveillance of all Red Tagged limited usage size olives and their movement throughout the storage area. After receiving has been curtailed, the responsibility for surveillance of the Red Tagged limited usage size olives becomes that of the outgoing inspection service.

When the Red Tagged storage tanks of limited usage size olives are emptied or transferred while under surveillance for disposition, credit may be given for the ingoing weight as certified on the speed-letter by incoming inspection. Estimated or actual weights recorded when the tanks were filled should be closely monitored during these transfers. Any extreme or unreasonable shortages should be noted and your supervisor should be informed.

The incoming certified weight of the limited usage size olives may in some instances be waived by the handler and the inspection service and replaced instead by weights taken when the product is transferred between storage and processing. If this method is used, it must be decided prior to the start of the canning season and must be adhered to regardless of any weight changes (gains or losses) in the product as originally reported by the incoming inspection service. The handler will not be permitted to change methods during the canning season.

Any inter-plant movement of Red Tagged limited usage size olives must be accompanied by a sealed speed-memo between the respective inspectors-in-charge involved.

D. The COC-5 (Do's, Don'ts and Distribution)

With the beginning of each crop year a new series of page numbers must be started on the Form COC-5 "Report of Limited and Non-Canning Size and Cull Olives, Inspection and Disposition". They should begin with the number 1 and be consecutively numbered thereafter as issued.

Olives that are of a larger size than required and of a quality better than culls cannot be certified on a COC-5 for obligation purposes without prior approval from the COC Manager's Office.

If this situation occurs, suggest to the handler that he contact the COC Manager's Office.

The handler may request examination of limited usage size, cull or undersize olives without immediate disposition. In such cases, the inspector will identify the olives by attaching a Red Hold Card until they are properly disposed of or used.

Before disposition credit can be given on limited usage size, cull, or undersize olives the handler must furnish to the inspection service (Incoming and Outgoing) a completed Form COC-5. The inspector will examine the form for errors and for conformance with the information contained in his records (disposition ledger) and, if they agree, sign and date the form.

Mail the original completed and signed COC-5 directly to the office; return 1 copy to the handler; and keep 1 copy for the inspector's files.

VI. SIZE CERTIFICATION - CANNING SIZE OLIVES

When Marketing Order sizes are in effect and size certification procedures are implemented for canned whole, pitted and limited use style olives, a handler may elect to have olives size certified by the incoming inspection service and later use these olives in the production of packaged olives.

Each lot must be kept intact and under surveillance by the USDA and identified with a yellow HOLD card. Inspector will receive a Speed Memo from Fed-State Inspector further identifying size certified olives stored in each tank. Information on speed memo includes: HOLD Card No., Storage Tank No., and count range. Record this information in your inspection ledger.

VII. SYMBOL DESIGNATIONS

The use of these symbols on the Pack and Certification Reports promotes brief, uniform reporting of lengthy descriptions sometimes necessary to qualify final grades. These symbols are to be used only on the Pack and Certification Report and product score sheets. (See Appendix B)

Symbols not on this list are not to be used.

Inspectors using these symbols on reports supplied to the plant shall make sure that all designated plant personnel (such as manager, sales manager, and warehouseman) have copies of the key.

VIII. USE OF CONTROL CARD FOR HOLDING LOTS

When it is necessary to request the processor to hold a particular lot or code, these lots must be identified by attaching a Hold Card (Form CCC-H). Some examples may be as follows:

Lots that require additional sampling and inspection to establish the final grade.

Lots that fail to meet grade or size requirements must be held pending regrading or disposition.

Lots of inspected culls, undersize or limited usage size olives held on premises until disposition.

Hold Cards are also used to identify storage tanks of tree-ripened, Sicilian or limited usage size olives.

IX. SURVEILLANCE OF HOLD AND FAILING LOTS OR TANKS

All hold lots or tanks and failing lots shall be controlled by attaching a completed Red Hold Card to the front of each pallet or container. If the lot has been stacked, it is permissible to attach the Red Hold Cards to all accessible pallets. Tape the remaining Red Hold Cards for inaccessible pallets to those that have already been tagged until the handler makes them accessible for tagging. These Red Hold Cards are to be removed only by the Inspection Services or COC representative.

Keep a listing of all hold lots and their disposition in a ledger. At the end of each accounting period take a physical inventory to see that these lots are still in the warehouse and report your findings on a USDA "Hold Lot Inventory" form and distribute as indicated below under end of year reports. Hopefully, all hold lots will be cleared prior to the end of the packing season. However, the handler may carry them over indefinitely.

Before leaving the plant at the end of a packing season take physical inventory of Hold and Failing Lots, including any storage tanks of olives under surveillance, i.e. Sicilian or limited usage size. Make a notation on your listing of the date of the check. Write a letter to management listing the inventory of Hold and Failing Lots. Distribute as follows:

- Original - Plant management
- Copy - File
- Copy - COC Office
- Copy - Field Office

At the beginning of a new packing season again take physical inventory. If any lots are unavailable, ask management for an explanation. Report any lots not located along with management explanation to the COC Manager by memo through your supervisor.

X. SANITATION SCORE SHEET

A sanitation score sheet Form 416-6 and continuation sheet Form 416-5 will be used for rating plant sanitation prior to the start of and during each shift. Three rating columns are available so that three shifts or less may be rated on the same sheet. A sheet representing the sanitation rating for a shift must be given to a designated plant employee prior to the start of the shift so that any necessary cleanup discrepancies may be corrected.

Plants under the Quality Assurance Program will follow the Sanitation procedure in their Quality Assurance Manual.

XI. REQUESTS FOR CERTIFICATES

Use of a written request for a certificate is recommended. A request form which provides all necessary information for certification and distribution of the certificate copies leaves little room for misunderstandings between the processor and the inspector. When properly filled for later reference, copies of the request provide the processor and inspector with a definite record of past certifications. (See Appendix A).

XII. COMPLAINTS AND POTENTIAL VIOLATIONS

Complaints regarding the requirements of the Order shall be referred to the Manager of the California Olive Committee.

The USDA inspector shall immediately report to his supervisor any complaints regarding inspection or any potential violations of the Marketing Order.

On all complaints, the Inspector or the Supervisor shall prepare a written report which will include the nature of the complaint, name of individual who made the complaint, time, date, and disposition or action taken. Copies of the report will be forwarded to the Field Office, Regional Office and the Office of the COC.

Instances of potential violation of the Marketing Order shall be reported by the Officer-in-Charge to the Office of the COC with copies to the Regional Office and the Fresno Marketing Field Office.

REQUEST FOR USDA CERTIFICATE

OCTOBER 1964

REQUEST NO _____ DATE _____

APPLICANT NAME _____ APPLICANT ADDRESS _____

RECEIVER OR BUYER _____ RECEIVER OR BUYER ADDRESS _____

DATE DESIRED _____ PERSON REQUESTING & TITLE _____

CONTRACT NO. _____ PURCHASE ORDER NO. _____

LOCATION IN WAREHOUSE	STYLE OF PACK	NUMBER OF CASES	TYPE AND SIZE OF CONTAINER	CODES OR OTHER MARKS

BASIS FOR CERTIFICATION Case Stamping Check Loading
 Condition of Container

Specification: U.S. Standard Fed. Spec. Buyer Spec.

Date Forwarded by USDA _____

Distribution of Certificates	Original	Copies	Tissues

DESIGNATIONS FOR CANNED OLIVES TO BE SHOWN ON RELATED USDA REPORTS

- 1a. Low average drained weight. 1/
- 1b. Most containers fail drained weight. 1/
- 1c. Low drained weight. Individual containers below limits for good commercial practice 1/
- 4b. Fails count requirements. 1/
- 5a. Fails declared label weight. 1/
- 6b. Fails FDA Standard of Fill. Excessive headspace. 1/
- 7b. Fails USDA Standard for product description. 1/
- 9a. Low average fill weight. 1/
- 9b. Fails fill weight control limits account low subgroup average. 1/
- 9c. Fails fill weight control limits account low individuals. 1/
- 9d. Fails fill weight control limits account all M_i or \bar{X} values below \bar{X}'_{min} .
- 10a. Lot contains some zero vacuums. 1/
- 10b. Lot contains some vacuum readings 1 through 4 inches. 1/
- 11. Container condition fails acceptance criteria. 1/
- 12. Fails buyer's specification or specific contract requirements. 1/
- 13. Inaccurate, partial or illegible coding (embossing, stamping or ring marks.)

1/ NOT TO BE MIXED WITH LOTS MEETING REQUIREMENTS FOR UNQUALIFIED CERTIFICATION