



APPROVED

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

FEDERAL PURCHASE PROGRAM SPECIFICATION (FPPS) FOR CANNED BONED CHICKEN WHITE MEAT

Supersedes: Canned Boned Poultry April 2013 – Changes
from previous requirements in [blue](#)

Effective: June 2016

100 ITEM DESCRIPTION

- 110 [Canned Boned White Chicken](#) (100094) – Twelve and one-half ounces of commodity ([white meat + broth or water](#)) shall be packaged in a 401 x 204 size metal can and packed 24 cans in each fiberboard shipping container. A purchase unit shall consist of 1900 shipping containers totaling 35,625 pounds.
- 120 Canned Boned [White Chicken](#) (100877) – Fifty ounces of commodity ([white meat + broth or water](#)) shall be packaged in a 404 x 700 size metal can and packed 12 cans in each fiberboard shipping container. A purchase unit shall consist of 1000 shipping containers totaling 37,500 pounds.

200 APPLICABLE DOCUMENTS

- 210 The following documents are incorporated as part of this USDA, AMS, FSCS Division [FPPS-Canned White Boned Chicken – June 2016](#):
- 210.1 AMS/ [LPS/QAD](#) Policies and Procedures ([QAD](#) 600 Series).
- 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 of Commodity Procurements.

320 Food Defense – Refer to the current AMS Master Solicitation of 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 must be produced under FSIS pathogen reduction standards, as specified in 9 CFR § 310.25.

530 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.*) under the supervision of an **AMS** Grader. The **AMS** Grader shall be responsible for certification of compliance with the requirements of this **FPPS** for chicken; cooked chicken carcasses and chicken parts; formulation of commodity; canned thermal-processed commodity; packaging and packing; labeling and marking; sampling; and checkloading.

531 AMS Monitoring and Inspection – USDA/AMS, **LPS** Program’s **Quality Assurance (QA) Division** field office or the Director of the **QA Division, LPS** Program, AMS, USDA, Room 3953-S, STOP 0258, 1400 Independence Avenue, SW, Washington, DC 20250-0258, telephone (202) 720-3271.

532 All steps in the manufacturing process shall be under the direct supervision of **QA Division** personnel and as outlined in **QA Division Policies and Procedures Manual (QAD 600 Series)**. Quality and compliance with product requirements shall be determined in accordance with those policies and procedures. The **QA Division** agent may also select samples for laboratory analyses or inspect the commodity at any point in transit and after delivery to point of destination.

- 533 [AMS Sampling Option](#) – [AMS](#) may select additional commodity for further inspection or may draw samples for laboratory analyses.
- 540 [Class and Style](#)
- 541 The commodity [shall](#) be prepared from freshly harvested ready-to-cook chickens:
- 541.1 [AMS 70.201 broiler or fryer \(c\), or](#)
- 541.2 [AMS 70.201 mature chickens \(f\), \(g\)](#) weighing 4.0 pounds or more without neck and giblets.
- 541.3 [A truckload shall contain only one class of chicken \(broiler or mature hen\).](#)
- 542 Chicken from Other Plants – Frozen and/or chilled chicken and chicken parts may be transferred or obtained from other processing plants provided they:
- 542.1 Have been processed, handled, and identified in accordance with this [FPPS](#), and
- 542.2 Comply with the organoleptic and other applicable requirements of this [FPPS](#) as evidenced by USDA certification.
- 543 Type, class, and specific name of the product, part, or meat; date [harvested](#) as applicable; and the USDA-assigned plant number [shall](#) be shown on each shipping container.
- 544 The chilled chicken and chicken parts [shall](#) be at an internal product temperature not higher than 40 °F (4.4 °C) and not lower than 26 °F (-3.3 °C) when shipped from the origin plant and when received at the destination plant.
- 545 Frozen Chicken – Frozen chicken and chicken parts may be used if they have been:
- 545.1 Packaged to protect the product from freezer burn, dehydration, and quality deterioration during storage,
- 545.2 Labeled as to kind and class of poultry and identified so the time in storage can be determined, and
- 545.3 Held in frozen (0 °F/-17.8 °C) storage for not more than 180 days.
- 546 [Mechanically separated \(comminuted\), finely ground, flaked, or finely chopped chicken meat cannot be used.](#)
- 550 [Bone and Other Defects](#) – [See Tables 2-3.](#)

- 551 Bone or Hard Bone-like Material – Regardless of the kind and number of defects found, any sample with bone or hard bone-like material greater than 0.40 inch (1.02 cm) shall be cause for the rejection of the product the sample represents.
- 552 If the sample has more defects than the maximum tolerance for the sample plan, the product the sample represents shall be rejected.
- 553 Organoleptic Requirements – The chilled ready-to-cook chicken and chicken parts used to produce cooked chicken parts shall be examined on a continuous basis for the following organoleptic requirements: chilled chicken and chicken parts shall be free of rancidity; free of fruity, sulfide-like, cardboardy, tallowy, oily, metallic, chlorine-like, or other foreign and off-odors; free of foreign materials (e.g., glass, paper, rubber, plastic, wood, metal); shall show no evidence of mishandling or deterioration; and shall have a bright color and show no evidence of dehydration or freezing and thawing. Any chicken or chicken part that does not comply with the organoleptic requirements shall be rejected for use under this FPPS.
- 560 The commodity shall not be processed or packaged more than 90 days prior to the first day of the delivery period.
- 561 Meat may be marinated prior to cooking according to the FSIS regulations on the level of phosphates.
- 562 **Cooking Options**
- 562.1 Cooked with water without pressure or,
- 562.2 Pressure cooked or,
- 562.3 Steam cooked.
- 563 Meat shall be reduced in size to a minimum of 1.0 inch cubes. Boneless meat may also be used from ready-to-cook chicken after cooking.
- 564 All white meat shall be used. No dark meat is allowed.
- 565 Cooked meat may be held at 40 °F (4.4 °C) or lower for not more than 5 days from time of cooking until canned, or the chilled cooked meat may be frozen and held at an internal product temperature of 0 °F (-17.8 °C) or lower for not more than 180 days from date of packaging.
- 566 Organoleptic Requirements – See Table 1.

- 567 Broth or Water
- 567.1 Broth or potable water shall be used in the commodity. Broth used shall be a flavorful broth from the un-pressurized cooking of not less than two or more than four batches of poultry in the same broth. A continuous cooking method may be used, provided water is added during the cooking operation and the process results in a broth equivalent to that described in the preceding sentence. Broth from one batch of pressure-cooked poultry may be used. Broth produced by cooking only fat and bones shall not be used. Broth shall be maintained at a temperature of 160 °F (71.1 °C) or higher or shall be chilled to and maintained at a temperature of 40 °F (4.4 °C) or lower within 4 hours of preparation. Broth may not be held for more than 48 hours unless the broth is frozen or dried.
- 567.2 Other methods of preparing broth or handling the broth may be approved by the Director of the QA Division, in writing. Approvals shall be granted on an individual plant basis after a review of the process and when the resulting method is found acceptable by supervisory personnel of the QA Division.
- 567.3 Broth shall be free from bitter, rancid, metallic, cardboardy, soapy, scorched, burnt, overcooked, stale, and other off-odors or off-flavors foreign to properly processed chicken broth.
- 568 The finished product shall contain no more than 350 mg sodium per 100g as evidenced by the nutritional labeling.
- 570 Metal Detection – All products shall be free of metal contaminants. Detection of stainless steel, ferrous, and non-ferrous (e.g., lead, copper, and aluminum) metals is required.
- 580 Commodity Defects – The contractor/processor may select one of the two options for the examination of commodity defects. Once an option is selected, the contractor/processor may not change options until the end of 1 day's production. Samples of commodity with more defects than the maximum tolerance for either option will result in the rejection of the lot or subplot the samples represent.
- 581 Option I – Examination **prior** to thermal processing.
- 581.1 Samples shall be randomly selected online prior to canning or thermal processing and examined for the defects shown in **Table 2**.
- 581.2 Samples and sampling frequency shall be determined in accordance with LPS QAD procedures.
- 582 Option II – Examination **after** thermal processing.
- 582.1 After drained weight determination, the samples shall be examined for the

defects shown in **Table 3**.

- 582.2 Samples and sampling frequency shall be determined in accordance with LPS QA Division procedures.
- 590 Filling Cans – Cans may be filled by first adding the meat to each can and then adding water or filling with a mixture of meat and water.
- 590.1 12.5-oz Cans – Twelve and one-half ounces (354 g) net weight of commodity must be packed in 401 x 204 size metal cans.
- 590.2 50-oz Cans – Fifty ounces (1.42 kg) net weight of contents of can must be packed in 404 x 700 size metal cans.
- 591 Drain Weight – Shall be determined in accordance with LPS QA Division procedures.
- 591.1 12.5-oz Cans – Filled cans from a lot or subplot must average not less than 10 oz. (283.5 g) of commodity on a drained-weight basis.
- 591.2 50-oz Cans – Filled cans from a lot or subplot must average not less than 30.0 oz. (850.5 kg) of commodity on a drained-weight basis.
- 592 Thermal Processing – Cans shall be filled allowing adequate headspace, hermetically sealed, and thermal-processed in accordance with FSIS regulations. The thermal-processed commodity shall have a stable shelf-life under the conditions of long-term, non-refrigerated storage and transportation. The exterior of the can shall be dry, clean, and free from rust, fat, and grease before packing into shipping containers.
- 593 Reworked Commodity – Sample cans examined by the AMS Grader or product rejected for defects exceeding the maximum tolerances and drained weight may be reworked and incorporated into formulated batches of product, prior to thermal processing, provided:
- 593.1 The defects are removed from the product;
- 593.2 The product is incorporated at a maximum of 5 percent of the formulated batch; and
- 593.3 Product removed from cans shall be reworked into a batch within 72 hours.
- 594 X-ray Examination – X-ray equipment may be used to examine product to be reworked provided:
- 594.1 The equipment and x-ray examination procedures are found to be in compliance with FSIS regulations and procedures; and

594.2 An AMS Grader monitors the x-ray and rework procedure.

594.3 The Contractor/Processor may remove product cans from a lot or subplot suspected of containing defects after the x-ray examination and the balance of the lot or subplot may be reoffered for acceptance. Product containing defects may be reworked once.

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.

611 Packaging – All packaging materials shall be clean and in new condition, shall be tamper-evident, and shall not impart odors or flavors to the product. 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)).

611.1 Cans – Shall be metal, round, and open-style with or without welded side seams and shall be equivalent in construction to those in commercial use.

620 Packing

620.1 12.5-oz Cans – 24 cans shall be packed per shipping container.

620.2 50-oz Cans – 12 cans shall be packed per shipping container.

630 Closure – Shipping containers shall be closed with tamper evident closure methods.

700 LABELING

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

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

711 Commercial Labeling Requirements

- 711.1 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**.
- 711.2 Commercial Labels – Commercial labels **shall** be the processor's own commercial label. Distributors' labels are not allowed.
- 711.3 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 **AMS** before production begins for the contract(s).
- 711.4 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 _____.
- 720 Inventory Control Information – The processor may include any additional information (including bar codes) for processor inventory control purposes. This information may be applied somewhere on the surface of the shipping container but **shall** not cover or conflict with the labeling requirements of this **FPPS**.
- 721 Shipping containers or labels with incorrect contract number, plant number, net weight, date packed, **shall** be corrected before they are used. The incorrect information **shall** 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 **shall** appear on each shipping container.
- 730 **Unacceptable** Labeling
- 731 Commercial labels that do not have a processor traceability system and code.
- 732 Commercial labeling traceability coding and systems that have not been reviewed by a representative of USDA/AMS/ **LPS/QAD**.
- 733 Distributor Commercial Labels

- 734 Two or more different commercial labels in the same purchase unit.
- 740 Free Along Side (FAS) Vessel Deliveries
- 741 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 panel.
- 800 FINAL EXAMINATION OF PACKAGED AND PACKED COMMODITY**
- 810 **QA Division** Testing – All testing **shall** be in accordance with **QA Division** policies and procedures for product testing to ensure product complies with all **FPPS** requirements. Tests included to be conducted but are not limited to:
- 810.1 Certification of compliance with **FPPS** requirements for chicken carcasses and parts; preparation, formulation, and fabrication; cooking and cooling; packaging and packing; labeling and marking; sampling; net weight; and checkloading.
- 810.2 Organoleptic requirements conducted in both the boneless and cooked state (**See Table 2**).
- 810.3 **Drain Weight (Table 4 or 5)** and Metal Detection
- 820 Final Examination – Material and net weight compliance, verification of materials and defects, verification of packaging and packing materials, and checkloading.
- 830 A copy of the original USDA, AMS, **LPS**, **QA Division** Certificate **shall** accompany each shipment.
- 840 Delivery Unit
- 841 **Canned Boned White Chicken** (100094) – Each delivery unit **shall** consist of a net weight of **35,625** pounds of commodity.
- 842 Canned Boned **White Chicken** (100877) – Each delivery unit **shall** consist of a net weight of **37,500** pounds of commodity.
- 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 shall be applied to a side of the container.

1011.2 A copy of the original USDA Poultry Products Grading Certificate issued at time of checkloading shall accompany each shipment.

1011.2.1 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 Grader, warehouseman, or consignee, as applicable.

1011.2.2 Trucks – If shipment is by truck, the driver shall upon delivery, give the certificate to the Grader, warehouseman, or consignee, as applicable.

1020 Loading and Sealing of Vehicles

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

1030 Delivery Notification

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

1040 Split Deliveries

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

1100 DESTINATION EXAMINATION

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

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 Master Solicitation for Commodity Procurements and Solicitation.

1220 Complaint Resolution – Customer complaint resolution procedures shall be the responsibility of the Contractor. These procedures shall include: a point of contact, investigation steps, 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 for Cooked Commodity

Organoleptic Requirements:	The commodity shall be free of skin and foreign materials (e.g., glass, paper, rubber, plastic, metal, wood); and odors which are not characteristic of properly cooked and handled poultry meat; for example, rancid, metallic, stale, sour, or scorched.
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TABLE 2. Commodity Defects – Option I

Defects – Meat	<p>A defect for meat is the presence of:</p> <p>Bone: Bone or hard bone-like material in a sample greater than 0.40 inch (1.02 cm).</p> <p>Bone or hard-bone-like material in a sample less than or equal to 0.40 inch (1.02 cm).</p> <p>Other: Dark colored (due to blood) vein or artery more than 1 inch (2.54 cm) in length; or</p> <p>Bruises, blood clots, and moderate discolorations that exceed an area equivalent to a circle with a diameter of 0.30 inch (0.76 cm); or</p> <p>Presence of skin</p> <p>Presence of Dark Meat – No Tolerance</p>
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TABLE 3. Thermal-Processed Commodity Defects - Option II

	Defects	Tolerance
Meat:	Dark Meat Presence of Bone or hard bone-like material * greater than 0.40 inch (1.02 cm) in a sample.	Rejected
Bones:	Bone or hard bone-like material * less than or equal to 0.40 inch (1.02 cm) in a sample.	6 bones permitted per lot
		3 bones permitted per subplot
Other:	Dark colored (due to blood) vein or artery more than 1 inch (2.54 cm) in length. Bruises, blood clots, and moderate discolorations that exceed an area equivalent to a circle with a diameter of 0.30 inch (0.76 cm).	10 defects permitted per lot
		5 defects permitted per subplot
Skin:	Presence of skin.	1 defect permitted per subplot

* Bone or hard bone-like material is material that does not break up or disintegrate when subjected to pressure from a spatula, flat side of a knife, or fork.

TABLE 4. Samples Drawn Online From a Lot or Sublot - *Option I*

12.5 oz (354g) cans			50 oz (1.42-kg) cans		
Lot or Sublot	Organoleptic Requirements and Defects	Drained Weight	Lot or Sublot	Organoleptic Requirements and Defects	Drained Weight
Lot	5 cans per Sampling interval	24 cans	Lot	1 can per Sampling interval	6 cans
Sublot*	5 cans per Sampling interval	12 cans	Sublot*	1 can per Sampling interval	3 cans

TABLE 5. Samples Drawn From a Lot or Sublot - *Option II*

12.5 oz. (354 g) cans			50 oz. (1.42 kg) cans		
Total No. of Cans	Drained Weight	Organoleptic Requirements and Defects	Total No. of Cans	Drained Weight	Organoleptic Requirements and Defects
	Number of Cans			Number of Cans	
Lot			Lot		
Total = 32 cans	First 24 cans	First 24 + 8 cans	Total = 8 cans	First 6 cans	First 6 + 2 cans
Sublot*			Sublot*		
Total = 16 cans	First 12 cans	First 12 + 4 cans	Total = 4 cans	First 3 cans	First 3 + 1 can

* The total number of samples drawn from all sublots in a lot must be equal to or greater than those specified for a lot.

EXHIBIT 1
USDA Symbol

