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I NSTITUTIONAL

M EAT

P URCHASE

S PECIFICATIONS

**FOR CURED, CURED AND SMOKED,
AND FULLY-COOKED PORK PRODUCTS
SERIES 500**

**INTERIM
APPROVED BY USDA**

EFFECTIVE DATE - January 1, 1992 -

(This 1998 version is issued to add an IMPS Ordering Checklist, reorganize the Ordering Data to correspond with the Checklist, update text, and to correct printing errors.)

INSTITUTIONAL MEAT PURCHASE SPECIFICATIONS

FOR CURED, CURED AND SMOKED, AND FULLY-COOKED PORK PRODUCTS

SERIES 500

The United States Department of Agriculture (USDA) through its Agricultural Marketing Service (AMS) develops and maintains the Institutional Meat Purchase Specifications (IMPS) for meat and meat products. The complete IMPS series includes the following ten documents:

General Requirements	
Quality Assurance Provisions	
Fresh Beef	Series 100
Fresh Lamb and Mutton	Series 200
Fresh Veal and Calf.....	Series 300
Fresh Pork.....	Series 400
Cured, Cured and Smoked, and Fully Cooked Pork Products	Series 500
Cured, Dried, and Smoked Beef Products	Series 600
Edible By-Products.....	Series 700
Sausage Products.....	Series 800

These specifications are recommended for use by any meat product procuring activity. For assurance that procured items comply with these detailed requirements, the USDA, through its Meat Grading and Certification Branch, provides a voluntary Meat Certification Service. For labeling purposes, only product certified by the Meat Grading and Certification Branch may contain the letters "IMPS" on the product label. Purchasers desiring this service should contact:

USDA, MRP, AMS, Livestock and Seed Program
Meat Grading and Certification Branch
Stop 0248, Room 2628 S-Bldg
1400 Independence Ave. SW
Washington, D.C. 20250-0248 PHONE::(202)-720-1113 FAX: (202)-690-4119

Internet Address: <http://www.ams.usda.gov/lsg/lc-mg.htm>

For any assistance regarding these documents and for additional copies, please contact:

USDA, MRP, AMS, Livestock and Seed Program
Standardization Branch
Stop 0254, Room 2628 S-Bldg
1400 Independence Ave. SW
Washington, D.C. 20250-0254 PHONE: (202)-720-4486 FAX: (202)-720-1112

I. SCOPE

This series provides ordering data for cured, cured and smoked, and fully-cooked pork products. Purchaser options have been designed to meet the needs of the large volume purchaser.

DEFINITION OF TERMS ¹

For the purpose of this specification, the following terms are briefly defined to assist the purchasing community identify product names and understand the different terminology used in this specification and in the market place:

1. BACON - Will not have a PFF requirement, but will remain under the concept of "no added substances". Therefore, the standard for bacon requires that the finished product not exceed its raw, uncured weight after curing and smoking.
2. BACON (cooked) - Not to yield more than 40% Bacon - 60% shrink required. (This is to insure complete cooking)
3. CHOPPED HAM - A total of 15% shank meat is permitted. This is 3% above the normal portion of 12% shank meat found in a whole ham.
4. COUNTRY STYLE - Means product is dry cured, smoked.
5. CURED - Meat soaked or injected with a brine solution to extend shelf life and, secondly, to impart the flavors of the curing agents.
6. DRY CURED - Product labeled as "Dry Cured" shall not be injected with a curing solution or processed by immersion in a curing solution.
7. FAT FREE PERCENT LABEL DECLARATIONS - Percent fat free statements, e.g., "95% Fat Free", are acceptable on product labels if the label also bears a positive declaration of the products fat content, e.g., "contains 5% fat". The percent fat free statement and the accompanying statement of the fat content are considered representative of the fat content of the total product only and do not necessarily represent the fat free portion as lean material.

Definition of terms (continued)

8. FRESH - Used in conjunction with product that has no cure added, regardless if the product is cooked or uncooked.
9. FULLY-COOKED - This term is acceptable provided product shows cooked characteristics (partial meat-bone separation, easy tissue separation, color, texture and flavor). This usually requires a minimum internal temperature of 148°F.
10. GROUND MEAT - If labeled as "Ground Meat", no water, cereal, soy derivatives, or other extenders are permitted.
11. "Ham", "Ham With Natural Juices", "Ham, Water Added", "Ham and Water Product" - These labels (listed in order) indicate to the purchaser the amount of water remaining in the ham after processing (curing, cooking, smoking, etc.). "Ham", with no further labeling terminology, having none or a very minimal amount of water, (above the natural occurring quantity, remaining after processing) and "Ham and Water Product" having the most water, (above the natural occurring quantity) remaining after processing.
12. HAM, BOILED - A fully-cooked, boneless product which must be cooked in water and may be processed in casing or can.
13. HAM, CHOPPED - Shank meat not more than 25% over that normally present in a boneless ham.
14. HAM, CHUNKED AND FORMED - HAM, GROUND AND FORMED - Total product that has been subject to mechanical reduction, such as grinding or chunking, serves to recharacterize the product in a way that is significantly different from that normally expected by consumers. Therefore, qualifiers such as "chunked and formed" and "ground and formed" shall continue to be required.
15. HONEY, CURED - Honey shall be used in sufficient amounts to flavor and/or affect the appearance of the finished product.
16. "IMPS" - Institutional Meat Purchase Specification. For labeling purposes, only product certified by the USDA, Meat Grading and Certification Branch (MGCB) may contain the letters "IMPS" on the product label.

Definition of Terms (continued)

17. LITE AND SIMILAR TERMS - Such terms may be used when a significant reduction has been made to the fat, salt, or sodium as compared to similar products. A significant reduction is considered to be 25%.

18. LOWFAT - May be used only for those products that contain no more than 10% fat.
19. PFF (protein fat free) - The "Protein Fat-Free" procedure reflects the presence of added ingredients, including water, and relates labeling claims to the percent of meat protein in the product. Simply stated, this means that water added to the product dilutes the natural protein content. Labeling requirements established by FSIS, MPIO, state that for products such as "Ham", "Ham With Natural Juices", "Ham, Water Added", "Ham and Water Product", etc., the product must comply with the minimum meat PFF percentages.

$$PFF = \left(\frac{\% MEAT PROTEIN (BY ANALYSIS)}{100 \% FAT (BY ANALYSIS)} \right) \times 100$$

20. PRIME, CHOICE, SELECT - May only be used applicable on red meat items that have been officially graded by the USDA. These terms shall not be used in describing the quality of pork. These terms may also be used on poultry that is equivalent of US Grade A.
21. PULLMAN STYLE - Refers to meat product packed into a long container (usually rectangular or square).
22. SKINNED vs SKINLESS - Skinned means that a specified amount, or specified area of skin shall be removed. Skinless means, that all of the skin shall be removed.
23. SMOKED - Meat cuts which have been exposed to the dry smoke of hardwoods, or which have had liquid smoke applied externally by transforming the flavoring into a true gaseous state by the heat of processing. Liquid smoke may be included with the brine injection if the item is labeled "Smoke Flavor Added".
23. SPIRAL SLICED - A method of slicing the ham while leaving the ham attached to the bone.
24. TWO-TONED COLOR - More than a slight color variation between two or more different muscles within a single sliced surface.

IMPS Ordering Checklist

The following checklist will assist the purchaser in providing contractual language necessary to describe the IMPS product and service desired. Each element within the checklist is further defined within Section **I. ORDERING DATA TO BE SPECIFIED BY THE PURCHASER.**

- A. Item Number** (See page 8.)
 - Special instructions
 - Purchaser Specified Options (PSO)
 - Added ingredients
 - Mechanical tenderization
- B. Grade and Special Requirements** (NA)
- C. State of Refrigeration** (see IMPS GENERAL REQUIREMENTS, section I. MEAT HANDLING)
 - Chilled
 - Frozen
- D. Fat Limitations** (See page 11.)
- E. Portion Cut Weight, Thickness, and Shape** (applicable to portion cut items only (See page 11.))
- F. Weight Range** (See weight range tables on pages 12-14.)
- G. Netting and Tying** (See page 15.)
- H. Packaging and Packing** (See IMPS GENERAL REQUIREMENTS, section II. PACKAGING AND PACKING.)
- I. Quality Assurance** (See IMPS QUALITY ASSURANCE PROVISIONS.)
 - Method of examination
 - Acceptable Quality Levels (AQLs)
 - Certification - (See page 15 and refer to the IMPS GENERAL REQUIREMENTS, Section III)
- J. USDA CERTIFICATION** (See page 15.)

II. ORDERING DATA - TO BE SPECIFIED BY THE PURCHASER

A. ITEM NUMBER

1. Special Instructions

The purchaser shall specify (1) IMPS item number and product name to be purchased; and (2) applicable options, modifications, and special instructions to the requirements of

the IMPS. All items in this series are listed in **Table 1. INDEX OF CURED, SMOKED, AND FULLY-COOKED PORK PRODUCTS AND WEIGHT RANGES** on pages 12-14.

The detailed requirements for each item are listed within the **MATERIAL REQUIREMENTS AND ITEM DESCRIPTIONS** sections of this document. In conjunction with other markings that may be required in the General Requirements and by Food Safety and Inspection Service (FSIS) Regulations, the IMPS item number and the product name (listed in Table 1.) shall be used for marking of shipping containers. Abbreviation of the product name is recommended. Abbreviations, when used, shall be as follows:

Blade - Bld	Trimmed - Trmd
Boneless - Bnls	Short Shank - Sht Shnk
Bladeless - Bldls	Shoulder - Shld
Ground - Grnd	Center Cut - Cntr Cut
Tenderloin - Tender	Skinned - Sknd
Smoked - Smk	Special - Sp

The above products names and abbreviations have been reviewed and approved by USDA, FSIS, Regulatory Programs, Standards and Labeling Division, Washington, DC.

2. Purchaser Specified Options (PSO) (which require purchaser selection)

a. **Ham Items** - 500, 501, 502, 503, 504, 505, 505A, 508, 509, 510, 511, 511A, 512, 512A.

- (1) **Style** - See added ingredients options page10.
- (2) **Weight Range** - See pages 12-14.
- (3) **Certified drained weight examination** - See page 21.
- (4) **PFF analysis** certified by the Meat Grading and Certification Branch - See page16 and Table II.
- (5) **Type and Shape of container** - See detailed item description.
- (6) **Piece size** - See detailed item description.
- (7) **Flavoring** - See detailed item description.
- (8) **Packaging options** - See detailed item description and IMPS General Requirements.
- (9) **CN labeling** - See page 22.

b. **Shoulder Items** - 515, 516, 517, 518, 525, 526, 527, 530, and 531.

- (1) **Style** - See added ingredients option page10.
- (2) **Weight range** - See Table I and detailed item description.
- (3) **PFF analysis** certified by the Meat Grading and Certification Branch - See page16 and Table II.
- (4) **Piece size** - See detailed item description.
- (5) **Flavoring** - See detailed item description.
- (6) **Packaging options** - See detailed item description and IMPS General Requirements.
- (7) **CN labeling** - See page22.

c. **Loin Items** - 545, 546, 547, 547A, 548, 548A, 550, 550A.

- (1) **Style** - See added ingredients options page 10.
- (2) **PFF analysis** certified by the Meat Grading and Certification Branch - See page 16 and Table II.
- (3) **Packaging options** - See detailed item description and IMPS General Requirements.
- (4) **CN Labeling** - See page 22.

d. **Bacon Items** - 535, 536, 537, 538, 538A, 539, 541

- (1) **Style option** not applicable to bacon.
- (2) **Analytical options** - See detailed item description.
- (3) **Packaging options** - See detailed item description and IMPS General Requirements.

e. **Rib and miscellaneous Items** - 514, 555, 556, 558, 559, 559A, 559B, 560, 561, 562, 563.

- (1) **Style option** not applicable.
- (2) **Piece size** - See detailed item description.
- (3) **Packaging options** - See IMPS General Requirements.

F. **Portion Items** - 1513, 1531, 1545, 1548, 1596.

- (1) **Style** - See Table I and added ingredients options page 10. Style option not applicable to item 1596.
- (2) **PFF analysis** certified by the Meat Grading and Certification Branch - See Page 16 and Table II.
- (3) **Fat content** - See detailed item description.
- (4) **Spices** - Item 1596, see detailed item description.
- (5) **Packaging options** - See IMPS General Requirements.
- (6) **CN labeling** - See page 22.

3. Added Ingredients (See Style.)

4. Style (to be specified by the purchaser)

Any of the IMPS items listed in this 500 Series document (EXCEPT selected items identified (*) in Table I) may be ordered by the purchaser to include, natural juices, water or Isolated Soy Protein.

The purchaser must select one of the following style options and specify that style option in the contract or purchase order. If no specific style option is designated by the purchaser, STYLE B when applicable to the item, shall be selected.

<u>STYLE</u>	<u>LABELING REQUIREMENT - QUALIFYING STATEMENT</u>
STYLE A	IMPS Name of Item
STYLE B	(IMPS Name of Item), With Natural Juices
STYLE C	(IMPS Name of Item), Water Added

- STYLE D (IMPS Name of Item) and water product, X% of weight is added ingredients
- STYLE E (IMPS Name of Item), Water And Isolated Soy Protein Added
- STYLE F (IMPS name of Item) & Water Product, Isolated Soy Protein Added. X% of weight is added ingredients.

The maximum percent of added substances in the finished product on a total weight bases would be inserted as the X value. Responsibility for the verification of this X value shall be made by a FSIS, MPIO Inspector.

Contractors producing items listed in TABLE II that have no minimum PFF value shall comply with the following qualification statement labeling requirement:

(IMPS Name) and Water Product
X% of Weight is Added Ingredients

All water or isolated soy protein added product selected by the purchaser shall be labeled (per IMPS General Requirements) on the front or primary display panel of the shipping container with the appropriate IMPS item number and labeling terminology, followed by the appropriate qualifying statement identified above. (As required and approved by USDA, FSIS, Meat and Poultry Technical Services, Standards and Labeling Division)

Example; Item No. 505 - Ham, Boneless (Cured and Smoked), and Water Product,
30% of weight is added ingredients

(NOTE - would be labeled as "IMPS 505" instead of "Item 505" if USDA, AMS certified)

B. GRADE AND SPECIAL REQUIREMENTS (NA)

C. STATE OF REFRIGERATION

- 1 - CHILLED - 28⁰F to 40⁰F (-2.2⁰C to 5⁰C)
- 2 - FROZEN - 0⁰F or lower (-17.8⁰C)

If the purchaser fails to specify state of refrigeration, the product shall be delivered chilled.

D. FAT LIMITATIONS (See individual item descriptions.)

E. PORTION-CUT WEIGHT AND THICKNESS TOLERANCES 1/ 2/

The purchaser shall specify the portion weight and/or thickness desired. For assistance in specifying weight, see weight range tables. When both weight and thickness are specified, it is recommended that those requirements be limited to items that are mechanically pressed and/or sliced.

PORTION THICKNESS TOLERANCES

Specified Thickness	Thickness Tolerance	Thickness Uniformity
1 inch (25 mm) or less	+/- 3/16 inch (5 mm)	3/16 inch (5 mm)

more than
1 inch (25 mm)

+/- 1/4 inch (6 mm)

1/4 inch (6 mm)

PORTION WEIGHT TOLERANCES

Specified Weight	Weight Tolerance	Thickness Uniformity
Less than 6.0 ounces (170 g)	+/- 1/4 oz (7 g)	3/16 inch (5 mm)
6.0 ounces (170 g) or more	+/- 1/2 oz (14 g)	1/4 inch (6 mm)

1/ Thickness measurements are not applicable within 0.25 inch (6 mm) of edge. Also, value listed under thickness uniformity is the maximum allowable difference between the thinnest and thickest measurement of an individual chop or steak.

2/ See detailed Item description for Item 1596.

F. WEIGHT RANGE

The following weight ranges are intended only as guide lines. The purchaser may specify any weight range desired.

TABLE I - INDEX OF CURED, SMOKED, AND FULLY-COOKED PORK PRODUCTS AND WEIGHT RANGE

Item No.	Product	Range A Pounds	Range B Pounds	Range C Pounds
500	Ham, Short Shank (Cured)	10-14	14-17	17-20
501	Ham, Short Shank (Cured and Smoked)	10-14	14-17	17-20
502	Ham, Short Shank, Skinned (Cured)	10-14	14-17	17-20

503	Ham, Short Shank, Skinned (Cured and Smoked), Fully-Cooked	10-14	14-17	17-20
504	Ham, Skinless, Partially Boned (Cured and Smoked)	8-10	10-12	12-14
505	Ham, Boneless (Cured and Smoked), Fully-Cooked	8-10	10-12	12-14
505A	Ham, Boneless, Tied (Cured and Smoked), Fully-Cooked	8-10	10-12	12-14
508	Ham, Boiled, Boneless (Cured), Fully-Cooked	8-10	10-12	12-14
509	Ham, Boneless (Cured and Smoked), Fully-Cooked, Special	5-11	11-16	
510	Ham, Honey Cured (Smoked), Partially Boned, Spiral Cut	8-10	10-12	12-14
511	Ham, Chunked and Formed (Cured), Fully-Cooked	8-10	10-12	12-14
511A	Ham, Chunked and Formed (Cured and Smoked), Fully-Cooked	8-10	10-12	12-14
512	Ham, Diced (Cured)	As specified by purchaser		
512A	Ham, Diced (Cured and Smoked)			
514	Pork, Diced (Cured)			
515	Pork Shoulder (Cured)	8-12	12-16	16-20
516	Pork Shoulder (Cured and Smoked)	8-12	12-16	16-20
517	Pork Shoulder, Skinned (Cured)	8-12	12-16	16-20

TABLE I - INDEX OF CURED, SMOKED, AND FULLY-COOKED PORK PRODUCTS AND WEIGHT RANGE (CONTINUED)

Item No.	Product	Range A Pounds	Range B Pounds	Range C Pounds
518	Pork Shoulder, Skinned (Cured and Smoked)	8-12	12-16	16-20
525	Pork Shoulder Picnic (Cured)	4-6	6-8	8-12
526	Pork Shoulder Picnic (Cured and Smoked)	4-6	6-8	8-12
527	Pork Shoulder Picnic (Cured and Smoked), Boneless, Tied	6-8	8-10	10-12
530	Pork Shoulder Butt, Cellar Trimmed, Boneless (Cured and Smoked)	1.5-3	3-5	5-8

531	Pork Boston Butt, Boneless (Cured and Smoked), Special	2-4	4-6	6-8
535*	Belly, Skin-On (Cured)	10-12	12-14	14-16
536*	Bacon, Slab (Cured and Smoked), Skin-On, Formed	10-12	12-14	14-16
537*	Belly, Slab (Cured and Smoked), Skinless, Formed	10-12	12-14	14-16
538*	Bacon, Slab, Center-Cut (Cured and Smoked), Skinless, Formed	8-10	10-12	12-14
538A*	Bacon, Sliced, Center-Cut (Cured and Smoked)	Number of Slices per Lb. 12-14; 14-18; 18-22; 22-26; 26-30; 28-32; or as specified		
539*	Bacon, Sliced (Cured and Smoked), Skinless			
541*	Bacon, Sliced (Cured and Smoked), Ends and Pieces	5 and 10 Lb. containers or as specified		
545	Pork Loin (Cured and Smoked)	10-14	14-17	17-20
546	Pork Loin, Bladeless (Cured and Smoked)	10-14	14-17	17-20
547	Pork Center Loin, 11 Ribs (Cured and Smoked)	5-7	7-10	10-12
547A	Pork Center Loin, Boneless (Cured and Smoked)	3-5	5-7	7-10
548	Pork Center-Cut Loin, 8 Ribs (Cured and Smoked)	4-6	6-8	8-11

* Style option not applicable to this item.

TABLE I - INDEX OF CURED, SMOKED, AND FULLY COOKED PORK PRODUCTS AND WEIGHT RANGE (CONTINUED)

Item	Product	Range A Pounds	Range B Pounds	Range C Pounds	No.
548A	Pork Loin, Center-Cut, Boneless (Cured and Smoked)	2-4	4-6	6-10	
550	Canadian Style Bacon (Cured and Smoked), Unsliced	3-4	4-6	5-6	
550A	Canadian Style Bacon (Cured and Smoked), Sliced	5 and 10 Lb. containers as specified			
555*	Jowl Butts, Cellar Trim (Cured)	1-2.5	2.5-4		
556*	Jowl Squares (Cured and Smoked)	0.8-2	2-3		
558*	Spareribs, Fully-Cooked	1.5-3	3-5	5-up	
559*	Spareribs (Cured and Smoked)	1.5-3	3-5	5-up	
559A*	Pork Spareribs, Fully-Cooked, St. Louis Style	1.5-2	2-3	3-up	
559B*	Pork Spareribs (Cured and Smoked), St. Louis Style	1.5-2	2-3	3-up	
560*	Hocks, Ham (Cured and Smoked)	0.5-1	1-1.5	1.5-2.5	
561*	Hocks, Shoulder (Cured and Smoked)	0.5-1	1-1.5	1.5-2.5	
562*	Clear Fatback (Cured)	6-8	8-10	10-12	
563*	Feet, Front (Cured)	0.8-1.5			
PRECOOKED PORTION ITEMS					
1513	Ham Patties (Cured), Fully-Cooked.	3-5 oz.	As specified by the purchaser		
1531	Ham Steaks (Cured and Smoked), Boneless	5-12 oz.	As specified by the purchaser		
1545	Pork Loin Chops (Cured and Smoked)	3-8 oz.	As specified by the purchaser		
1548	Pork Loin Chops, Boneless, Center Cut (Cured and Smoked)	3-8 oz.	As specified by the purchaser		
1596*	Pork Patty, Pre-Cooked	3-8 oz.	As specified by the purchaser		

*- Style option not applicable to this item

G. NETTING AND TYING

When tying is required, FSIS, MPIO approved stretchable netting shall be used to make cuts firm and compact. Unless otherwise specified, cuts shall be netted so that all portions are held intact, without any portions protruding through the ends of the netting. Alternatively, cuts may be string tied by loops of twine uniformly spaced at no more than approximately 2-inch (51 mm) intervals girthwise (perpendicular to item length). When girthwise tying does not make cuts firm and compact, lengthwise tying shall also be used.

H. PACKING AND PACKAGING

Purchaser shall specify packaging and packing for delivery of product (See IMPS General Requirements for details.)

I. QUALITY ASSURANCE

The purchaser may consult the IMPS Quality Assurance Provisions for options regarding production examination and lot acceptance criteria in terms of acceptable quality levels (AQL's).

J. USDA CERTIFICATION - When requested, the purchaser shall specify within a contract or purchase order that product shall be certified by USDA, AMS, Meat Grading and Certification Branch. The purchaser shall consult the IMPS Quality Assurance Provisions for options regarding product examination and lot acceptance criteria in terms of acceptable quality levels (AQL's). For more information regarding this service, contact:

**USDA, MRP, AMS, Livestock and Seed Program
Meat Grading and Certification Branch
Stop 0248 Room 2628 S-Bldg
1400 Independence Ave. SW
Washington, D.C. 20250-0248 Phone: (202) 720-1113 Fax: (202)-690-4119**

Internet Address: <http://www.ams.usda.gov/lsg/lsg.htm>

III. MATERIAL REQUIREMENTS

All product offered must comply with the following material requirements and the individual item descriptions. For certification, product shall be evaluated in accordance with the IMPS QUALITY ASSURANCE PROVISIONS.

A. PROTEIN FAT FREE REQUIREMENTS

USDA's Food Safety and Inspection Services, Meat and Poultry Inspection program implemented the Protein Fat-Free (PFF) regulation on April 15, 1985.

The Protein Fat-Free (PFF) procedure reflects the presence of added ingredients, including water, and relates labeling claims to the percent of meat protein in the product. Simply stated, this means that water added to the product dilutes the natural protein content, and for certain products to meet the labeling regulations established by FSIS, MPIO, the product must comply with the minimum PFF percentage listed in TABLE II.

Unless otherwise specified in the purchaser's contract, the producer/vendor shall be responsible for providing to the purchaser, laboratory analysis and written verification of PFF values on all lots of cooked, cured, cooked and cured, hams, loins, shoulders, and portion items (EXCEPT Items identified in Table I (*) which have no PFF requirement). PFF values must meet or exceed FSIS, MPIO regulations applicable to each individual type of product being produced. Failure of the average analytical analysis of a sample unit to meet or exceed the FSIS, MPIO minimum required PFF percentages listed in TABLE II shall cause rejection of the involved lot. See the IMPS Quality Assurance Provisions for detailed sampling procedures.

Contractors producing items listed in TABLE II that have no minimum PFF value shall not be required to provide laboratory analysis/ verification of the PFF value to the purchaser. This type of product shall be labeled in accordance with IMPS General Requirements with the following qualification statement:

(IMPS Name) and Water Product
X% of Weight is Added Ingredients

The maximum percent of added substances in the finished product on a total weight bases would be inserted as the X value. Responsibility for the verification of this X value shall be made by a FSIS, MPIO Inspector.

PFF values shall be determined at a FSIS approved and certified laboratory designated by the vendor, who shall be responsible for supplying official documentation of the PFF results directly to the purchaser.

The USDA, AMS, Meat Grading and Certification Branch shall only Certify PFF values when specifically designated to do so in the purchaser's contract or purchase order.

TABLE II – INDEX OF PRODUCTS AND MINIMUM PFF PERCENTAGES

PRODUCT NAME AND QUALIFYING STATEMENT	MINIMUM MEAT PFF PERCENTAGE
1. COOKED HAM, COOKED LOIN	20.5
2. COOKED HAM, COOKED LOIN (with natural juices)	18.5
3. COOKED HAM, COOKED LOIN (water added)	17.0
4. COOKED HAM, COOKED LOIN (and water product)	LESS than 17.0
5. COOKED SHOULDER, BUTT, PICNIC	20.0
6. COOKED SHOULDER, BUTT, PICNIC (with natural juices)	18.0
7. COOKED SHOULDER, BUTT, PICNIC (water added)	16.5
8. COOKED SHOULDER, BUTT, PICNIC (and water product)	LESS than 16.5
9. UNCOOKED CURED HAM, OR LOIN	18.0
10. UNCOOKED CURED HAM, OR LOIN (and water product)	LESS than 18.0
11. UNCOOKED CURED SHOULDER, BUTT, PICNIC	17.5
12. UNCOOKED CURED SHOULDER, BUTT, PICNIC (and water product)	LESS than 17.5
13. HAM PATTIES, CURED	19.5
14. HAM PATTIES, CURED (with natural juices)	17.5
15. HAM PATTIES, CURED (water added)	16.0
16. HAM PATTIES, CURED (and water product)	LESS THAN 16.0

B. QUALITY

Hams, loins, shoulders, shoulder picnics, Boston butts, and pork side (belly), shall have at least a moderate degree of meatiness, based on a composite evaluation of thickness of muscling and quantity of intermuscular and internal fat.

Bellies must indicate at least a slightly high ratio of lean to fat and have uniform distribution of fat and lean layers. They may vary in thickness from slightly thick to moderately thick and shall be moderately uniform in thickness and moderately long in relation to their width.

Cuts shall be at least moderately thick and plump with no more than a small amount of intermuscular (seam) fat. The lean meat shall be firm and have a bright reasonably uniform cured color (slightly two-toned is permissible). The meat shall have a fine, smooth texture. The pork cuts must be free from bruises, broken bones, dislocated or enlarged joints or other malformations, odor or flavor foreign to meat, and be practically free from scores, miscuts, hook marks, or other defects which would negatively affect the usability of the product. Pork cuts showing only a slight amount of hair roots, or which are only slightly misshapen may be included.

1. Lean Quality

All pork shall be practically free from bruises, blood clots, bloody tissue, blood discoloration, bone dust, exposed spinal cord portions, or any other conditions which would negatively affect the use of the product. Pork shall be thoroughly cured and/or smoked and shall not show any evidence of coarse, dark, and/or open porous textured lean.

2. Skeletal Condition

When present, bones shall not be ossified to a degree that cartilage is not evident in the pelvic, spinal, and scapular sections. The split chine bones, spinous processes, and cross-cut sections of bones must be porous.

Pork cuts shall be free from dislocated or enlarged joints or other malformations of the skeletal structure. However, cuts with bones broken during processing are acceptable if the bones are not splintered to the extent that the lean around the fracture is affected.

C. CASING REQUIREMENTS

When items are required to be enclosed in an artificial casing, plastic bag, polyethylene liner or vacuum sealed 1 pound packages, the materials used shall be of sufficient strength and quality to prevent splits, holes or extrusion of the product from the casing and, when applicable, loss of vacuum in the package.

D. CUTTING REQUIREMENTS

Unless otherwise specified in the individual item descriptions, all cuts shall be made in a straight line approximately perpendicular to the outer "skin" surface.

E. TRIMMING REQUIREMENTS

Unless otherwise specified, all boneless cuts shall be totally skin free. Cuts may have a minor amount of trimming done after curing and smoking, and prior to acceptance, as indicated in the examples below. However, cuts which have been excessively trimmed in order to meet specified weights, or which do not meet specification requirements for any reason, are not acceptable. Examples of permitted minor trimming:

1. Fat on the butt end (anterior) of hams and the butt end (dorsal) and sides of shoulders may be beveled to meet specification requirements.
2. Shanks from hams, shoulders, and shoulder picnics may be removed (though not beyond natural separation points) to meet specification requirements.
3. Pelvic fat, loose fat, and ragged edges on the face of a ham may be removed, provided it is done without any scoring of the muscular portion.
4. Edges of slab bacon (skinless or skin on) for use on slab bacon contracts, and edges of slab bacon to be used in production of sliced bacon may be trimmed to meet specification requirements.

Trimming of external fat shall be accomplished by smoothly removing the fat following the contour of the underlying muscle surface. Beveling of the edges only is not acceptable. Two terms used for describing surface fat limitations are: (1) maximum fat thickness at any one point and (2) average fat thickness. The maximum fat thickness at any one point is evaluated by visually determining the areas of a cut which have the thickest fat depositions and measuring the thickness of fat in these areas.

The actual measurements of fat are made on the edges of the cut and by probing or scoring the overlying fat as necessary in a manner that reveals the actual fat thickness and any natural depression or seam which could affect the measurement. When a natural depression occurs in a muscle, only the fat above the portion of the depression that is more than 0.75 inch (19 mm) in width is considered.

When a seam of fat occurs between adjacent muscles, only the fat above the level of the involved muscles is measured. The average fat thickness is determined by evaluating the thickness of fat, as described above over the various areas of the fat surface in relation to the surface area that each thickness represents.

<u>MAX. AVERAGE FAT THICKNESS</u>	<u>MAX. FAT AT ANY ONE POINT</u>
1/4 inch (6 mm)	1/2 inch (13 mm)
Practically free (75% lean exposed)	1/4 inch (6 mm)

Note: When average fat thickness are specified in an item description, the appropriate "MAXIMUM AT ANY ONE POINT" limitation shall apply.

F. FINISHED PRODUCT CHARACTERISTICS

The finished product shall show no evidence of freezing, defrosting, or mishandling, and shall be free of any "off" or foreign odors. The product shall reflect the appropriate style, shape, weight range, curing, skinning, boning, defatting, smoking, cooking, packaging, packing, and state of refrigeration (as applicable). In addition, the color of the lean meat shall be characteristic of a thoroughly-cured product without evidence of greening, streaking, or other discoloration (a slightly two toned or iridescent color is permissible). The product shall possess a fine, smooth texture and be cohesive, firm or only slightly resilient, but not unduly hard. Smoked products shall have an acceptable flavor and aroma and a fairly bright, uniform well-penetrated smoked color, and be practically free from extraneous material, including encrusted salt and smokehouse residue (except the natural smoke color). The smoked product shall be fairly dry on the exterior and interior, but not excessively dry or scorched. Cooked products shall be fully-cooked and practically free from air holes, pockets of moisture, rendered fat, gelatinous matter, ragged edges, surface strings (except closely tied necessary netting), and extraneous material, and shall be totally free from fermented or other odor or flavor foreign to meat, rancidity, mold, and other deterioration or damage.

For examination of the cut surfaces of whole bone in and boneless cuts, the item shall be divided into (2) two pieces not less than 2.5 inches from either end. For certification, the right hand cut surface shall be evaluated for defects in accordance with the IMPS QUALITY ASSURANCE PROVISIONS. Within 5 minutes of making the cut and without application of any hand pressure, whole bone in and boneless cuts within the 500 series shall not exhibit more than a slight amount of dripping or exudation of moisture on the cut surface.

After examination of the cut surface the producer may repackage the sampled product and include in the accepted delivery unit, or replace with extra product from the same production lot.

G. DRAINED WEIGHT REQUIREMENT

Unless otherwise specified by the purchaser, canned ham items and non smoked items cooked in plastic cooking bags, in addition to meeting the required PFF percentages, shall also meet the following drained weight requirements.

Pullman cans - Drained weight of ham shall be not less than 97% of net weight.

Pear Shaped cans - Drained weight of ham shall be not less than 95% of marked net weight.

Plastic cooking bags - Drained weight of ham shall be not less than 99% of marked net weight.

Total net weight shall be determined by subtracting the tare weight from the gross weight. The tare weight shall be determined by weighing randomly selected empty cans, lids and bags used in packaging the product. The number of empty containers selected shall be equivalent to the number of samples examined for total drained weight. See the IMPS Quality Assurance Provisions for detailed sampling procedures.

H. SOY PROTEIN PRODUCTS

UNLESS OTHERWISE SPECIFIED BY THE PURCHASER, vegetable protein flours and concentrates shall not be acceptable in the items specified in this document. Any vegetable protein product used shall not impart any flavors to the meat item and shall be at least 85% protein (as is basis), 90% protein (moisture free). The vegetable protein product shall be included in the cure at a rate not to exceed 2 percent of the weight of the finished product. Unless otherwise specified by the purchaser, responsibility for the verification of formulations shall be with the FSIS, MPIO inspector. Style E shall meet or exceed the following PFF percentages:

Style E - minimum PFF percentage shall not be less than 17%

Style F - No Minimum PFF percentage

Contractors producing Style F items which have no minimum PFF value, shall comply with the following qualification statement labeling requirement:

(IMPS Name) and Water Product
Isolated Soy Protein Added
x% of Weight is Added Ingredients

The maximum percent of added substances in the finished product on a total weight bases would be inserted as the X value percent. Responsibility for the verification of this X value shall be with the FSIS, MPIO inspector.

I. CHILD NUTRITION PROGRAMS

If specified by the purchaser, the Vegetable Protein Isolate shall be fortified to meet or exceed the Food and Nutrition Service guide for the National School Lunch Program and shall comply with applicable CN labeling requirements. If this option is chosen, the package label shall state, "This product meets USDA-FNS requirements for use in meeting a portion of the meat/meat alternate requirement of the child nutrition programs". Labeling of the finished product must reflect Isolated Soy Protein in the ingredient statement (i.e., Isolated Soy Protein product, Zinc Oxide, Niacinamide, Ferrous Sulfate, Copper Gluconate, Vitamin A Palmitate, Calcium Pantothenate,

Thiamine Monitrate (B₁), Pyridoxine Hydrochloride (B₆), Riboflavin (B₂), Cyanocobalamin (B₁₂)).

The purchaser shall maintain the right to verify, using appropriate testing procedures, that the Vegetable Protein Product complies with the specification requirement.

IV. DETAILED ITEM DESCRIPTIONS

Item No. 500 - Ham, Short Shank (Cured). - The ham is separated from the side by a straight cut approximately perpendicular to the outer skin surface and to a line parallel to the shank bones. This cut passes through a point that is not less than 1.5 inches and not more than 3.0 inches from the anterior edge of the *aitch bone*. Approximately half or more of the shank (anterior to the *Achilles tendon* but not beyond the stifle joint) shall be removed by a straight cut made at a right angle to the shank bones. The tail, vertebrae, (opaque) *gracilis membrane*, *rectus femoris (flank muscle)*, *cutaneous trunci*, *prefemoral lymph gland*, and/or any exposed lymph gland shall be removed. The skin, and collar fat over the *semimembranosus* (cushion) shall be smooth and well rounded such that the innermost curvature of the skin is trimmed back at least half the distance from the stifle joint to the posterior edge of the *aitch bone*. The skin overlying the medial side (inside) of the *quadriceps femoris* shall be removed and fat overlying the *quadriceps femoris* and pelvic area shall be removed close to the lean. Each ham

shall be individually wrapped in moisture and grease resistant wax paper or plastic. Unless otherwise specified by the purchaser, the fat thickness beneath the ham face measured at the skin edge directly under the bone shall not exceed that indicated in the following schedule.

END ITEM EXAMINATION - TABLE 500A

WEIGHT RANGE OF HAM (POUNDS)

MAXIMUM FAT THICKNESS

A. 14 - 17 (6.4 - 7.7 kg)	.5 in. (13 mm)
B. 17 - 20 (7.7 - 9.1 kg)	.75 in. (19 mm)
C. 20 - 26 (9.1 - 11.8 kg)	1.00 in. (25 mm)
D. 26 (11.8 kg) and up	1.25 in. (32 mm)

Item No. 501 - Ham, Short Shank (Cured and Smoked). - The (cured and smoked) short shank ham must conform with the requirements specified for Ham, Short Shank (Cured) - Item No. 500, except that in addition to curing, the ham shall be smoked.

END ITEM EXAMINATION - TABLE 500A

Item No. 502 - Ham, Short Shank, Skinned (Cured). - The skinned short shank ham shall conform with the requirements specified for a Ham, Short Shank, (Cured) - Item 500, except that the ham shall have a well rounded skin collar in which the skin is removed at or posterior to the stifle joint on a line which is parallel with the loin-ham separation. Fat remaining on the skinned surface area shall not exceed 0.25 inch (6 mm) average depth (0.5 inch (13 mm) maximum depth at any point) 1.5 inches (38 mm)

or more from the edge of the skin collar. Fat along the butt end shall be neatly beveled to meet the lean.

END ITEM EXAMINATION - TABLE 500A

Item No. 503 - Ham, Short Shank, Skinned (Cured and Smoked), Fully Cooked. -

The skinned (cured and smoked), fully-cooked ham shall conform with the requirements for Ham, Short Shank, Skinned (cured) Item No. 502, except that in addition to curing, the ham shall be smoked and cooked using a dry-heat method. All trimming, skinning, and defatting may be accomplished before or after curing, but must be done prior to smoking and cooking (exceptions section B part 6) so that the finished product will be trimmed, shapely, smooth, and uniformly smoked on the entire surface. Promptly after smoking and cooking, the fully cooked ham shall be handled as necessary to remove rendered surface fat and extraneous matter. After cooking, the fully cooked ham shall be properly chilled (28⁰F to 40⁰F) prior to individual wrapping in suitable moisture and grease resistant plastic or paper.

END ITEM EXAMINATION - TABLE 500A

Item No. 504 - Ham, Skinless, Partially Boned (Cured and Smoked). -The skinless, partially boned ham (cured and smoked) shall conform with the requirements specified for Ham, Short Shank (Cured and Smoked) - Item No. 501, except that the ham shall be made completely skinless and the shank shall be removed from the ham through the natural seam separating the shank and the heel (inner shank). All surface fat in excess of 0.25 inch (6 mm) average depth, (0.5 inch (13 mm) maximum depth at any point) shall be removed. All trimming, skinning, and defatting may be accomplished either before or after curing but must be done prior to smoking (exceptions section B part 6). The *itch bone* and overlying flesh and shank bones shall be removed without undue scoring or other damage to the ham, leaving the *femur bone* intact in the ham. The ham shall be encased in an artificial casing, producing a smooth, plump, elongated, oval-shaped, skinless, partially boned, cured and smoked ham. END ITEM EXAMINATION - TABLE 500A

Item No. 505 - Ham, Boneless (Cured and Smoked), Fully-Cooked. - The skinless, completely boneless (cured and smoked) fully-cooked whole muscle ham shall be free of exposed lymph glands, the *popliteal lymph gland* and exposed, heavy (opaque) connective tissue. The *femur bone* shall be removed closely without undue scoring or damaging the ham. Approximately half or more of the shank (anterior to the *Achilles tendon* but not beyond the stifle joint) shall be removed by a straight cut made at a right angle to the shank. Naturally attached shank meat may be included and shall be folded into femur bone cavity as a plug. The ham shall be fully cooked using a dry-heat method. All surface fat in excess of 0.25 inch (6 mm) depth at any point shall be removed. The prepared cured ham shall be encased in a close-fitting, artificial casing of good transparency showing the exterior characteristics of the smoked ham. The casing

must be of suitable size, strength, and quality to withstand conventional careful handling of the product to the time of delivery. The ham shall be handled and placed in the casing with the major muscle fibers running parallel (lengthwise) with the casing to permit customary slicing at approximate right angles to the long axis of the ham. The resulting ham shall be a smooth, compact, cohesive item of good symmetry having a cylindrical, oval, or elliptical shape and without detrimental recesses (pockets of air, moisture, rendered fat), in the finished product (close string stitching permissible). END ITEM EXAMINATION - TABLE 500B

Item No. 505A - Ham, Boneless, Tied (Cured and Smoked), Fully Cooked. - The skinned, boned, and tied (cured and smoked) ham is the same as Ham, Skinless, Boneless (Cured and Smoked) - Item No. 505, except that the ham shall not be encased in an artificial casing. The boneless ham shall be netted or string tied. END ITEM EXAMINATION - TABLE 500B

Item No. 508 - Ham, Boiled, Boneless (Cured), Fully Cooked. -This item may be prepared from any portion(s) of the ham(s) that has been trimmed practically free of fat and heavy (opaque) connective tissue. Shank meat may only be included if ground/chopped and used as a binder. The amount of binder used shall not exceed MPIO regulations. The finished product may be Pullman or pear shaped and may be canned or cooked and then stuffed into a close-fitting, vacuum packed, polyethylene plastic bag as specified by the purchaser. If a polyethylene plastic bag style container is specified, the container shall be free from holes, and the exterior of the encased ham shall be free from gelatinous material, rendered fat, extraneous matter, and mechanical fasteners. If canning is specified, the cans shall be lined with a suitable polyethylene bag that will completely cover the ham. At the option of the purchaser, smoke flavoring may be added to either of the two styles of ham. However, if this option is chosen, it shall be so noted in the labeling nomenclature. END ITEM EXAMINATION - TABLE 500B

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED

Type: A. Canned (if selected must be reflected in label)
B. Polyethylene plastic bag style container

Shape: A. Pear shaped
B. Pullman shaped

Flavoring: A. Smoke flavoring NOT added.
B. Smoke Flavoring added (if selected must be reflected in label, i.e., "smoke flavoring added")

Item No. 509 - Ham, Boneless (Cured and Smoked), Fully Cooked, Special. - This item is prepared from one or a combination of the larger muscle systems of the ham specifically from the *semimembranosus* (inside) and associated muscles or *biceps femoris* (outside) of the ham. Any of the remaining portions of the ham may be included only if ground/chopped and used as a binder, the amount of binder used shall not exceed MPIO regulations. The lean shall be trimmed of all fat including seam fat and shall be practically free from exposed heavy (opaque) connective tissue. A cross section of this item shall have the appearance of four (or less) whole muscle systems (excluding binder) which is of an even uniform color across the entire cut surface (two tone color not permitted).
END ITEM EXAMINATION - TABLE 500B

Item No. 510 - Ham, Honey Cured (Smoked), Partially Boned, Spiral cut. - This item shall be prepared as described in Item 504, except honey shall be included in the curing process. The ham shall be spiral sliced (thickness to be specified by the purchaser) with the ham slices remaining firmly attached to the femur bone and packaged into a close-fitting, vacuum packed, polyethylene plastic bag. END ITEM EXAMINATION - TABLE 500A

Item No. 511 - Ham, Chunked and Formed (Cured), Fully Cooked. - This item may be prepared from any portion of the ham (except shank meat) which will meet end item requirements. Shank meat may only be included if ground/chopped and used as a binder. The amount used shall not exceed MPIO regulations. The ham shall be free from bones, cartilage, skin, heavy connective tissue, air, or gelatin pockets and lymph glands. A cross-sectional cut of this item shall show a definition of various muscle groups as you would expect to see of chunks of ham held together with binder of finely ground ham trimmings or finely ground shank meat. If the purchaser chooses the canning option, the ham shall be fully enclosed in a polyethylene liner and unless otherwise specified shall be formed and canned Pullman style.
END ITEM EXAMINATION - TABLE 500B

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED

TYPE: A. Canned (if selected must be reflected in label)
B. Artificial casing

Shape: A. Pear shaped
B. Pullman shaped

Item No. 511A - Ham, Chunked and Formed (Cured and Smoked), Fully-Cooked. - This item is prepared exactly as described in Item 511 except that in addition to being
IMPS 500 CURED, CURED AND SMOKED, AND 25 EFFECTIVE DATE: JANUARY 1992
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cured the ham shall be stuffed into an artificial casing and smoked. Artificial smoke flavoring shall not be allowed. END ITEM EXAMINATION - TABLE 500B

Item No. 512 - Ham, Diced (Cured). - This item may be prepared from any 500 series boneless, fully-cooked, cured ham (specified by the purchaser) or portions thereof which will meet all end item requirements for diced ham. Dices shall be practically free from shank and heel meat (inner shank), fat, bones, cartilage, skin, connective tissue and lymph glands. The meat shall be either hand diced or mechanically diced (grinding is not permitted). At least 75%, by weight, of the resulting pieces shall comply with the designated size requirement. To facilitate dicing, hams may be frozen and/or tempered one time only prior to dicing. The examination for shank and heel meat (inner shank) and condition shall be done prior to freezing or dicing (a sample unit shall be 10 pounds of adjacent product and the sample size shall be as specified in QAP Table I-A). Piece size and packaging requirements shall be at the option of the purchaser. Smoke flavoring is not permitted.

END ITEM EXAMINATION - TABLE 500J

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED

- Piece Size Options:
- A. 1/4 inch Cube
 - B. 1/2 inch Cube
 - C. 1/2 inch x 1/2 inch x 1 inch long
 - D. 1/2 inch x 1/2 inch x 2 1/2 inches long
 - E. Other, as specified by purchaser

- Packaging Options:
- A. Individual Servings (size as specified by purchaser)
 - B. Bulk Pack (size as specified by purchaser)

Item No. 512A - Ham, Diced (Cured and Smoked). - This item is prepared exactly as described in Item 512 except that in addition to being cured the ham shall also be smoked prior to dicing. All trimming, skinning, and defatting may be accomplished either before or after curing but must be done prior to smoking or dicing (exceptions section B part 6).

END ITEM EXAMINATION - TABLE 500J

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED

- Piece Size Options:
- A. 1/4 inch Cube
 - B. 1/2 inch Cube
 - C. 1/2 inch x 1/2 inch x 1 inch long
 - D. 1/2 inch x 1/2 inch x 2 1/2 inches long
 - E. Other, as specified by purchaser

- Packaging Options:
- A. Individual servings (size as specified by purchaser)
 - B. Bulk pack (size as specified by purchaser)

Item No. 514 - Pork, Diced (Cured). - This item is the same as Item 511 except that is prepared from any cured portion of the carcass which will meet the end item requirements. Shank meat and jowls shall be excluded. Dices shall be free of shank meat, bones, cartilage, skin, heavy connective tissue, and lymph glands. The meat shall be either hand diced or mechanically diced (grinding is not permitted). At least 75%, by weight, of the resulting pieces shall comply with the designated size and fat requirement. Dices shall not exceed 0.25 inch (6 mm) in maximum depth of surface fat. Dices shall not exceed 0.25 inch (6 mm) maximum width of seam fat. To facilitate dicing, pork may be frozen and/or tempered one time only prior to dicing. The examination for shank and heel meat (inner shank) and condition shall be done prior to freezing or dicing (a sample unit shall be 10 pounds of adjacent product and the sample size shall be as specified in QAP Table I-A). Piece size and packaging requirements shall be at the option of the purchaser. At the option of the purchaser smoke flavoring may be added to cured ham, however, if this option is chosen, it shall be so noted in the labeling nomenclature (i.e., smoke flavoring added).
END ITEM EXAMINATION - TABLE 500J

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED

Piece Size Options:

- A. 1/4 inch Cube
- B. 1/2 inch Cube
- C. 1/2 inch x 1/2 inch x 1 inch long
- D. 1/2 inch x 1/2 inch x 2 1/2 inches long
- E. Other, as specified by purchaser

Flavoring:

- A. Smoke flavoring NOT added.
- B. Smoke flavoring added (if selected, must be reflected on label, i.e., smoke flavoring added)

Packaging Options:

- A. Individual Servings (size as specified by purchaser)
- B. Bulk pack (size as specified by purchaser)

Item No. 515 - Pork Shoulder (Cured). - The cured shoulder is separated from the side by a straight cut, approximately perpendicular to the outer skin surface, beginning not more than 1 inch posterior to the elbow joint, but not exposing the elbow joint and continuing across the hog side. The *longissimus dorsi* must be evident. The neckbones, ribs, breastbones, cartilage, *intercostal* meat, exposed lymph glands and breast flap shall be removed. The shoulder shall be suitably faced without appreciable scoring or undue removal of lean. The foot shall be removed at or slightly above the upper joint of the knee by a straight cut made at an approximate right angle to the shank bones. Unless otherwise specified, shoulders with shorter shanks (but not cut beyond the elbow joint) will be acceptable. The jowl shall be removed by a straight cut approximately perpendicular with the loin side that is anterior to, but not more than 1.0 inch (25 mm) from the innermost curvature of the ear dip. The fat and skin shall be beveled to approximately meet the lean at the butt end. The exterior fat thickness, measured perpendicular to the skin at the approximate center of the butt, shall not exceed that indicated in the following schedule:
END ITEM EXAMINATION - TABLE 500C

<u>Weight Range of Shoulder</u>	<u>Maximum Fat Thickness</u>
A. 8-12 pounds (3.6 - 5.4 kg)	0.5 inch (12.7 mm)
B. 12-16 pounds (5.4 - 7.3 kg)	0.75 inch (38 mm)
C. 16-20 pounds (7.3 - 9.1 kg)	1.0 inch (38 mm)

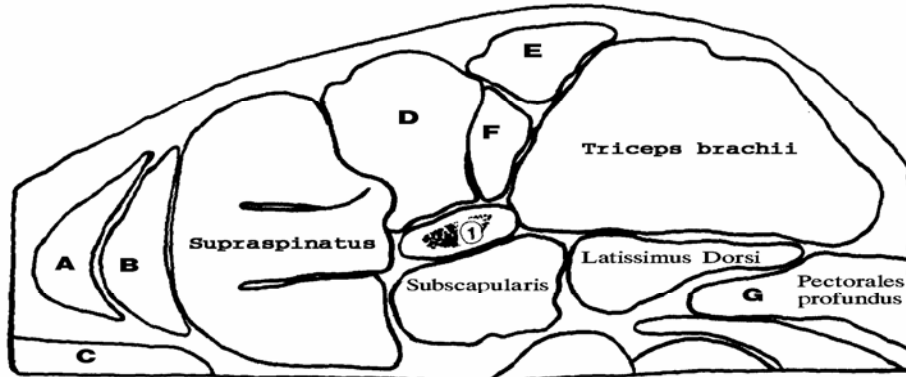
Item No. 516 - Pork Shoulder (Cured and Smoked). - The cured and smoked shoulder shall conform to the requirements specified for Shoulder, (Cured) - Item No. 515, except that in addition to curing, the shoulder shall be smoked. All trimming, skinning, and defatting may be accomplished either before or after curing but must be done prior to smoking (exceptions section B part 6).
END ITEM EXAMINATION - TABLE 500C

Item No. 517 - Shoulder, Skinned (Cured). - The partially skinned shoulder (cured) shall conform to the requirements specified for a Shoulder (Cured) - Item No. 515, except that the shoulder shall be partially skinned leaving a well-rounded skin collar. The skin shall be removed dorsal to a straight line parallel to the dorsal side that starts at a point that does not exceed 25 percent of the distance from the elbow joint to the butt edge. Fat remaining on the skinned surface shall not exceed 0.25 inch average depth (0.5 inch maximum at any point) 1.5 inches or more from the edge of the skin collar and shall be beveled to approximately meet the lean at the butt end and on both sides. At least traces of false lean shall be exposed.
END ITEM EXAMINATION - TABLE 500C

Item No. 518 - Pork Shoulder, Skinned (Cured and Smoked). - The skinned shoulder (cured and smoked) shall conform with the requirements specified for Shoulder, Skinned (Cured) - Item No. 517, except that in addition to curing, the shoulder shall be smoked. All trimming, skinning, and defatting may be accomplished either before or after curing but must be done prior to smoking (exceptions section B part 6).
END ITEM EXAMINATION - TABLE 500C

Item No. 525 - Pork Shoulder Picnic (Cured). - The cured shoulder picnic is that portion of the standard cut Shoulder, (Cured) Item No. 515, remaining after the removal of the Boston butt. The shoulder picnic is separated from the Boston butt by a straight

Butt-picnic separation



- A** Cutaneous faciei
- B, G** Pectorales profundus
- C** Semispinalis capitis
- D** Infraspinatus
- E** Deltoideus
- F** Teres minor
- 1** Scapula

cut, dorsal to the shoulder joint at an approximate right angle with the belly side. The jowl shall be removed by a straight cut approximately parallel with the belly side which is not more than 1 inch (25 mm) from the *Pectorales profundi* (half moon muscle), measured on the

butt side. The foot shall be removed at or slightly above the upper knee joint at an approximate right angle to the shank bone. Unless otherwise specified, shoulder picnics with shorter shanks (but not cut dorsal to the elbow joint) will be acceptable. The skin and fat shall be beveled to meet the lean at the butt side. The exterior fat thickness measured at the skin edge of the bevel directly under the blade bone at the butt edge, shall not exceed the following schedule:

END ITEM EXAMINATION - TABLE 500C

Maximum Fat Thickness

<u>Weight Range of Shoulder Picnic</u>	<u>Maximum Fat Thickness</u>
4-6 pounds (1.8 - 2.7 kg.)	.25 inch (6 mm)
6-8 pounds (2.7 - 3.6 kg.)	.5 inch (13 mm)
8-12 pounds (3.6 - 5.4 kg.)	.75 inch (19 mm)

Item No. 526 - Shoulder Picnic (Cured and Smoked). - The shoulder picnic (cured and smoked) must conform with the requirements specified for Shoulder Picnic (Cured) - Item No. 525, except that in addition to curing, the shoulder picnic shall be smoked. All trimming, skinning, and defatting may be accomplished either before or after curing but must be done prior to smoking (exceptions section B part 6).

END ITEM EXAMINATION - TABLE 500C

Item No. 527 - Pork Shoulder Picnic (Cured and Smoked), Boneless, Tied. - This item is prepared from Item No. 526, except that the picnic shall be made completely boneless and skinless. The arm bone and blade bone shall be removed closely without unduly scoring or damaging the Shoulder Picnic. Tendinous ends of the shank shall be trimmed to expose at least 75% lean. Surface fat in excess of 0.25 inch (6 mm) maximum at any point shall be removed. All trimming, skinning, and defatting may be accomplished either before or after curing but must be done prior to smoking (exceptions section B part 6). When specified the picnic shall be netted or tied. END ITEM EXAMINATION - TABLE 500D

Item No. 530 - Pork Shoulder Butt, Cellar Trimmed, Boneless (Cured and Smoked). - The boneless shoulder butt is separated from the shoulder as described in Item 525. All bones and skin shall be removed, and surface fat in excess of 0.25 inch (6 mm) in depth shall be removed. The blade bone and overlying lean shall be removed. At least traces of *trapezius* (false lean) shall be exposed, and the fat shall be beveled to meet the lean. The jowl shall be removed by a straight cut approximately parallel with the loin side that is anterior to but not more than 1.0 inch (25 mm) from the innermost curvature of the ear dip. The picnic side shall expose the *supraspinatus* with no more than a slight enlargement of the tendons. The trimmed, boneless shoulder butt shall be cured and stuffed into a close, smooth-fitting artificial casing, either prior to or after smoking. Dissolved clear gelatin may be used to momentarily dip the product to facilitate stuffing in the casing. Promptly after smoking, the finished product shall be handled as necessary to remove grease and extraneous matter. END ITEM EXAMINATION - TABLE 500D

Item No. 531 - Pork Boston Butt, Boneless (Cured and Smoked), Special. - The boneless shoulder butt is separated from the shoulder as described in Item 525. All bones, skin, and *trapezius* shall be removed. This item shall be trimmed practically free of all surface fat (i.e. at least 75% lean shall be exposed and any remaining fat shall not exceed 0.25 inch (6 mm) maximum depth at any point). The jowl shall be removed by a straight cut approximately parallel with the loin side and immediately posterior to the ear dip. The trimmed, boneless Boston butt shall be cured and stuffed into a close, smooth-fitting artificial casing either prior to or after smoking. Dissolved clear gelatin may be used to momentarily dip the product to facilitate stuffing in the casing. Promptly after smoking, the finished product shall be handled as necessary to remove grease and extraneous matter. END ITEM EXAMINATION - TABLE 500D

Item No. 535 - Belly, Skin-On (Cured). - The skin-on (cured) belly is prepared from that portion of the pork side remaining after removal of the shoulder, loin, fat back, and the spareribs. All bones and cartilage shall be removed. Practically all leaf fat shall be removed. The belly shall be separated from the fat back in a straight line not more than 1.5 inches (38 mm) beyond the outermost dorsal curvature of the scribe line. All sides and ends of the belly shall be reasonably straight and parallel. No one side of the belly

may be more than 2.0 inches longer than it's opposing side. The width of the *rectus abdominous* (flank muscle) shall be at least 25% of the width of the belly on the ham end. The belly shall be free of enlarged soft, porous, or seedy mammary tissue, pizzle recesses, scores, and other damage affecting the end product. There shall be no area of exposed fat on the face of the belly below the scribe line that exceeds 8.0 square inches.

END ITEM EXAMINATION - TABLE 500E

Item No. 536 - Bacon, Slab (Cured and Smoked), Skin-on, Formed. - The skin on (cured and smoked) slab bacon shall conform with the requirements specified for Belly, Skin-on (Cured) - Item No. 535, except that the belly shall be pressed and squared on all edges with approximately straight and parallel sides and ends. In addition to curing, the belly shall be smoked.

END ITEM EXAMINATION - TABLE 500E

Item No 537 - Bacon, Slab (Cured and Smoked), Skinless, Formed. -The skinless slab bacon shall conform with the requirements specified for Bacon, Slab (Cured and Smoked), Skin-on, Formed - Item No. 536 except that the finished product shall have the skin removed and excluded, leaving a smoothly skinned surface free of hair roots. The skin may be removed from the belly or slab bacon, either before or after curing, but must be done prior to smoking (exception section B part 6). The skinless slab bacon shall be pressed and formed after smoking and cooling.

END ITEM EXAMINATION - TABLE 500E

Item No. 538 - Bacon, Slab, Center Cut (Cured and Smoked), Skinless, Formed. - The smoked and cured slab shall be prepared as specified in Item No. 537, except that the fat back shall be removed by a straight cut dorsal to, but not exceeding 0.5 inch (13 mm), of the outermost curvature of the scribe line. The ventral portion of the belly shall be removed by a straight cut dorsal to the teat line. The belly shall be squared on all edges and with approximately straight and parallel sides and ends. There shall be no area of exposed fat on the face side of the belly that exceeds 4.0 square inches. The skinless slab bacon shall be pressed and formed after smoking and cooling. Maximum thickness of the formed slab shall not exceed 2.25 inches. Minimum thickness of the slab shall not be less than .75 inch (19 mm).

END ITEM EXAMINATION - TABLE 500E

Item No. 538A - Bacon, Sliced, Center Cut (Cured and Smoked).

The slices shall be produced only from skinless slab bacon Item No. 538. The bacon slices shall be approximately uniform in length, ranging from 7 to 9 inches without underfolding. Maximum width of the slices shall not exceed 2.25 inches. Minimum width of the slices shall be not less than .75 inch (19 mm). The surface lean on the face side of the slice (opposite of skin side) shall extend for a combined distance of at least 90% of the length of the slice. Unsliced pieces or slices showing hanger comb marks, product residue, punctured or mutilated sections, cracked slices due to hard or granular fat, or those cut on an appreciable slant or bias, or from small or irregular pieces, or which have

other serious damage shall be excluded. One part slice may be used per package to make exact weight (part slice shall not be considered when determining defects). The individual packages of sliced bacon shall be of the number of slices per pound as specified. (See weight range table).

Chemical analysis - If specified by the purchaser, a chemical analysis of the fat, moisture, and salt content may be requested - (all or any one of the three may be selected for analysis). Unless otherwise specified, the fat content shall not exceed 61 percent, the salt shall not exceed 2.5 percent, and the analytical moisture content may not exceed by more than 3.0 percent the calculated moisture content [78.60 - (0.8 x analytical fat)]. The analytical content shall be determined in accordance with the Official Methods of the Association of Analytical Chemists, at a FSIS approved laboratory designated by the vendor, who shall supply official documentation of the analysis results to the purchaser.

Alternatively, if the purchaser wishes the analytical content to be certified by USDA, AMS, they MUST specify that option in the contract or purchase order.

END ITEM EXAMINATION - TABLE 500M

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED

Packaging options:

A. Individual One pound packages

1. Layed-out packed - Individual slices are placed adjacent to each other on grease and/or heat resistant paper.
2. Shingle packed on grease resistant paper.
3. Stack packed - Has slices packaged on edge in their sequence of slicing on grease resistant paper.

B. Bulk packaged

1. Layed-out packed - Individual slices are placed adjacent to each other on grease and/or heat resistant paper.
2. Shingle packed on grease resistant paper.
3. Stack packed - Has slices packaged on edge in their sequence of slicing on grease resistant paper.

Analytical content options:

- A. Fat
- B. Moisture
- C. Salt

Item No. 539 - Bacon, Sliced (Cured and Smoked), Skinless. - The slices may be produced from any 500 series skinless slab bacon. The bacon slices, as packaged in individual packages, shall be at least reasonably uniform in length, width, and thickness, ranging from 8 to 10 inches in length without underfolding. The surface lean on the face side of the slice (opposite of skin side) shall extend for a combined distance of at least 75% of the length of the slice. Unsliced pieces or slices showing hanger comb marks, product residue, punctured or mutilated sections, bruises, severe muscle separation,

breaks extending more than half the width of the slice, or those cut on an appreciable slant or bias, or which have other serious damage shall be excluded. One part slice may be used per package to make exact weight (part slice shall not be considered when determining defects). The individual packages of sliced bacon shall be of the number of slices per pound as specified. (See weight range table).

Chemical analysis - If specified by the purchaser, a chemical analysis of the fat, moisture, and salt content may be requested - (all or any one of the three may be selected for analysis). Unless otherwise specified, the fat content shall not exceed 61 percent, the salt shall not exceed 2.5 percent, and the analytical moisture content may not exceed by more than 3.0 percent the calculated moisture content $[78.60 - (0.8 \times \text{analytical fat})]$. The analytical content shall be determined in accordance with the Official Methods of the Association of Analytical Chemists, at a FSIS approved laboratory designated by the vendor, who shall supply official documentation of the analysis results to the purchaser.

Alternatively, if the purchaser wishes the analytical content to be certified by USDA, AMS, they **MUST** specify that option in the contract or purchase order. **END ITEM EXAMINATION - TABLE 500M**

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED

Packaging options:

A. Individual One pound packages

1. Layed-out packed - Individual slices are placed adjacent to each other on grease and/or heat resistant paper.
2. Shingle packed on grease resistant paper.
3. Stack packed - Has slices packaged on edge in their sequence of slicing on grease resistant paper.

B. Bulk packaged

1. Layed-out packed - Individual slices are placed adjacent to each other on grease and/or heat resistant paper.
2. Shingle packed on grease resistant paper.
3. Stack packed - Has slices packaged on edge in their sequence of slicing on grease resistant paper.

Analytical content options:

- A. Fat
- B. Moisture
- C. Salt

Item No. 541 - Bacon, Sliced (Cured and Smoked), Ends and Pieces. - The ends and pieces may be obtained from the regular production of sliced bacon. Frayed, shredded, broken, or otherwise damaged slices; small, unsliced pieces, slices showing string or hanger marks; or slices from small or extreme sections and machine scrap pieces are acceptable.

END ITEM EXAMINATION - TABLE 500M

Item No. 545 - Pork Loin (Cured and Smoked). - The cured and smoked pork loin is that portion of a side remaining after removal of the shoulder, ham, belly, skin, and fat

back, leaving a portion of the blade bone with its overlying flesh and at least 2 *sacra*, but no *caudal vertebrae* in the loin. The shoulder and ham shall be separated from the loin by straight cuts reasonably perpendicular to the split surface of backbone. The outer tip of the *subscapularis* shall not extend past the center of the medial ridge of the blade bone. The line of separation of the loin from the belly shall be reasonably straight extending from a point which is ventral to but not more than 3.0 inches from the *longissimus dorsi* on the shoulder end, to a point on the ham end which is ventral to but not more than 0.5 inch (13 mm) from the tenderloin (a slight dorsal curvature is acceptable). Surface fat shall be trimmed to an average depth of 0.25 inch (6 mm) (maximum of 0.5 inch (13 mm) at any one point) or less except in the hip pocket area. The hip pocket area which has no measurable fat requirement is defined as the area contained within 2 parallel lines, 2.0 (51 mm) on either side of the anterior end of the hipbone and related cartilage. Fat in the hipbone area shall be trimmed to the same contour as the rest of the trimmed surface of the loin. The false lean over the blade end shall be exposed lengthwise with the loin for a distance of at least 2.0 inches (51 mm). Lumbar and pelvic fat shall not exceed 0.5 inch in thickness at any one point. Loins with broken ribs and loins that have had more than a slight amount of lean removed from the major loin muscles are not acceptable. The tenderloin shall remain intact. The *diaphragm* and hanging tender shall be removed. The spinal cord groove shall be evident on at least 75% of the vertebrae, and all exposed spinal cord portions shall be removed. END ITEM EXAMINATION - TABLE 500F

Item No. 546 - Pork Loin, Bladeless (Cured and Smoked). - The bladeless (cured and smoked) loin shall conform with the requirements specified for Loin (Cured and Smoked) - Item No. 545, except that the blade bone and related cartilage and the overlying flesh shall be removed and excluded. The loin/shoulder separation shall show a cross section of the *longissimus dorsi* that has a diameter of at least 1.0 inch (25 mm) across. END ITEM EXAMINATION - TABLE 500F

Item No. 547 - Pork Center Loin, 11 Ribs (Cured and Smoked). - This loin is prepared from Item 545. The shoulder end separation shall be made from a point that leaves not more than 11 ribs on the loin. Floating rib(s) which do not show a cross section at the belly are exempt. The ham end shall be removed immediately anterior to the hipbone and related cartilage and shall expose the *gluteus medius*. END ITEM EXAMINATION - TABLE 500F

Item No. 547A - Pork Center Loin (Cured and Smoked), Boneless. - This item is prepared from item 547. The tenderloin, all bones and cartilage shall be removed. On the blade end, the diameter of the exposed *longissimus dorsi* shall be at least 2.0 inches (51 mm). The sirloin shall be removed by cutting immediately anterior to the hipbone cartilage exposing the *gluteus medius*. The belly shall be removed by a cut from a point ventral to, but not more than 3.0 inches (76 mm) from, the *longissimus dorsi* at the blade end to a point on the sirloin end ventral to, but not more than 3.0 inches (76 mm) from the *longissimus dorsi*. The finished product may be encased in artificial casings. Dissolved

clear gelatin may be used to momentarily dip the product to facilitate stuffing in the casing. END ITEM EXAMINATION - TABLE 500G

Item No. 548 - Pork Center Cut Loin, 8 Ribs (Cured and Smoked). - This item is prepared from Item No. 545. The blade and the sirloin portions are removed by straight cuts made approximately perpendicular to the split surface of the backbone and the length of the loin. The sirloin is removed anterior to the hipbone and associated cartilage. The blade portion shall be removed to leave not more than eight (8) ribs present. Floating rib(s) which do not show a cross-section at the belly side are exempt. The belly shall be removed by a straight cut (a slight dorsal curvature is acceptable) from a point that is ventral to, but not more than 4.0 inches (102 mm) from, the *longissimus dorsi* at the blade end to a point on the sirloin end which is ventral to, but not more than 3.0 inches (76 mm) from the *longissimus dorsi*. Surface fat shall be trimmed to not exceed 0.25 inch (6 mm) in depth. Lumbar fat shall be trimmed to not exceed 0.5 inch (13 mm) in depth. The tenderloin shall remain intact. The spinal cord groove shall be evident on at least 75 percent of the vertebrae, and all exposed spinal cord portions shall be removed.

END ITEM EXAMINATION - TABLE 500F

Item No. 548A - Pork Loin, Center Cut, 8 Ribs, Boneless (Cured and Smoked). - This item is prepared from Item No. 548. The tenderloin, all bones and cartilage, shall be removed. On the blade end, the diameter of the exposed *longissimus dorsi* shall be at least 2.0 inches (51 mm) across. The sirloin is removed anterior to the hip bone cartilage and shall expose the *gluteus medius*. The belly shall be removed by a cut ventral to, but not more than 4.0 inches (101 mm) from, the *longissimus dorsi* at the blade end to a point on the sirloin end ventral to, but not more than 3.0 inches (76 mm) from, the *longissimus dorsi*. The finished product may be encased in artificial casings. Dissolved clear gelatin may be used to momentarily dip the product to facilitate stuffing in the casing.

END ITEM EXAMINATION - TABLE 500G

Item No. 550 - Canadian Style Bacon (Cured and Smoked), Unsliced. - The Canadian back includes the *longissimus dorsi*, *spinalis dorsi*, *multifidus dorsi*, *complexus*, and *gluteus medius* muscles of Item No. 545 after the ham end had been removed by a straight cut approximately perpendicular to the split surface of the back bone and to the length of the loin through a point anterior to the hip bone cartilage. The blade end shall show a cross sectional cut of the loin with the *longissimus dorsi* having a diameter of at least 2.0 inches (58 mm) or more. The shoulder and sirloin ends shall be removed by straight cuts approximately parallel to each other. All bones, cartilage, and surface fat shall be removed. The finished product may be encased in artificial casings. Dissolved clear gelatin may be used to momentarily dip the product to facilitate stuffing in the casing.

END ITEM EXAMINATION - TABLE 500G

Item No. 550A - Canadian Style Bacon (Cured and Smoked), Sliced. - Sliced Canadian style bacon shall be produced from the cured and smoked Canadian back Item 550. The slices shall be uniform in thickness and diameter. Thickness may range from 7-9 slices per linear inch. Slicing shall be at approximate right angles to the major muscle. Insofar as practical, the slices shall be maintained in conventional layers

in the same order as produced. Slices showing string or hanger marks; slices from small or irregular end sections; mutilated slices, machine scrap pieces, or other product residue shall not be included. END ITEM EXAMINATION - TABLE 500M

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED

Packaging options: A. Individual 1 lb. packages
B. Bulk packed (weight as specified by purchaser)

Item No. 555 - Jowl Butts, Cellar Trim (Cured). - Cured jowl butts shall be of standard cellar trim and reasonably square with ragged ends smoothly removed and excluded. The product shall not exude more than a slight amount moisture. Individual pieces of the product delivered dry salted shall be coated with clear granulated salt; however, loose and encrusted salt shall be removed and excluded. The finished product shall not exhibit evidence of over or undercuring, or of improper storage. END ITEM EXAMINATION - TABLE 500K

Item No. 556 - Jowl Squares (Cured and Smoked). - Jowl squares shall be reasonably rectangular in shape and at least reasonably squared on the sides and ends, being reasonably symmetrical and smooth on all surfaces. They shall be faced by close removal, before smoking, of surface glandular and loose tissue, and bloody discoloration. END ITEM EXAMINATION - TABLE 500K

Item No 558 - Spareribs, Fully-Cooked. - Spareribs shall contain at least 11 ribs. The fully cooked ribs may include portions of the *costal cartilage* with or without portions of the breastbone and *diaphragm*. The membranous portion of the *diaphragm* shall be removed close to the lean. Any portion of the *diaphragm* not firmly attached shall be removed close to the lean. The lean shall not extend more than 2.0 inches (51 mm) past the curvature of the last rib and *costal cartilage*. Heart fat on the inside surface of the ribs shall not exceed 0.25 inch (6 mm) average depth. Leaf fat over the *diaphragm and transverse abdominis* shall be trimmed practically free. END ITEM EXAMINATION - TABLE 500H

Item No. 559 - Spareribs (Cured and Smoked). - The spareribs shall conform with the requirements specified for Spareribs Fully-Cooked - Item No. 558, except that the spareribs shall be cured and smoked. END ITEM EXAMINATION - TABLE 500H

Item No. 559A - Pork Spareribs Fully-Cooked, St. Louis Style. - The spareribs shall be as described in Item No. 558 except the *sternum* and the ventral portion of the *costal cartilage* shall be removed along with the flank portion. The breast shall be removed at a point that is dorsal to the curvature of the *costal cartilage*. When specified, the *diaphragm* shall be removed, and the spareribs shall be separated into two

approximate equal portions by a lengthwise cut. END ITEM EXAMINATION - TABLE 500H

Item No. 559B - Pork Spareribs (Cured and Smoked), St. Louis Style. - The spareribs St. Louis Style (cured and smoked) shall conform to the requirements specified for St. Louis Style Spareribs Fully-cooked - Item No. 559A, except that the spareribs shall be cured and smoked. END ITEM EXAMINATION - TABLE 500H

Item No. 560 - Hocks, Ham (Cured and Smoked). - Ham hocks shall be separated from the hind foot by a cut at or above the hock joint toward the ham and shall be at least 2.0 inches (51 mm) in length. END ITEM EXAMINATION - TABLE 500I

Item No. 561 - Hocks, Shoulder (Cured and Smoked). - The shoulder hocks (cured and smoked) are prepared from shoulders or picnics. They shall be cut through or above the knee and shall be at least 2 inches (51mm) in length. To differentiate from ham hocks, shoulder hocks will not exhibit the *Achilles tendon*. END ITEM EXAMINATION - TABLE 500I

Item No. 562 - Clear Fat Back (Cured). - The cured clear fat backs shall be produced from the fatty portion of the back after the removal of the loin. They shall be relatively short and thick, and the thickness shall be relatively uniform throughout. All edges shall be reasonably squared. The cured product shall be drained and reasonably free from loose and encrusted salt. END ITEM EXAMINATION - TABLE 500K

Item No. 563 - Feet, Front (Cured). - Feet are removed from the shoulder at least slightly above the knee joint. They shall be practically free of hair and hair roots. END ITEM EXAMINATION - TABLE 500I

PORTION CUT ITEMS

Item No. 1513 - Ham Patties (Cured), Fully-Cooked. - This item is moderately coarse textured and is prepared ham and/or ham trimmings (excluding shank in excess of FSIS requirements) and shall be fully-cooked. The ham patties shall be free from bones, cartilage, skin, heavy connective tissue and lymph glands. Product shall be initially examined prior to grinding in accordance with the Quality Assurance Provisions defect Table 500N. The boneless ham shall be ground at least once through a plate having holes not larger than 1.0 inch (25 mm) in diameter. Alternatively, boneless pork may be chopped or machine cut by any method provided the texture and appearance of the product after final grinding is typical of ground ham prepared by grinding only. Unless otherwise specified, final grind shall be through a plate having holes 3/16 inch (5 mm) in diameter. The ground ham may be thoroughly blended at least once prior to final grinding. However, the ground ham shall not be mixed after final grinding. Initial reduction in size, blending, final grinding and packaging shall be a continuous sequence.

Fat Content - Unless otherwise specified, the fat content shall not exceed 15 percent. However, the purchaser may specify a fat content range from 10 to 30 percent and may specify discount ranges. The fat content shall be determined at a FSIS approved and certified laboratory designated by the vendor, who shall supply official documentation of the fat analysis results to the purchaser. Alternatively, if the purchaser wishes the fat content to be certified by USDA, AMS, they MUST specify that option in the contract or purchase order.

PFF percentages shall meet or exceed FSIS, MPIO regulations applicable to each style of product being produced. Failure of any analyzed sample to meet or exceed the FSIS, MPIO required PFF value shall cause rejection of the involved lot. PFF percentages shall be determined at a FSIS approved and certified laboratory designated by the vendor, who shall supply official documentation of the PFF percentage results to the purchaser of each lot produced. Alternatively, the purchaser may specify in the contract or purchase order that the PFF values are to be certified by USDA, AMS.

The ham patties shall be mechanically formed into portion sizes as specified by the purchaser. Alternatively the product may be stuffed into casings and sliced. To facilitate slicing, the ham may be frozen and/or tempered one time only prior to slicing. The examination for condition shall be done prior to freezing or slicing.

EXAMINATION OF PRODUCT PRIOR TO GRINDING - TABLE 500N
END ITEM EXAMINATION - TABLE 500L

Item No. 1531 - Ham Steaks (Cured and Smoked), Boneless. - This item may be prepared from Item No. 505, 508 or 509. The ham steaks shall be free from all skin, bruises, blood clots, lymph glands, bone, cartilage, and surface fat. Steaks shall be sliced from hams perpendicular to the long axis of the ham. Portions shall be sliced as specified. Slices shall be approximately round and exhibit a cured and smoked appearance. The lean meat shall possess a fine, smooth texture, with a uniform and bright color (a slightly two toned or iridescent color permissible). Excessive trimming of the ham steak for any reason is prohibited.
END ITEM EXAMINATION - TABLE 500L

Item No. 1545 - Pork Loin Chops (Cured and Smoked). - The chops are prepared by slicing Item No. 545. Chops shall be cut in full slices in a straight line reasonably perpendicular to the outer surface and at an approximate right angle to the length of the cut being sliced or portioned. The entire cut shall be sliced from end to end, and all suitable portions shall be included. Chops shall be practically free from: (1) fractures, (2) tag ends, and (3) knife scores. Individual chops shall remain intact when suspended 0.5 inch (13 mm) from the outer edge.
END ITEM EXAMINATION - TABLE 500L

Item No. 1548 - Pork Chops, Boneless, Center Cut (Cured and Smoked). - The chops are prepared by slicing Item Nos. 547A or 548A. Chops shall be cut in full slices in a

straight line reasonably perpendicular to the outer surface and at an approximate right angle to the length of the loin being portioned. The entire cut shall be sliced from end to end, and all suitable portions shall be included. Chops shall be practically free from fractures, tag ends, knife scores, bones, cartilage, bruises, and blood clots. Surface fat, measured along the outer edge of the chop shall not exceed 0.25 inch (6 mm) maximum depth at any point. Both the surface and seam fat (fat between adjacent muscles within the cut) (combined) shall not exceed 25% of the total cut surface area on either side of the chop. Individual chops shall remain intact when suspended 0.5 inch (13 mm) from the outer edge.

END ITEM EXAMINATION - TABLE 500L

Item No. 1596 - Pork Patty, Precooked. -

Material - Ground pork may be prepared from any portion of the carcass that will meet the end item requirements. The meat shall be free from bones, cartilage, seedy mammary tissue, heavy exposed tendons, heavy connective tissue, *prefemoral*, *popliteal*, *prescapular*, and other exposed lymph glands. The tendinous ends of shanks shall be removed so that a cross-sectional cut exposes at least 75 percent lean. Product shall be initially examined prior to grinding in accordance with the Quality Assurance Provisions defect Table 500N. At the option of the purchaser, holding of previously certified pork in the frozen state may be permitted provided that the pork is frozen to 0° F within 72 hours after initial acceptance in accordance with IMPS General Requirements.

Processing - The boneless meat shall be coarse ground one time through a plate having holes not larger than 1.0 inch (25 mm) or smaller than 0.5 inch (13 mm) in diameter, and at the option of the purchaser the analytical fat content shall be not more than 24% nor less than 14%. The fat content of the coarse ground pork shall be determined at a FSIS approved laboratory designated by the vendor, who shall supply official documentation of the fat analysis results to the purchaser. Alternatively, if the purchaser wishes the fat content to be certified by USDA, AMS, they must specify that option in the contract or purchase order. When fat content is certified by the USDA, the purchaser may specify the fat content analysis to be determined on a composite analysis or average analysis (as defined within the IMPS QUALITY ASSURANCE PROVISIONS). If no preference is stated by the purchaser, an average analysis shall be performed.

Spices may be added at the option of the purchaser and shall be evenly and thoroughly mixed with the coarse ground pork and ground one (1) final time through a plate having holes 3/16 inch in diameter. The ground pork blend shall not be mixed after the final grind. The ground mixture shall then be mechanically formed into a round patty. Alternatively the product may be stuffed into casings, cooked and sliced. To facilitate slicing, the item may be frozen and/or tempered one time only prior to slicing. The examination for condition shall be done prior to freezing or slicing. The patties shall be fully cooked in accordance with FSIS, MPIO regulations, and shall also be of a size which will meet the weight range specified by the purchaser after the shrink of cooking.

The portion weight tolerance for this particular item shall be determined on an average of 10 patties. The declared patty weight shall be multiplied by 10. The value for 10 declared patty weights shall be multiplied by 0.05 (5%). Five percent of the value of 10 declared patty weights shall be subtracted to provide for the lower limit and added to provide for the maximum limit (i.e. if declared patty weight is 2.5 oz. then the acceptable range for 10 patties will be 23.75 oz. to 26.25 oz.)

The patties shall be placed in a blast freezer within 4 hours after completion of the cooking and frozen to 0° F or lower within 24 hours from the time they are placed into the freezer or following final certification. Patties may be individually quick frozen prior to placement in the freezer. The entire process, from the beginning of the grinding of the boneless pork, to the placement of the cooked patty in the freezer, shall be a continuous operation.

EXAMINATION OF PRODUCT PRIOR TO GRINDING - TABLE 500N

END ITEM EXAMINATION - TABLE 500L

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