



# APPROVED

**FEDERAL PURCHASE PROGRAM  
SPECIFICATION (FPPS) FOR  
FROZEN, FULLY-COOKED  
WHOLE MUSCLE TURKEY  
BREAST**

Agricultural Marketing Service (AMS)  
Livestock and Poultry (LP) Program  
Food Safety and Commodity Specification (FSCS) Division  
Room 3932 S-Bldg, Phone: (202) 690-3148

**Effective: January 2020**

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**100 ITEM DESCRIPTION**

110 Whole Muscle Turkey Breast (111222) – Frozen, fully-cooked whole muscle turkey breast produced from freshly harvested young turkeys. Product shall be produced from non-basted, U.S. Grade A turkey breasts and shall be boneless with or without skin-on. Individual turkey breasts shall weigh 3 to 6 pounds and be individually packaged in moisture proof plastic film bags, packed with a minimum 6 breasts per fiberboard container. A purchase unit shall consist of 950 shipping containers, ranging from 34 to 42 pounds per container, and shall not exceed 39,900 pounds net weight (with a minimum of 34,000 pounds).

**200 APPLICABLE DOCUMENTS**

210 The following documents are incorporated as part of this USDA, AMS, FSCS Division FPPS – Frozen, Fully-Cooked Whole Muscle Turkey Breast – January 2020:

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

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

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

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

**300 CHECKLIST OF REQUIREMENTS**

- 310 Domestic Products – Refer to the current AMS MSCP-D.
- 320 Food Defense – Refer to the current AMS MSCP-D.
- 400 HARVESTING**
- 410 All harvesting activities shall comply with all applicable Food Safety and Inspection Service (FSIS) regulations and requirements, including 9 CFR § 381, and shall be done under FSIS inspection.
- 420 Humane Handling – All poultry shall be humanely handled in accordance with FSIS Directive 6100.3.
- 500 PROCESSING**
- 510 All processing activities shall comply with all applicable FSIS regulations and requirements, including 9 CFR § 381, and shall be done under FSIS inspection.
- 511 Date Processed – The commodity shall not be processed, frozen and packaged more than 90 calendar days prior to the first date of the delivery period for each sales order.
- 512 Lot Definition – A lot is the amount of packaged commodity produced during a processing shift.
- 520 Performance Standards – Product shall be produced under FSIS pathogen reduction standards, as specified in 9 CFR § 381.
- 521 Inspection for contract and FPPS Compliance shall be in accordance with the Regulations Governing the Voluntary Grading of Poultry Products and Rabbit Products (7 CFR § 70) and the U.S. Classes, Standards, and Grades for Poultry (AMS 70.200 *et seq.*). The AMS Grader shall be responsible for certification of compliance with the requirements of this FPPS including review of raw material defects, processing, cooking, packaging and packing; freezing; labeling and marking; sampling; net weight; and checkloading.
- 522 AMS Certification – USDA/AMS/LP Program’s QAD field office or the Director of QAD, LP Program, AMS, USDA, 1400 Independence Avenue, Room 3953-S, STOP 0258, Washington, DC 20250-0258, telephone (202) 690-3147.
- 523 All steps in the manufacturing process shall be under the direct supervision of an AMS Grader as outlined in QAD Policies and Procedures for quality and compliance with product requirements. The AMS Grader may also select samples for laboratory analyses or inspect the commodity at any point including transit and after delivery to point of destination.
- 530 Boneless Whole Muscle Turkey Breast Meat
- 531 The commodity shall be US Grade A (AMS 70.231) boneless turkey breasts

produced from freshly harvested young turkeys (AMS 70.202(b)). Turkey breast meat shall be non-basted, with skin attached or without skin. Grading shall be under the supervision of an AMS Grader using the LP Program's Sample Plan Level 1 (SPL-1) for Grade A boneless parts.

- 531.1 Skin that is not attached to turkey breast meat shall not be used in the commodity.
- 531.2 Single whole muscle breast lobe may be size reduced to meet the weight requirement provided at least one-half of the breast remains intact, and the normal symmetrical shape and appearance of the whole muscle breast is retained.
- 540 Turkey from Other Plants – Turkey breast meat may be transferred or obtained from other processing plants provided it:
  - 540.1 has been processed, handled, and identified in accordance with this FPPS, and
  - 540.2 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.
- 541 Type, class, and specific name of the product, date harvested, and date placed in frozen storage, as applicable; and the USDA-assigned plant number shall be shown on each shipping container.
- 542 The turkey breast meat 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.
- 550 Meat Time Requirements for Turkey Breast Meat
- 551 The chilled turkey breast meat shall be processed, cooked, packaged, packed, and placed in a freezer within 7 calendar days after the date of harvest.
- 552 Frozen turkey breast meat may be used when:
  - 552.1 produced from freshly harvested young turkeys;
  - 552.2 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;
  - 552.3 held not more than 180 days in frozen storage; and
  - 552.4 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.
- 553 Other than the final freezing process for finished, packaged commodity, the commodity shall not be derived from turkey meat that has been frozen more than

one time.

- 554 Maximum Temperature – The temperature of the meat shall not exceed 55°F (12.8°C) at any time during preparation or processing into the commodity.
- 555 Cooling Requirements – Meat and skin which are not used in the commodity on a continuous basis shall be cooled by methods or media to ensure that the internal product temperature is continuously lowered to not higher than 40°F (4.4°C) and not lower than 26°F (-3.3°C).
- 555.1 Cooling Medium – Cooling methods and media (e.g., liquid carbon dioxide (CO<sub>2</sub>), dry ice or liquid nitrogen (N<sub>2</sub>)) may be used to maintain the temperature of meat.
- 555.2 Water, refrigerated water, slush ice and water, or ice used to cool or maintain the temperature of meat or parts shall not be incorporated into the commodity. Liquid associated with normal product purge is acceptable.
- 560 Organoleptic Requirements and Defects for Meat and Skin
- 561 Organoleptic Requirements – Meat shall be examined on a continuous basis and shall not (a) be rancid; have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign or off-odors; contain foreign materials (e.g., glass, paper, rubber, plastic, metal); and have a bright color; and (b) show evidence of mishandling or deterioration; or dehydration or freezer burn or thawing and refreezing.
- 562 Meat and Skin Defects – A sample of 30 pieces of boneless turkey breast meat, with or without skin, shall be drawn and examined for the defects in compliance with USDA Grade A requirements before it is used in the formula. The frequency of sampling and the number of defects allowed shall be those outlined in QAD's Sample Plan Level 1 (SPL-1) for boneless breast meat. If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents shall be rejected.
- 562.1 Optional (Skin) – Skin shall be free of any moderate discoloration. Slight discolorations are permitted on the skin, provided the discoloration does not detract from the overall appearance of the finished product. Skin shall be free of fatty blubber, spongy fat, and membranes.
- 570 Processing Sequence – Unless otherwise specified, processing, formulation, cooking; packing; and freezing of the commodity shall be a continuous process that complies with the time and temperature requirements of this FPPS.
- 571 Flavor and Appearance – Boneless turkey breast shall be minimally seasoned and exhibit a mild oven-roasted flavor. The product shall not appear undercooked, nor shall it appear overcooked (burnt or scorched).
- 572 Formulation:  
Turkey Breast Meat 82.00

Water (up to)	16.00
Seasoning	1.50
Sodium/Potassium Phosphate (maximum)	0.50

- 573 Ingredients shall be used to produce a finished product and incorporated through vacuum tumbling or injection. Ingredients shall not exceed 18% of raw product weight.
- 573.1 Sodium content shall not exceed 550 mg per 100 grams.
- 574 Cooking – All products shall be fully cooked in accordance with FSIS regulations.
- 574.1 Weight Requirements – Cooked turkey breasts shall weigh between 3 to 6 pounds each. Product shall be examined for compliance prior to packaging with the individual weight requirements. A sample of 10 breasts shall be randomly drawn and weighed. The frequency of sampling and the number of defects allowed shall be those outlined in the LP Program’s Sample Plan Level-2.
- 575 Cooling – After cooking, the commodity shall be cooled to an internal product temperature of 40°F (4.4°C) or lower. Cooling methods and procedures shall be in compliance with FSIS directives and guidelines for cooked products.
- 576 Freezing – Packaged commodity shall be placed in a freezer within 48 hours of packing. The commodity shall be frozen by lowering the internal product temperature to 10°F (-12.2°C) or lower within 72 hours from the time of entering the freezer.
- 576.1 If the commodity is not placed in a freezer immediately after packing, the product shall be held at a temperature between 26°F (-3.3°C) and 36 °F (2.2°C). When packaged product is held at a temperature below 26°F (-3.3°C), the commodity shall be considered to be in a freezer and subject to the 72-hour freezing requirement which begins at the end of the shift the commodity enters the 26°F (-3.3°C) or lower facility.
- 580 Organoleptic Requirements for Cooked Product – Cooked boneless breast shall (a) not be rancid; have a fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign or off-odors; not contain foreign materials (e.g., glass, paper, rubber, metal, plastic, wood); or (b) show evidence of mishandling or deterioration; or dehydration or freezer burn or thawing and refreezing. Any product that does not comply with the organoleptic requirements shall be rejected for use under this FPPS.
- 590 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.

**600 PACKAGING AND PACKING**

- 610 The contractor shall assure that all packaging, packing, labeling, closure, marking, and palletization comply with the National Motor Freight Regulations and FSIS regulations and the requirements listed below.
- 620 Packing – A minimum of six (6) 3 to 6-pound individual packages shall be packed in a shipping container with a net weight of 34 to 42 pounds.
- 630 Packaging – All packaging and packing materials shall be clean and in new condition, shall not impart objectionable odors or flavors to the commodity, shall be safe 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 of barriers to entry, which, if breached or missing, can reasonably be expected to provide visible evidence that tampering has occurred. All packaging material shall comply with FSIS regulations (9 CFR § 381.144(c)).
- 631 Product must be packaged in a heat-shrinkable plastic-film bag. The bags shall have a wall thickness of not less than 2 mil (0.002 inch) and be oxygen and water-proof. The bag shall be shrunk to fit tightly against the surface of the commodity. Excess air shall be removed (by vacuum) and be hermetically heat sealed to ensure a vacuum closure. Package must protect the commodity from dehydration, freezer burn, quality deterioration, or contamination during the conditions of use. Metal wire ties, paper-coated wire ties, or staples shall not be used for sealing bags.
- 632 Individual packages shall be consumer-labeled. Individual packages must appear uniform in shape and size, and shall be between 3 and 6-pounds (1.36 kg and 2.72 kg) net weight each.
- 640 Shipping Containers – Shipping containers shall:
- 640.1 be good commercial fiberboard containers that are acceptable by common or other carrier for safe transport to point of destination,
- 640.2 be of such size to pack the commodity without slack filling or bulging,
- 640.3 withstand the stresses of handling, shipping, stacking, and storage, and
- 640.4 be closed by commercially accepted methods and materials. Steel or wire straps shall not be used for final closure.
- 641 Staples shall not be used for final closure of shipping containers. Adhesive or staples cannot be used to fasten the top portion of telescope-style containers to the bottom portion. Staples may be used to manufacture and to assemble the fiberboard shipping containers, provided the staples are fastened into the container and tightly clenched to eliminate sharp edges prior to packing the commodity into the shipping containers.

**700 LABELING**

- 710 Commercial Labeling Requirements
- 711 Each individual package and shipping container shall be commercially labeled in accordance with FSIS requirements. Labeling shall be approved by FSIS prior to acceptance for use under this FPPS. Individual packages shall comply with retail consumer labeling requirements and must meet Section 4A52.211-4 of the MSCP-D.
- 711.1 Labels shall be adhered directly on individual package or printed label.
- 712 Commercial labels shall be the processor's own commercial retail label. Distributors' labels are not permitted.
- 720 Traceable Product – The processor shall establish a product identification and record system that clearly links product by place and time of manufacture to specific USDA contracts and destinations. When the company uses the same commercial label for the product certified as complying with this FPPS and commercial product, the identification system shall differentiate between USDA and non-USDA products. An alpha numeric code may be used for information that is in addition to FSIS labeling requirements. The required product identification and record system, including codes, shall be reviewed by USDA/AMS before production begins for the contract(s).
- 730 Nutrition Facts, Ingredients, and Allergen Statements on Individual Packages – Nutrition Facts shall be provided. The ingredient statement, even for single ingredient foods, shall be included as a statement separate from the name of the product, e.g. Ingredients: \_\_\_\_\_. The allergen statement shall be provided in the format which complies with the Food Allergen Labeling and Consumer Protection Act (FALCPA) for any product which contains milk, eggs, fish, crustacean shellfish, tree nuts, peanuts, soy or wheat; e.g. Allergen: This product contains \_\_\_\_\_. For additional guidance refer to the Compliance Guidance at:  
  
<http://www.fsis.usda.gov/wps/wcm/connect/f9cbb0e9-6b4d-4132-ae27-53e0b52e840e/Allergens-Ingredient.pdf?MOD=AJPERES>
- 740 Unacceptable Labeling:
- 741 commercial labels that do not have a processor traceability system and code;
- 742 commercial labeling traceability coding and systems that have not been reviewed by a representative of USDA/AMS/LP/QAD;
- 743 distributor commercial labels;
- 744 two or more different commercial labels in the same purchase unit.
- 750 Free Along Side (FAS) Vessel Deliveries
- 751 FAS vessel deliveries that are not source loaded in a seavan are required to show

the final destination's overseas address as provided in the Sales Order/Item Number. The address shall be clearly printed on at least two sides of each pallet.

**800 FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY**

- 810 Packaging Defects – Packages in a delivery unit shall be examined for defects that affect protection, expose product, or permit dehydration or freezer burn, or quality deterioration during storage, such as tears, holes, or improperly sealed packages.
- 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 (7 CFR § 42).
- 820 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.
- 830 Delivery Unit – A purchase or delivery unit shall consist of 950 shipping containers, ranging from 34 to 42 pounds, and shall not exceed 39,900 pounds net weight (with a minimum of 34,000 pounds).
- 831 Weight Variation – USDA shall pay the contractor only for the amount of commodity delivered within the required weight range. Each delivery unit shall be examined for compliance with the net weight requirements at time of checkloading.
- 832 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 (or his/her designee) shall determine that the facilities and procedures are in accordance with the applicable LP Program's instructions for this FPPS.
- 840 Loading and Shipping Frozen Commodity
- 841 Visual Inspection – Frozen commodity showing any evidence of thawing, refreezing, or freezer deterioration shall be rejected for use under this FPPS.
- 842 Internal Product Temperature
  - 842.1 Frozen – Commodity shall be 2°F (-16.7°C) or lower at time of loading. Delivery units with internal product temperatures exceeding 2°F (-16.7°C) and up to 5°F (-15°C) shall be tentatively rejected. Tentatively rejected delivery units may be returned to the freezer and the temperature reduced to 2°F (-16.7°C) or lower and reoffered one time only. Delivery units exceeding 5°F (-15°C) or delivery units that have been tentatively rejected and exceed 2°F (-16.7°C) when reoffered shall be rejected for use under this FPPS.
  - 842.2 Optional Temperature Verification – The contractor may request an alternate method utilizing product temperature-sensing devices. If this option is selected, a Federal-State supervisor shall determine that the facilities, equipment, procedures,

and the contractors' current level of freezing compliance are in accordance with the established guidelines outlined in the applicable LP Program's instructions for this FPPS.

850 Inspection and Checkloading

851 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.

852 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, LP Program, AMS, USDA, 1400 Independence Avenue, Room 3953-S, STOP 0258, Washington, DC 20250-0258, telephone (202) 690-3147.

852.1 The quality, quantity, weight, packaging, packing, and checkloading of the commodity shall be evidenced by certificates issued by the AMS Grader. Contractor shall not ship the commodity unless informed by the AMS Grader that the designated commodity to be shipped meets the requirements of the AMS MSCP-D, Solicitation, and this FPPS.

## **900 PALLETIZED UNIT LOADS**

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

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

## **1000 SHIPMENT AND DELIVERY**

1010 Shipment and Delivery, including Loading and Sealing, Delivery Notifications and Split Deliveries – Refer to the current AMS MSCP-D.

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

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

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

1012 A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading shall accompany each shipment.

## **1100 DESTINATION EXAMINATION**

1110 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.

1120 Temperature – The commodity shall arrive at destination at an average internal product temperature not to exceed 10°F (-12.2°C) with no individual temperature exceeding 15°F (-9.4°C) when shipped, during transit, and when received at the destination plant. When any sample exceeds 15°F (-9.4°C) the purchase unit shall be rejected for use under this FPPS.

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

1210 Product Assurance – The Contractor shall guarantee that the product complies with all requirements and provisions set forth in the FPPS, AMS MSCP-D, and Solicitation.

1220 Waiver Requests – Contractor shall submit all waiver requests directly to the Commodity Procurements Program (CPP) Contracting Officer for review and determination. Full list of CPP contacts can be found at:

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

1230 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.