



APPROVED

FEDERAL PURCHASE PROGRAM SPECIFICATION (FPPS) FOR COOKED PORK ITEMS

Agricultural Marketing Service (AMS)
Livestock, Poultry and Seed (LPS) Program
Food Safety and Commodity Specification (FSCS) Division
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Effective: **March 2015**

100 ITEM DESCRIPTIONS

- 101 Pork Taco Filling, Fully Cooked – This item consists of ground pork cooked in lightly seasoned ingredients for use in a variety of applications, including taco fillings, burritos, enchiladas and similar items.
- 102 Pork Sloppy Joe Mix, Fully Cooked – This item consists of ground pork cooked in seasoned tomato product for use in a variety of applications, including sandwich filling and similar items.
- 103 Breaded Pork Patties, Fully Cooked – This item consists of ground pork that is formed into round or oval patties, breaded and Individually Quick Frozen (IQF) for use as sandwiches or a stand-alone item. Portion Weight – 3.0 ounces.
- 104 Pork Patties with SPP, Fully Cooked - 2.7 oz. – This item consists of ground pork with soy protein product (SPP) and sausage seasonings, formed into round or oval patties, fully cooked, and then IQF for use as sandwiches or a stand-alone item. Portion Weight – 2.7 ounces.
- 105 Pork Patties with SPP, Fully Cooked – 1.2 oz. – This item consists of ground pork with SPP and sausage seasonings, formed into round or oval patties, fully cooked, and then IQF for use as sandwiches or a stand-alone item. Portion Weight – 1.2 ounce.
- 106 Pork Patty Links with SPP, Skinless, Fully Cooked – This item consists of ground pork with SPP and sausage seasonings, processed into skinless links cylindrical in shape, fully cooked, and then IQF for use as a stand-alone item. Portion Weight - 1.0 ounce.

- 107 Pork Patty Crumbles, Fully Cooked – This item consists of ground pork with SPP that is lightly seasoned and processed to a crumble size of ¼-inch maximum for use in a variety of applications such as chili, sloppy joe, tacos, spaghetti sauce, pizza, lasagna, casseroles, pasta dishes, and any recipe that calls for ground pork.
- 110 Formula – Pork will comprise at least 75 percent of the raw formula for all items.
- 120 Non-Meat Component – Non-meat components will comprise no more than 25 percent of the raw formula.
- 130 Fat – Fat will not exceed 13 g per 100 g basis.
- 140 Sodium – The sodium content will not exceed 440 mg per 100 g basis.
- 150 Packing – Four (4) 10-pound, five (5) 8-pound, eight (8) 5-pound, or twenty (20) 2-pound immediate containers (packages) will be packed in a 40-pound (net weight) shipping container.
- 160 Delivery Unit – Each delivery unit will consist of 1,000 cases and 40,000 pounds, except for the pork patties 1.2/2.7 ounces which will consist of 950 cases and 38,000 pounds.

200 CHECKLIST OF REQUIREMENTS

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

300 MATERIALS

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

320 MEAT COMPONENT

- 321 Pork (shall be derived from suitable lean from any portion of the sow and/or hog carcass) will be the only meat component allowed. Pork derived from boars is not permissible.
- 322 Domestic Origin of Meat Component – All sows and/or hogs will originate from U.S. produced livestock as defined in the Supplement.
- 323 Harvesting (Slaughtering) – All sows and/or hogs will be harvested in facilities that comply with the following requirements:
- 323.1 Humane Handling – All sows and/or hogs will be humanely handled in accordance with all applicable FSIS regulations and AMS requirements.

- 323.2 Non-Ambulatory Disabled Animals – Meat from carcasses of non-ambulatory disabled livestock will not be included in USDA Purchase Programs.
- 323.3 Raw Material Type^{1/} – The type of boneless pork utilized shall be specified from the following options:
- 323.3.1 Type I – Sow Trimmings Only
- 323.3.2 Type II – Hog Trimmings Only
- 323.3.3 Type III – Combination of Sow and Hog Trimmings^{2/}
- 323.4 The contracting officer will designate the raw material type permitted for each solicitation.
- 324 Boneless Pork – Boneless pork will comply with the following requirements:
- 324.1 Traceability – Contractors are responsible for providing sufficient product traceability and must have records to verify the source of raw materials used in each lot of product.
- 324.2 Handling – All boneless pork must be maintained in excellent condition. The contractor's technical proposal shall include detailed production scheduling that addresses time and temperature controls necessary to maintain excellent condition of the boneless pork. Frozen boneless pork may be used provided it is processed into the final product within 60 days from the date of pack.
- 324.3 Objectionable Materials – Boneless pork shall be free of skin, bones, cartilages, organ tissue, heavy connective tissue, significant glandular tissue, spinal cord, and foreign materials.
- 325 Mechanical Separation – Meat that is mechanically separated from bone with automatic deboning systems, advanced lean (meat) recovery (AMR) systems, or powered knives will not be allowed.
- 326 Pathogen Testing – Boneless pork previously tested and found positive for any pathogen will not be allowed.
- 330 NON-MEAT COMPONENTS**
- 331 Domestic Origin of Non-Meat Component – Significant ingredients (more than one percent) will be derived from U.S. produced products.

^{1/}One, two, or all of these types may be represented in the contractor's technical proposal.

^{2/}The contractor shall specify the ratio of these two raw material types in their technical proposal.

- 332 Seasonings and Other Ingredients – Seasonings and other ingredients will be used to produce products with mild flavor profiles suitable for institutional feeding systems. For pork patty crumbles and breaded patties, seasonings and other ingredients will comprise no more than 2 percent of the raw formula.
- 333 MSG – Monosodium Glutamate (MSG) is not allowed.
- 334 Soy Protein Product (SPP) – Pork Patties with SPP, Pork Patty Links with SPP, and Pork Patty Crumbles must contain SPP in the raw formula that meets the following requirements:
- 334.1 The SPP will be hydrated to yield no less than 18 percent protein (as-is basis).
- 334.2 The physical characteristics of SPP, in the dry form, must be either granular or textured. The types of soy that may be used are soy concentrate or isolate (65 percent and 85 percent as-is basis, respectively).
- 335 Batter and Breading – For Breaded Pork Patties, Only – If flour is used in the batter and breading combination, it must be enriched.
- 400 PROCESSING**
- 410 GRINDER PLATE**
- 411 The size of the grinding plate for grinding boneless pork will be declared.
- 420 BONE COLLECTOR / EXTRUDER SYSTEM**
- 421 A bone collector/extruder system must be in operation to effectively remove skin, bone, cartilage, and heavy connective tissue during the final grind.
- 430 PATTIES**
- 431 Raw Weight – The raw weight of the patties will be declared and charted on control charts featuring average weight and range.
- 432 Individually Quick Frozen (IQF) – Patties will be IQF so the individual pieces do not stick together after they are packaged and packed.
- 433 Pink Appearance – Patties with pink appearance after cooking will not be allowed.
- 434 Shape – Patties will be round or oval shape.

440 LINKS

441 Skinless – Casing must be removed.

442 Weight - Target packaged weight per cooked link will be 1.0 ounce. The raw weight of links shall be declared. All weights will be charted on control charts featuring average weight and range.

443 IQF – Links will be IQF so individual links do not stick together after they are packaged.

444 Pink Appearance – Links with pink appearance after cooking will not be allowed.

450 CRUMBLES

451 Size – The size of the crumbles will be ¼-inch maximum with an allowance of five percent 'fines' (<¹/₁₆-inch) in each immediate package. 'Fines' per immediate package will be charted on control charts featuring average value and range.

452 IQF – The crumbles will be IQF or may be produced from IQF's materials to prevent it from sticking together after freezing.

453 Flavor – Crumbles must not have a 'char-broil' flavor.

460 COOKING TEMPERATURE

461 All products will be fully cooked in accordance with FSIS regulations.

470 METAL DETECTION

471 All products will be free of metal contaminants. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required. The contractor's technical proposal must identify and describe the equipment, location, detection procedure, sensitivity levels, frequency of equipment validation, and corrective action procedures.

500 FINISHED PRODUCT LIMITATIONS

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

520 FAT

521 The fat content of the finished product will not exceed 13 percent

522 (Percent Fat = (Total Fat ÷ Serving Size) x 100).

530 SODIUM

531 Sodium level, must not exceed 440 mg per 100 g basis

532 $((\text{Declared Sodium Level (mg)} \times 100) \div \text{Declared Serving Size (grams - racc*)} < 440)$).

540 MICROBIAL

541 Contractor will have documented plan to comply with the latest FSIS Salmonella and Listeria monocytogenes requirements for ready-to-eat foods. Product tested positive for any pathogen will not be allowed as rework or delivery to USDA.

600 HEATING INSTRUCTIONS

610 Heating instructions for the end-user will be provided in the contractor's technical proposal and must be included on the immediate container and/or in the shipping container (e.g. flyer, included on the package label, etc.) as specified for a particular packing orientation discussed in Section 722.4 below. Finished product will be processed so that the end-user may prepare them in a conventional or microwave type oven for serving.

700 PREPARATION FOR DELIVERY

710 PACKAGING AND PACKING

711 Packaging – All products will be vacuum packaged or packed in a sealed (tamper proof) immediate package. In addition, pork taco fillings and sloppy joe mix will be hot-filled into reheatable high oxygen and high moisture barrier pouches.

712 Packing^{3/} – Four (4) 10-pound, five (5) 8-pound, eight (8) 5-pound, or twenty (20) 2-pound immediate containers (packages) will be packed in a 40-pound (net weight) shipping container.

720 LABELING^{4/}

721 The shipping containers will be in compliance with the National Motor Freight Classification, or the Uniform Freight Classification, as applicable. Both immediate and shipping containers will be labeled to include all information required by FSIS regulations.

722 Immediate Container Labels – Immediate container labels will contain the following information:

^{3/}The contracting officer will designate the packaging orientation permitted for each solicitation.

^{4/}All labeling illustrations must be provided.

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- 722.1 A “Best-If-Used-By” date.
- 722.2 A nutrition facts panel based on actual nutritional analysis of the product.
- 722.3 A traceability code that is traced back to establishment number, production lot, and date.
- 722.4 For the twenty (20) 2-pound packing orientation, the heating instructions must be included on the immediate container. The heating instructions for the four (4) 10-pound, five (5) 8-pound and eight (8) 5-pound packing orientations must be included in/on the shipping container and/or on the immediate container.
- 722.5 Ingredient declaration (including single ingredient products).
- 723 Shipping Container Labels – Shipping container labels will contain the following information:
 - 723.1 USDA shield at least 2 inches high and appearing on the top of the container or on the principal display panel.



- 723.2 Applicable purchase order number.
- 723.3 A traceability code that is traced back to establishment number, production lot, and date.
- 723.4 A nutrition facts panel based on actual nutritional analysis of the product.
- 723.5 The appropriate product name and material number listed in the table below for each of the items.

<u>Item</u>	<u>Material Number</u>
Pork Taco Filling, Fully Cooked	100150
Breaded Pork Patties, Fully Cooked	100149
Pork Sloppy Joe Mix, Fully Cooked	100148
Pork Patties with SPP, Fully Cooked, 2.7 ounce	100145
Pork Patties with SPP, Fully Cooked, 1.2 ounce	100146
Pork Patty Links, Skinless, Fully Cooked, 1.0 ounce	100143
Pork Patty Crumbles, Fully Cooked	100144

723.6 An allergen statement in a format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains _____.

730 CLOSURE

731 Shipping containers will be closed by strapping, taping or gluing. When strapping is used, the initial closure (usually the bottom of container) shall be secured by the gluing or taping method.

740 PALLETIZED UNIT LOADS

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

800 DELIVERY UNIT

810 Each delivery unit will consist of 1,000 cases and 40,000 pounds, except for pork patties 1.2/2.7 ounces which will consist of 950 cases and 38,000 pounds.

900 DELIVERED PRODUCT

910 SIZE AND STYLE OF CONTAINER

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

920 TEMPERATURE

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

930 SEALING

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

1000 PRODUCT ASSURANCE

1010 WARRANTY AND COMPLAINT RESOLUTION

1011 Warranty – The contractor will guarantee that the product complies with all contractual requirements required under the Master Solicitation and Supplement.

1012 Complaint Resolution – The contractor’s technical proposal must provide steps taken to resolve complaints received on the product (i.e. point of contact, cause and effect analysis, corrective and preventative actions taken, and product replacement).

1020 AMS MONITORING AND PRODUCTION ASSESSMENT

1021 The contractor has the option for using an AMS audit-based system or an AMS grader certification-based system.

1022 If the contractor uses the AMS grader certification-based system, a QA Division agent must be present during the production of the finished product for all USDA contracts. The QA Division agent will monitor and verify the processing steps, quality assurance activities, and any corrective actions to assure that all requirements outlined in the approved technical proposal and FPPS are complied with. The QA Division agent will be conducting the monitoring and production verification in accordance with applicable QA Division procedures. Any deviations to contractual requirements will be reported to the contractor and FSCS Division. The FSCS Division will make all determinations as to the acceptability of the product relative to findings documented by the QA Division agent.

1030 NON-CONFORMING PRODUCT

1031 The contractor must have documented procedures that assure nonconforming product identification, segregation, and disposition in order to prevent misuse and that nonconforming product is not delivered to USDA. The plan must address 1) control and segregation of non-conforming product, 2) removal of any USDA markings, and 3) disposition of non-conforming product, including vendor notification in writing to the FSCS Division of final disposition (e.g., diverted to commercial production, cooked or destroyed).

1040 CONTRACTOR CHECKLOADING

1041 Contractor will perform checkloading examinations at the time of shipment and issue a contractor’s certificate to accompany each shipment that includes all of the following information:

1041.1 Purchase Order Number/Purchase Order Line Item Number;

1041.2 Sales Order Number/Sales Order Line Item Number;

- 1041.3 Destination of shipment;
- 1041.4 Name of Product and applicable Material Number;
- 1041.5 Shipping Date;
- 1041.6 Production lot number(s) and date each lot was produced along with shipping container and immediate container code(s) and the code used that provides traceability to establishment number, production lot and date;
- 1041.7 Count of shipping containers and total projected net weight in each production lot;
- 1041.8 Identity of car or truck (car numbers and letters, seals, truck license, etc.) as applicable;
- 1041.9 Contractor certification that product conforms with the applicable specification (FPPS-CP-2015);
- 1041.10 Count and projected net weight verified and;
- 1041.11 Signature of company official responsible for checkloading.