

FEDERAL PURCHASE PROGRAM SPECIFICATION (FPPS) FOR TURKEY TACO FILLING

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

Supersedes: Turkey Taco Filling April 2013 –
Changes from pervious requirements in [blue](#)

Effective: July 2017

100 ITEM DESCRIPTION

110 Turkey Taco Filling (100119) – Frozen, fully-cooked turkey taco filling, produced from ready-to-cook, non-basted, young turkeys or turkey carcasses and parts. The commodity shall be packaged in [ten 3-pound](#) or [six 5-pound](#) packages [to a net weight of 30 pounds](#) in each fiberboard shipping container. A purchase unit shall consist of 1,300 shipping containers totaling 39,000 pounds.

200 APPLICABLE DOCUMENTS

210 The following documents are incorporated as part of this USDA, AMS, [FSCS Division FPPS-Turkey Taco Filling – July 2017](#):

210.1 [AMS/ LPS/Quality Assessment Division \(QAD\) Policies and Procedures.](#)

210.2 [Poultry Products Inspection Regulations \(9 CFR § 381\).](#)

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

210.4 [AMS Master Solicitation for Commodity Procurements and Solicitation.](#)

300 CHECKLIST OF REQUIREMENTS

310 [Domestic Products – Refer to the current AMS Master Solicitation for Commodity Procurements.](#)

320 [Food Defense – Refer to the current AMS Master Solicitation for Commodity Procurements.](#)

400 HARVESTING

- 410 All harvesting activities shall comply with all applicable Food Safety and Inspection Service (FSIS) regulations and requirements, including 9 CFR § 381, and shall be done under FSIS inspection.
- 420 Humane Handling – All poultry shall be humanely handled in accordance with FSIS Directive 6100.3.

500 PROCESSING

- 510 All processing activities shall comply with all applicable FSIS regulations and requirements, including 9 CFR § 381, and shall be done under FSIS inspection.
- 520 Performance Standards – Product shall be produced under FSIS pathogen reduction standards, as specified in 9 CFR § 381.
- 530 Date Processed – The commodity shall not be processed or packaged more than 90 days prior to the first day of the delivery period.
- 540 Inspection for contract and FPPS compliance shall be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 CFR § 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*). The AMS Grader shall be responsible for certification of compliance with the requirements of this FPPS for chilled turkey carcasses and parts; size-reduced turkey products; ground turkey; processing, formulation, packaging, cooking of the commodity, and packing; turkey taco filling; freezing; labeling and marking; sampling; laboratory results; net weight; and checkloading.
- 541 AMS Certification – USDA/AMS, LPS Program’s QAD field office or the Director of the QAD, LPS Program, AMS, USDA, Room 3953-S, STOP 0258, 1400 Independence Avenue, SW, Washington, DC 20250-0258, telephone (202) 720-3271.
- 542 All steps in the manufacturing process shall be under the direct supervision of an AMS Grader and as outlined in QAD Policies and Procedures. Quality and compliance with product requirements shall be determined in accordance with those policies and procedures. The AMS Grader may also select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination.
- 543 Lot Definition – A lot is the amount of packaged commodity produced during a processing shift.

- 543.1 Sub-Lot – Contractor shall clearly identify sub-lot size and maintain the identity and traceability of each sub-lot.
- 550 Turkey from Other Plants – Turkey carcasses and parts may be transferred or obtained from other plants, provided it:
- 550.1 Has been processed, handled, and identified in accordance with this FPPS; and
- 550.2 Complies with the non-basted, organoleptic, and other applicable requirements of this FPPS as evidenced by USDA certification. USDA certification may occur either at the plant of origin or at the receiving plant.
- 551 Type, class, and specific name of the product, part, boneless part, or meat; date harvested or date placed in frozen storage; and the USDA-assigned plant number shall be shown on each shipping container.
- 552 The chilled turkey and turkey carcasses and parts shall maintain an internal product temperature between 26 °F (-3.3 °C) and 40 °F (4.4 °C) during transit, from plant origin to destination.
- 560 The commodity shall be produced from meat (with skin attached or without skin), non-basted carcasses, and parts (no solution or ingredients added).
- 561 Skin that is not attached to meat shall not be used in the commodity.
- 562 Meat Time Requirements – The chilled commodity shall be processed, packaged, packed, and placed in a freezer within 7 calendar days after the date of harvest.
- 562.1 Within this 7-day timeframe the ground turkey shall be fabricated into the cooked commodity within 72 hours after size reduction.
- 563 Frozen meat may be used when:
- 563.1 produced from freshly slaughtered turkeys;
- 563.2 packaged to protect against quality deterioration during frozen storage and identified so the time in storage and the class, kind, and specific deboned turkey product can be determined;
- 563.3 held not more than 180 days in frozen storage; and
- 563.4 product shows no evidence of thawing and refreezing or freezer deterioration. After tempering, the meat shall be used to produce the finished cooked

commodity within 48 hours. The temperature of the meat **shall** not exceed 40 °F (4.4 °C) during the tempering process.

- 564 Other than the final freezing process for finished, packaged commodity, the commodity **shall** not be derived from turkey meat (carcasses, parts, or ground turkey) that has been frozen more than one time.
- 565 Maximum Temperature – The temperature of the carcasses, bone-in or boneless parts, and skin **shall** not exceed 55 °F (12.8 °C) at any time during preparation or processing into ground turkey.
- 566 Cooling Requirements – Carcasses and bone-in or boneless parts which are not used in the ground turkey on a continuous basis **shall** be cooled by methods or media to ensure that the internal product temperature is continuously lowered to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C).
- 566.1 Cooling Medium – Cooling methods and media (e.g., use of liquid carbon dioxide (CO₂), dry ice or liquid nitrogen (N₂)) may be used to maintain the temperature of meat and parts.
- 566.2 Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat or parts **shall** not be incorporated into the ground turkey. Liquid associated with normal product purge is acceptable.
- 567 Neck and crop skin **shall not** be used in ground turkey.
- 568 Desinewing Requirements – The long bone (tibiotarsus) **shall** be removed from the drumsticks (with or without attached skin) prior to processing through a desinewer to remove the tendons.
- 570 Organoleptic Requirements – Meat, boneless parts, deboned drumsticks, and parts (bone-in) **shall** be examined on a continuous basis for the organoleptic requirements **shown** in Table 1. Any product that does not comply with the organoleptic requirements will be rejected for use under this **FPPS**.
- 571 **Meat Defects and Formulation Requirements**
- 571.1 A sample of 30 pieces of meat, boneless parts, deboned drumsticks, and parts (bone-in) **shall** be examined for the defects **shown** in Table 1 before formulation or size reduction. The frequency of sampling and the number of defects allowed **shall** be those outlined in **QAD's** Sample Plan Level 1. If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents **shall** be rejected.

- 571.2 If simultaneous size-reduction and bone removal systems are to be used, boneless parts and deboned drumsticks shall be examined for the applicable defects **shown** in Table 1 except for the presence of bone or bone-like material, hard tendonous material, or cartilage (gristle).
- 572 Formulation Requirements – Ground turkey **shall** be formulated according to one of the following two formulas:
- 572.1 Meat and Skin Basis – Formula is based on deboned meat (with skin attached or without skin) or boneless parts. The maximum amount that can be used in a formula **shall be** specified.
- 572.1.1 White Meat (with skin attached or without skin) – The maximum amount of white meat that can be used in a formula is 30 percent of the total weight of the formula. The white meat may be wing meat or scapula portion. Other white meat trimmed from the frames (white frame meat) may be used. White frame meat is limited to no more than 3 percent of the total weight of the formula.
- 572.1.2 Dark Meat (with skin attached or without skin) – Boneless thighs or boneless and skinless thighs (not more than one-half of meat missing) or desinewed drumstick meat may be used. Dark meat trimmed from the frame (dark frame meat) may be used. Dark frame meat is limited to no more than 2 percent of the total weight of the formula.
- 572.2 Bone-in Basis – Formula is based on bone-in parts (with or without attached skin). The maximum amount of a specific part that can be used in a formula **shall be** specified. These parts are for preparation of ground turkey by mechanically removing the meat and skin directly from the parts and simultaneously reducing the size of the meat and skin (mechanical and simultaneous reduction process).
- 572.2.1 Drumsticks/Thighs – Drumsticks and/or thighs may be used.
- 572.2.2 Wings – Wings may be whole wings, the first portions, or attached first and second portions. Wing tips can only be used when they are part of a whole wing. The maximum amount of wings or wing portions that can be used in a formula is 40 percent of the total weight of the formula.
- 573 Skin – Skin that is attached to the chilled or frozen meat or parts may be formulated according in natural proportion only.
- 574 Processing and Size Reduction
- 574.1 Processing – The meat (with skin attached or without skin) **shall** be processed and blended, as applicable, and reduced in size by equipment and

procedures that produce a uniform blend of meat and skin with muscle fibers and strand-like texture, and having the functional properties of ground turkey.

- 574.2 Size Reduction – Meat (with skin attached or without skin) for the ground turkey **shall** be reduced in size by one of the following procedures:
 - 574.2.1 Ground through a plate with holes 0.125 inch (1/8 inch) (3.175 mm) in diameter;
 - 574.2.2 Desinewed or reduced through a desinewer plate or screen with holes 0.0591 inch to 0.0787 inch (1.5 mm to 2.0 mm) in diameter or as required to ensure equivalent removal of tendons present in the meat;
- 574.3 Unacceptable Size-reduced Products
 - 574.3.1 Comminuted meat;
 - 574.3.2 Any skin that is not attached to the meat;
 - 574.3.3 Meat reduced to an emulsified or pasty consistency; or
 - 574.3.4 Meat which developed a discoloration during size-reduction process.
- 575 Cooling Size-Reduced Turkey – Cooling methods and media (e.g., liquid CO₂/dry-ice or liquid N₂) may be used before, during, or after size reduction. Ice or ice water may not be used to lower the temperature of the ground product.
- 576 Temperature of Size-Reduced Turkey – Temperature of ground turkey or any size-reduced component of the product (ground, desinewed, or mechanically reduced meat and skin) hereinafter referred to as “ground turkey / ground product” **shall** not exceed 55 °F (12.8 °C).
- 580 Organoleptic Requirements and Defects
- 581 Organoleptic Requirements – The ground turkey **shall** be examined on a continuous basis for the organoleptic requirements **shown** in Table 2. Any ground turkey that does not comply with the organoleptic requirements **shall** be rejected for use under this **FPPS**.
- 582 Defects – A 5-pound sample of ground turkey **shall** be examined for the defects **shown** in Table 2 prior to formulating into the commodity. The defect requirements **shall** be examined in the fresh state.
 - 582.1 The examination for bone **shall** be made separately from the examination for other defects.

- 582.2 Regardless of the kind and number of defects (within Table 2) found, any sample containing bone and bone-like material **shall** be cause for rejection of the product the sample represents.
- 582.3 The frequency of sampling and the number of defects allowed **shall** be those outlined in QAD's Sample Plan Level 2 (SPL-2). If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents **shall** be rejected.
- 583 Ground Turkey Rework – Ground turkey may be reworked provided:
- 583.1 the temperature of the ground turkey has not exceeded 55 °F (10 °C) and has been maintained at that temperature or lower,
- 583.2 complies with organoleptic requirements, and
- 583.3 is incorporated into batches of ground turkey within 12 hours.
- 583.4 Time and Temperature Requirements – Ground turkey which has been chilled, packaged, and maintained at a product temperature of not higher than 40 °F (4.4 °C) or lower than 26 °F (-3.3 °C) may be reworked within 72 hours from the end of the shift it was produced. When the chilled ground turkey is reworked, the temperature of the commodity **shall** not exceed 40 °F (4.4 °C) during tempering.
- 584 Freezing Ground Turkey – If the ground turkey is frozen prior to being processed into the finished commodity, the ground turkey **shall** be packaged and/or packed (to protect against quality deterioration), and continuously lowered to an internal temperature of 0 °F (-17.8 °C) or lower within 72 hours from the time of entering the freezer. If any sample of packaged ground turkey does not comply with the freezing requirements, the product or lot the sample represents **shall** be rejected for use under this **FPPS**.
- 585 Processing Ground Turkey into Commodity
- 585.1 Temperature – The internal product temperature of ground turkey **shall** be not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) before it is processed into the commodity and **shall** be determined just before it is formulated and mixed with spices and flavorings. Unless otherwise specified, chilled ground turkey **shall** be fabricated into the cooked commodity within 72 hours after grinding.
- 585.2 Ground turkey that does not comply with the temperature requirements of this section **shall** be rejected for use under this **FPPS**.

- 586 Frozen ground turkey may be used when:
- 586.1 Packaged to protect against quality deterioration during storage and identified so the time in storage can be determined;
 - 586.2 Held not more than 60 days in frozen storage if produced from freshly slaughtered turkey carcasses, and parts;
 - 586.3 The product shows no evidence of thawing and refreezing or freezer deterioration; and
 - 586.4 The product temperature is not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) during tempering or prior to processing into the commodity. After tempering, the ground turkey **shall** be used in the production of commodity within 36 hours.
- 587 Other than the final freezing process for finished, packaged commodity, the commodity **shall** not be derived from turkey meat (carcasses, parts, deboned meat or ground turkey) that has been frozen more than one time.
- 590 Ground Turkey From Other Plants – Ground turkey may be transferred or obtained from other plants to produce the commodity, provided it is:
- 590.1 Processed, handled, and identified in accordance with this **FPPS** and meets the temperature requirements, and
 - 590.2 Processed from turkey carcasses and parts which comply with the non-basted, organoleptic, and other applicable requirements of this **FPPS** for turkey as evidenced by USDA certification.
- 591 Type, class, specific name of the product, date slaughtered or placed in frozen storage, and the USDA-assigned plant number **shall** be shown on each shipping container of ground turkey.
- 592 The chilled and/or frozen ground turkey **shall** be maintained at an internal product temperature not higher than 40 °F (4.4 °C) **during transit, from plant origin to destination.**
- 5000 Processing Sequence – Commodity processing **shall** follow the sequence stated within this paragraph. Unless otherwise specified, ground turkey processing, turkey taco formulation, mixing, packaging then cooking or cooking then packaging (or other packaging/cooking alternative), chilling, and freezing of the commodity **shall** be a continuous process that complies with the time and temperature requirements of this **FPPS**. Formulation and mixing

may be accomplished during the cooking processes.

5010 Formulation – Proportions of ingredients required in preparing the commodities are as follows:

Ingredients	<u>Percent</u>
Ground Turkey (Minimum)	60.00
Water (Maximum)	26.00
Tomato Paste (Range)	6.00 – 10.00
Spices/Flavorings/Other Ingredients Formulation (Range)	4.00 – 6.00
Soy Protein (Maximum percent of total formula) (Range)	4.00 – 6.00
Shall Total	100.00

5011 Fat content shall not exceed 11% of the finished product.

5012 The sodium content of the cooked turkey taco filling shall be equal to or lower than 300 mg per 100 g.

5013 “Other ingredients” may include potassium phosphate. Spices/flavorings shall be the types used in conjunction with mild turkey taco flavoring. Ingredients to be included are cumin, paprika, garlic powder, onion powder, and chili powder.

5014 Soy protein (in a dry form, not hydrated) used in the spices/flavorings/other ingredients formulation shall not exceed 6 percent of the total formula. The contractor shall furnish the AMS Grader a statement by the manufacturer certifying the spices, flavorings, and other ingredients are in compliance with this FPPS prior to production.

5015 Processing aids (e.g., anti-caking agents, anti-dusting agents, or other manufacturing aids) are allowed. If processing agents are used, the ingredients and amount of ingredients listed in the formulation shall remain the same. Gluten and MSG are not allowed.

5020 Mixing – A uniform blend of ground turkey, water, and spices/flavorings shall be achieved by mechanically mixing all ingredients prior to packaging.

5030 Cooking

5031 Formulated raw commodity must be cooked prior to or after packaging (or other packaging/cooking alternative) in accordance with the processing sequence.

- 5032 The commodity shall reach an internal temperature of at least 165 °F (73.9 °C) during cooking. Cooking methods and product temperature shall be monitored by FSIS personnel and procedures.
- 5040 Reprocessing Cooked Commodity – Cooked and packaged commodity which does not meet the FPPS requirements may be reprocessed provided the:
- 5041 Product is reprocessed within 8 hours from the time of cooking;
- 5042 Temperature of the cooked commodity has been lowered to not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) if the product is held for longer than 8 hours; and
- 5043 Commodity is incorporated into raw formulated commodity (at a maximum of 5 percent of the formulated batch), packaged, cooked, and placed in a freezer within 48 hours of packing.
- 5050 Freezing – Immediately after cooking, the product shall be placed under refrigeration where the internal product temperature of the cooked packaged commodity is continuously lowered. The commodity shall be packed and placed in a freezer within 48 hours of packing. The internal temperature of the packaged and packed commodity shall be continuously lowered to 10 °F (-12.2 °C) or lower within 72 hours from the time of entering the freezer. If any sample of the commodity does not comply with the freezing requirements, the product or lot the samples represent shall not be accepted for use under this FPPS.
- 5060 Metal Detection – The commodity shall be examined by a metal detection device capable of detecting metallic contaminants including, but not limited to, stainless steel shavings, metal clips, metal fragments from cutting equipment, and pieces of metal according to QAD policies and procedures.
- 5061 Commodity found to be contaminated with metal shall be handled in accordance with FSIS procedures. Other procedures for the examination of the commodity shall be approved by the Director of the FSCS Division in writing.

600 PACKAGING AND PACKING

- 610 The contractor shall assure that all packaging, packing, labeling, closure, marking, and palletization comply with the National Motor Freight Regulations and FSIS regulations and the requirements listed below.
- 620 Packaging – All packaging and packing materials shall be clean and in new condition, shall not impart objectionable odors or flavors to the commodity, shall be safe for use in contact with food products (cannot adulterate product or be injurious to health), and shall be tamper-evident. Tamper-evident is

defined as packaging and packing materials with one or more indicators or barriers to entry, which, if breached or missing, can reasonably be expected to provide visible evidence that tampering has occurred. All packaging material shall comply with FSIS regulations (9 CFR § 381.144(c)).

- 621 Plastic-film Bags – Bags for packaging and/or packing the commodity shall be a polyethylene-film bag with a wall thickness of not less than 4 mil (0.004 inch); and shall protect the commodity from dehydration, freezer burn, or quality deterioration during the conditions of use. Closure methods shall be approved by a representative of the QA Division.
- 621.1 The bag and seal shall be of a design and structure to remain intact (sealed) and prevent leaking when the commodity is reheated (by recipient) in a boiling water bath.
- 630 Shipping Containers – Shipping containers shall:
- 630.1 Be good commercial fiberboard containers that are acceptable by common or other carrier(s) for safe transport to point of destination,
- 630.2 Be of such size to pack the commodity without slack filling or bulging,
- 630.3 Withstand the stresses of handling, shipping, stacking, and storage, and
- 630.4 Be closed by commercially accepted methods and materials. Steel or wire straps shall not be used for final closure.
- 631 Staples shall not be used for final closure of shipping containers. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. Staples may be used to manufacture and to assemble the fiberboard shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.
- 632 Packing – Ten 3-pound or six 5-pound bags with 30 pounds net weight of commodity shall be packed in a fiberboard shipping container.
- 640 Organoleptic Requirements and Product Characteristics
- 641 After packaging, a package of commodity shall be sampled and examined for organoleptic requirements. If any sample does not comply with the organoleptic requirements, the product the sample represents shall be rejected for use under this FPPS.

- 641.1 Additionally, the commodity **shall** be evaluated for the product characteristics (defects) shown in Table 3. The frequency of sampling and the defects allowed **shall** be in accordance with those outlined in LPS Program's SPL-2.
- 642 Production samples **shall** be evaluated, reviewed, and compared to a pre-bid sample to ensure compliance with the product characteristics found in Table 3.
- 642.1 The frequency of production sample review **shall** be in accordance with LPS Program's "Sampling Requirements and Procedures for Turkey Taco Filling."

700 LABELING

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

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

- 711 Commercial labeling or USDA labeling shall be used. When commercial or USDA labeling is selected, the shipping containers within a purchase unit shall be labeled in that format. The contractor shall use the same label format (either commercial or USDA) within a purchase unit.
- 720 Commercial Labeling Requirements
- 721 Commercially labeled packages and shipping containers **shall** be labeled in accordance with FSIS requirements. Labeling **shall** be approved by FSIS prior to acceptance for use under this **FPPS**.
- 722 Commercial labels **shall** be the processor's own commercial labels. Distributors' labels will not be allowed.
- 723 Traceable Product – The processor **shall** establish a product identification and record system that clearly links product by place and time of manufacture to specific USDA contracts and destinations. When the company uses the same commercial label for the product certified as complying with this **FPPS** and commercial product, the identification system **shall** differentiate between USDA and commercial products. An alpha numeric code may be used for information that is in addition to FSIS labeling requirements. The required product identification and record system, including codes, **shall** be reviewed by USDA/**AMS** before production begins for the contract(s).

- 724 Nutrition Facts, Ingredients and Allergen statements on shipping containers. Nutrition Facts **shall** be provided. The ingredient statement, even for single ingredient foods, **shall** be included as a statement separate from the name of the product, e.g. Ingredients: _____. The allergen statement **shall** be provided in the format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains _____. **For additional guidance refer to the Compliance Guidance at:**
- <http://www.fsis.usda.gov/wps/wcm/connect/f9cbb0e9-6b4d-4132-ae27-53e0b52e840e/Allergens-Ingredient.pdf?MOD=AJPERES>
- 730 USDA Labeling Requirements
- 731 When USDA labeling is used, any deviation from labeling requirements in this **FPPS shall** be approved by the Contracting Officer, in writing, prior to the start of production. Labeling and marking of the **product shall** be in accordance with this **FPPS**.
- 732 Labeling and marking information **shall** be water-fast, non-smearing, of a contrasting color, clear, and readable.
- 733 USDA Labeled Shipping Containers Requirements
- 733.1 Labeling and marking information **shall** be preprinted, stamped, or stenciled on each shipping container; or printed on a self-adhesive label and applied to each shipping container. This information, in essentially the same layout, is provided in EXHIBITS 1 and 2.
- 733.2 Nutrition Facts, Ingredients and Allergen statements on shipping containers. Nutrition Facts must be provided. The ingredient statement, even for single ingredient foods, must be included as a statement separate from the name of the product, e.g. Ingredients: _____. The allergen statement must be provided in the format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains _____.
- 734 Universal product bar code.
- 734.1 A Universal Product Code (UPC), symbol and code, called Interleaved 2 of 5 (I 2/5), must appear on each shipping container. The complete code, including the check digit, must be printed in machine-readable and human-readable form. The start and stop indicators will be included in the bar codes. Printing, readability, and scanability of the bar code must be in accordance

with UPC guidelines published by GS1 US, Princeton Pike Corporate Center, 1009 Lenox Drive, Suite 202, Lawrenceville, New Jersey 08648.

- 734.2 The contractor will use the code furnished by USDA. USDA has acquired a unique manufacturer's identification number for the commodity purchase programs and will use a unique item code number for the commodity purchased under this Specification. The contractors need not join GS1 US.
- 734.3 The 14-digit UPC code for shipping containers of this commodity is:
1 07 15001 00119 8
- 734.4 The UPC code must be placed in the lower right-hand corner of the principal display panel of each shipping container.
- 735 Recycle Symbol and Statement – The contractor shall place somewhere on the surface of each recyclable shipping container the recycle symbol shown in EXHIBIT 3. The statement "PLEASE RECYCLE" is to be placed under the symbol. The recycle symbol and statement must be legibly printed in permanent ink.
- 736 Inventory Control Information – The processor may include any additional information (including bar codes) for processor inventory control purposes. This information may be applied somewhere on the surface of the shipping container but must not cover or conflict with the labeling requirements of this Specification.
- 740 Use of Previously Printed USDA Labeling Materials
- 740.1 Carryover inventories of existing supplies of printed packing materials (USDA labeling) from the Commodity Specification for Turkey Taco Filling from the preceding year may be used. If the ingredients statement, labeling of the ingredients, or nutrition facts information or panel changes from that printed on existing supplies, the contractor/processor must request temporary approval for use of carryover inventories from FSIS.
- 740.2 Shipping containers or labels with incorrect: (1) plant number, (2) net weight, (3) date packed, (4) name of product, (5) ingredients statement, or (6) nutrition facts information or panel must be corrected before they are used. The incorrect information must be blocked out and the correct information legibly printed, stamped, or stenciled in permanent ink. Additionally, the name, address, and phone number of the processor must appear on each shipping container.
- 750 Additional Labeling Issues
- 751 The following are not acceptable for use under this FPPS:

- 751.1 Commercial labels that do not have a processor traceability system and code.
- 751.2 Commercial labeling traceability coding and systems that have not been reviewed by a representative of USDA, AMS, LPS Program, QA Division.
- 751.3 Distributor commercial labels.
- 751.4 Two or more different commercial labels in the same purchase unit.
- 751.5 Commercial labels and USDA labels in the same purchase unit.
- 760 Free Along Side (FAS) Vessel Deliveries
- 761 FAS vessel deliveries that are not source loaded in a seavan are required to show the final destination's overseas address as provided in the Sales Order/Item Number. The address must be clearly printed on at least two sides of each pallet.
- 800 FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY**
- 810 Packaging Defects – Packages in a delivery unit **shall** be examined for defects that affect protection, expose product, or permit dehydration or freezer burn; or permit quality deterioration during storage, such as tears, holes, or improperly sealed or closed packages.
- 811 Packing Defects – Shipping containers in a delivery unit **shall** be examined for condition, labeling, and marking defects according to the United States Standards for Condition of Food Containers.
- 812 Tolerance for Defects – If samples of packaged commodity or the shipping containers in a delivery unit have more defects than the maximum tolerance for the **applicable QAD sample plan**, the delivery unit **shall** be rejected.
- 820 A purchase unit or delivery unit **shall** total 39,000 pounds net.
- 821 Each delivery unit, except **for on-line verification of net weights**, **shall** be examined for compliance with the net weight requirements at time of checkloading.
- 822 The tare weight of all packing materials **shall** be determined by weighing a representative sample of all packaging components such as plastic-film bags and fiberboard containers.

- 823 Fifteen (15) shipping containers **shall** be selected at random from a delivery unit to determine net weight. The total net weight of the 15 shipping containers **shall** be equal to or greater than 450 pounds.
- 824 If the total net weight is less than 450 pounds, the delivery unit **shall** be rejected.
- 824.1 A rejected delivery unit may be reworked and reoffered one time only. However, if an individual shipping container in the sample of the reworked delivery unit has a net weight of less than 30 pounds, the delivery unit **shall** be rejected.
- 825 As an alternative to test weighing at time of checkloading, the contractor may request on-line verification of net weights. Upon receiving the request, a Federal-State supervisor, USDA, AMS, QA Division, LPS Program (or their designee), **shall** determine that the facilities and procedures are in accordance with applicable LPS Program's Instructions for this **FPPS**.
- 830 Loading and Shipping Frozen Commodity
- 831 Visual Inspection – Frozen **cooked** commodity showing any evidence of defrosting, refreezing, or freezer deterioration **shall** be rejected for use under this **FPPS**.
- 832 Internal Product Temperature
- 832.1 The frozen **cooked** commodity **shall** be 2 °F (-16.7 °C) or lower at time of loading. Delivery units with internal product temperatures exceeding 2 °F (-16.7 °C) and up to 5 °F (-15 °C) **shall** be tentatively rejected. Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2 °F (-16.7 °C) or lower and reoffered one time only. Delivery units exceeding 5 °F (-15 °C) or delivery units that have been tentatively rejected and exceed 2 °F (-16.7 °C) when reoffered **shall** be rejected for use under this **FPPS**.
- 832.2 Optional Temperature Verification – The contractor may request an alternate method utilizing product temperature-sensing devices. If this option is selected, a Federal-State Supervisor **shall** determine that the facilities, equipment, procedures, and the contractors' current level of freezing compliance are in accordance with the established guidelines outlined in applicable LPS Program's instructions for this **FPPS**.
- 840 Inspection and Checkloading
- 841 Requirements – Inspection for contract compliance **shall** be made by a USDA representative, in accordance with 7 CFR § 70, FSIS regulations, and this

FPPS, at site of processing, both during and after processing and packaging. Inspection records shall be complete and made available to USDA, as requested, to assure contract compliance.

842 Procedures – The inspection and checkloading shall be performed by the AMS Grader. Procedures to be followed and a schedule of fees for these services may be obtained by contacting the nearest QAD field office or the Director of QAD, USDA, AMS, LPS Program, Room 3932-S, STOP 0258, 1400 Independence Avenue, SW, Washington, DC 20250, telephone (202) 720-3271. The quality, quantity, weight, packaging, packing, and checkloading of the commodity shall be evidenced by certificates issued by the AMS Grader. The contractor shall not ship the commodity unless informed by the AMS Grader that the designated commodity to be shipped meets the requirements of the AMS Master Solicitation of Commodity Procurements, Solicitation, and this FPPS.

900 PALLETIZED UNIT LOADS

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

920 Size and Style of Container – Only one size and style of shipping container shall be used in any one delivery unit.

1000 SHIPMENT AND DELIVERY

1010 Shipment and Delivery – Refer to the current AMS Master Solicitation of Commodity Procurements.

1011 In addition, the contractor shall adhere to the following provisions:

1011.1 Each shipping container shall be identified with a USDA Contract Compliance stamp with the applicable certificate number. An AMS Grader, or other authorized personnel under the supervision of the AMS Grader, shall stamp one end of each shipping container prior to shipment. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container.

1011.2 As an alternative to stamping, the contractor may preprint the stamp on the shipping container or label. Prior approval by QAD is required before using this alternative method.

1012 A copy of the original USDA Poultry Products Grading Certificate issued at

time of checkloading shall accompany each shipment.

1012.1 Railcar or Piggyback – If shipment is by rail or piggyback, the certificate shall be placed in the railcar or trailer for easy access to the AMS Grader, warehouseman, or consignee, as applicable.

1012.1 Trucks – If shipment is by truck, the driver shall, upon delivery, give the certificate to the AMS Grader, warehouseman, or consignee, as applicable.

1020 Loading and Sealing of Vehicles

1021 Refer to the current AMS Master Solicitation on Commodity Procurements.

1030 Delivery Notification

1031 Refer to the current AMS Master Solicitation on Commodity Procurements.

1040 Split Deliveries

1041 Refer to the current AMS Master Solicitation on Commodity Procurements.

1100 DESTINATION EXAMINATION

1110 The cost of a destination examination, before or after delivery, by an AMS Grader on accepted product will be for the account of USDA. Costs for destination examinations of rejected delivery units shall be for the account of the contractor. The origin AMS Grader shall make arrangements for destination examination prior to delivery.

1111 Commodity Requirements – Before acceptance by consignee, the commodity may be examined by an AMS Grader on a spot-check basis for temperature, condition, identity, and when applicable, count. The commodity may be examined for conformance to contract provisions at any time required by the Contracting Officer.

1112 Temperature – The commodity shall arrive at destination at an average internal product temperature not to exceed 10 °F (-12.2 °C) with no individual temperature exceeding 15 °F (-9.4 °C).

1200 PRODUCT ASSURANCE AND COMPLAINT RESOLUTION

1210 Product Assurance – The Contractor shall guarantee that the product complies with all FPPS requirements and provisions set forth in the AMS Master Solicitation of Commodity Procurements and Solicitation.

1211 Waiver Requests – Contractor shall submit all waiver requests directly to the Commodity Procurements Staff (CPS) Contracting Officer for review and determination. Full list of CPS contacts can be found at:

<https://www.ams.usda.gov/sites/default/files/media/AMS%20Commodity%20Procurement%20Staff%20Contact%20List.pdf>

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

Table 1. Organoleptic Requirements and Defects for Meat and Skin

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

Table 2. Organoleptic Requirements and Defects for Ground Turkey

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

Table 3. Organoleptic Requirements and Product Characteristics for Cooked Commodity

	Criteria
Organoleptic Requirements: Examined after packaging	The commodity shall be free of: (a) rancidity; (b) metallic, overcooked, burnt, scorched, bitter, oxidized, stale, fruity, beany, oily, soapy, or other flavors or odors foreign to properly prepared and cooked turkey taco filling; and (c) foreign materials (e.g., glass, paper, rubber, plastic, metal).
Product Characteristics: Examined after packaging	Shall have the: texture, appearance, color, and flavor of properly prepared cooked turkey taco filling

EXHIBIT 1 USDA Labeled Shipping Containers

Marking Information: Shipping containers may be marked substantially as shown below. Detailed USDA labeling information is provided in EXHIBIT 2. Markings shall be preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. The USDA symbol (EXHIBIT 4), is to be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or principal display panel. The processor’s name, address, and phone number shall be printed on the “TOP PANEL” or principal display panel. The processor’s name and address shall indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.

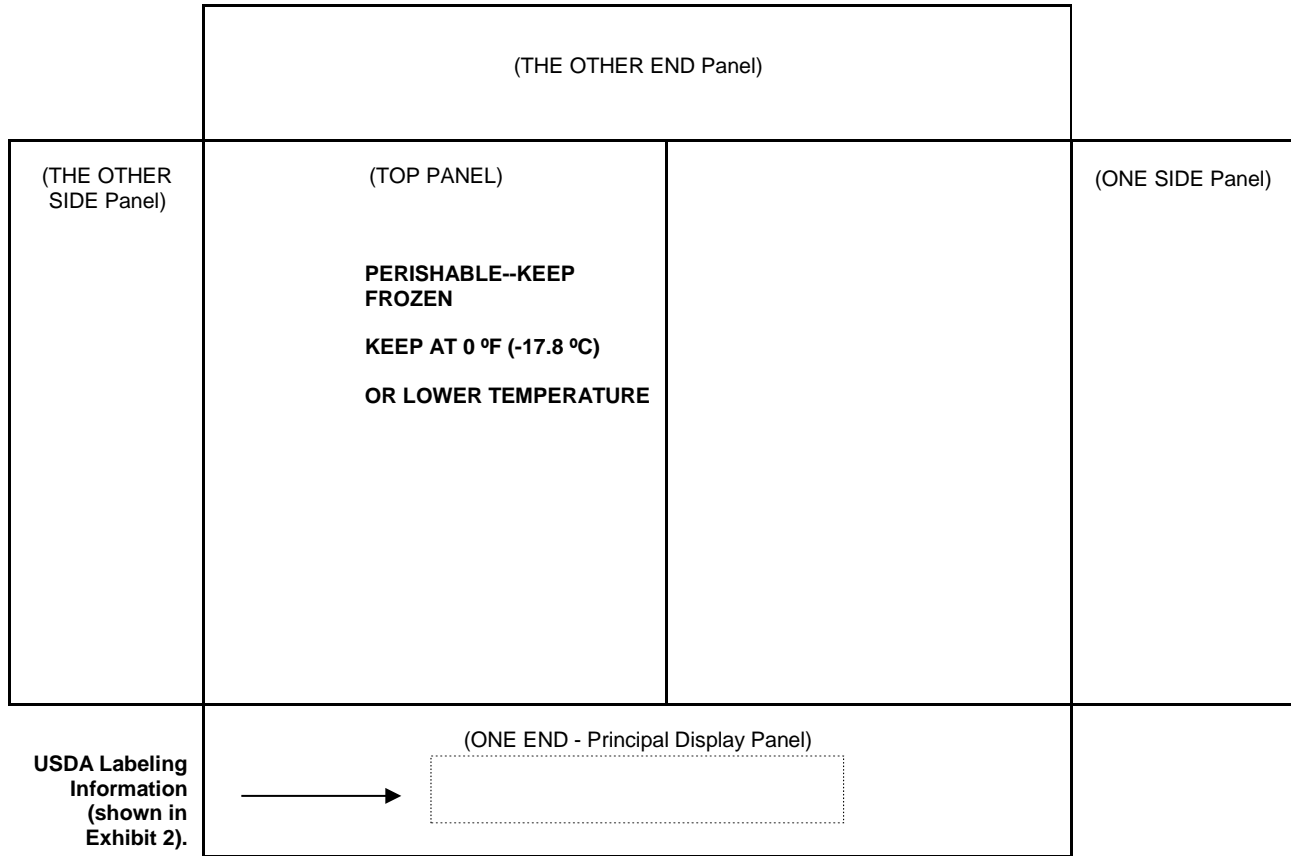


EXHIBIT 2
USDA Label Information for Turkey Taco Filling

Marking Information: USDA labeling information **shall** be printed on the principal display panel of each shipping container as provided in EXHIBIT 1. Markings **shall** be preprinted, stamped, stenciled on containers, or printed on a separate self-adhesive label and applied to containers. The UPC 14-digit 2/5 code and symbol, **shall** be shown in the lower right-hand corner of the principal display panel. The USDA symbol (**EXHIBIT 4**), **shall** be a minimum of 2.25 inches (5.72 cm) in height and may be printed on the “TOP PANEL” or principal display panel. The processor’s name, address, and phone number **shall** be printed on the “TOP PANEL” or principal display panel. The processor’s name and address **shall** indicate the individual processing plant, the company headquarters, or the company address and phone number that handles product complaints.



FROZEN COOKED
TURKEY TACO FILLING

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

Processor’s Name,
Address, and Phone Number

Nutrition Facts Label
Shall Be Placed Here

KEEP FROZEN

__ Bags Net Weight
30 LBS. (13.61 KG)

DATE PACKED Month, Day, and Year

UPC Code and Symbol

EXHIBIT 3
“Please Recycle” Symbol and Statement



**PLEASE
RECYCLE**

EXHIBIT 4

USDA SYMBOL

