

***I*NSTITUTIONAL *M*EAT *P*URCHASE *S*PECIFICATIONS**

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

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Institutional Meat Purchase Specifications

Cured, Cured and Smoked, and Fully-Cooked Pork Products - Series 500

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1.1 Introduction

1.1 IMPS Documents

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 11 documents:

General Requirements (GR)	
Quality Assurance Provisions (QAP)	
Fresh Beef	Series 100
Fresh Lamb	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

Variety Meats and By-Products	Series 700
Sausage Products	Series 800
Fresh Goat	Series 11

1.2 Contact Information

These specifications are recommended for use by any meat product procuring activity.

For assurance that procured items comply with these detailed requirements, AMS, through its Livestock and Poultry (LP) Program, provides a voluntary meat certification service and a process verification program. For labeling purposes, only producers who have meat products certified according to the IMPS or operate under an approved IMPS Process Verified Program may use the letters "IMPS" on the product label.

Purchasers desiring these services should contact:

USDA, AMS, LP Program
1400 Independence Ave, SW, Room 3932, Stop 0258
Washington, DC 20250
Phone: (202) 720-5705

2.0 IMPS Ordering Checklist

2.1 Checklist Elements

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 3.0 – Ordering Data to be Specified by the Purchaser**.

Item Number

Special instructions
Purchaser Specified Option (PSO)
Added ingredients

Grade and Special Requirements

State of Refrigeration (See IMPS GENERAL REQUIREMENTS (GR).)

Chilled
Frozen

Fat Limitations

Portion Cut Weight, Thickness, and Shape Weight Range

Netting & Tying

Packaging & Packing (See IMPS GR.)

Quality Assurance (See IMPS QUALITY ASSURANCE PROVISIONS (QAP).)

Method of examination

Acceptable Quality Levels (AQLs)

Certification - (See IMPS GR and QAP.)

3.0 Ordering Data to be Specified by the Purchaser

3.1 Item Number, PSO's & Special Instructions

The purchaser must specify: (1) IMPS item number and product name to be purchased, and if applicable, (2) PSOs, (3) added ingredients, applicable options, modifications, and special instructions to the requirements of the IMPS.

3.1.1 Abbreviations

In conjunction with other markings that may be required in the GR and by the Food Safety and Inspection Service (FSIS), the IMPS item number, "Pork", and the product name listed above must be used for marking of shipping containers. Abbreviation of the product name is recommended. Abbreviations, when used, must be as follows:

Bladeless - Bldls	Fresh – Fr	Short Shank – Sht Shnk
Bone in – Bn-in	Frozen – Frz	Shoulder – Shld
Boned, Rolled & Tied - BRT	Ground - Grnd	Skinned – Sknd
Boneless - Bnls	Not to exceed – NTE	Smoked - Smk
Cellar Trimmed - CT	Partially - Part	Special - Sp
Center-Cut – Cntr Cut	Picnic – Pix	Trimmed – Trmd
Chop – Chp	Portion – Portn	

The product names and abbreviations listed in this series have been reviewed and approved by USDA; FSIS; Office of Policy and Program Development (OPPD); Labeling and Program Delivery Staff, Washington D.C.

3.1.2 Added Ingredients

The use of ingredients, method of addition, and product labeling must comply with FSIS Regulations and Policies.

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, must be selected.

STYLE	LABELING REQUIREMENT – QUALIFYING STATEMENT
A	IMPS Name of Item
B	(IMPS Name of Item) with Natural Juices
C	(IMPS Name of Item) Water Added
D	(IMPS Name of Item) and Water Product – X% of Weight is Added Ingredients
E	(IMPS Name of Item) Water and Isolated Soy Protein Added
F	(IMPS Name of Item) 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 basis would be inserted as the X value. Responsibility for the verification of this X value must be made by FSIS personnel.

Contractors producing items listed in TABLE II that have no minimum PFF value must 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 must be labeled (per IMPS GR) 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)

The purchaser and/or AMS agent maintain the right to verify the amounts of added ingredients using approved testing methods.

3.2 State of Refrigeration

Purchaser must specify the state of refrigeration (chilled or frozen) for delivery of product. (See IMPS GR.)

3.3 Fat Limitations

Purchaser must specify IMPS item number, product name, and fat content or thickness to be purchased. The fat thickness guidelines are intended as guidelines.

3.3.1 Fat Content Verification

The fat content must be specified by the purchaser and verified by one or any combination of the following PSOs. If not specified, the fat content must be verified with PSO #2 requirements.

Option No.	Fat Content
1	Fat content must be declared on the product label along with a nutrition facts panel in accordance with FSIS regulations
2	Contractor must submit documentation of fat analysis to purchaser
3	Fat content certified by AMS (see QAP)
4	Samples selected by AMS and sent to purchaser designated laboratory

3.4 Portion Cut Weight, Thickness, & Shape

3.4.1 Weight & Thickness

The purchaser must specify the portion weight and/or thickness desired. For assistance in specifying weight, see weight range tables. Unless other portion weight and/or thickness tolerances are specified by the purchaser, the following tables must be used. 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)

*Thickness measurements are not applicable within 1/4-inch (6 mm) of the edge. Also, value listed under thickness uniformity is the maximum allowable difference between the thinnest and thickest measurement of an individual chop or patty.

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

^See detailed Item description for Item 1596.

3.4.2 Shape

Unless otherwise specified, the shape of whole muscle portion cuts must resemble the approximate shape relative to the cut of origin. Unless otherwise specified, patties must be round.

3.5 Weight Range

Purchaser must specify IMPS item number, product name, and weight range to be purchased. The following weight ranges are intended as guidelines.

Carcass weights are not necessarily related to the weight of cuts within their respective weight range. Other weights or ranges may be specified.

Weights for cured pork products reflect their drained weight. Draining must be

accomplished on a conventional rack or shelf; and, at the time of weighing, the product must be practically free of dripping pickle.

Unless otherwise specified by the purchaser, canned ham items and non-smoked items cooked in plastic cooking bags, in addition to meeting the required Protein Fat Free (PFF) percentages, must also meet the following drained weight requirements.

Pullman cans – Drained weight of ham must be not less than 97% of net weight.

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

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

Foodservice Items					
Item No.	Product Name	Weight Ranges (pounds)			Page #
		A	B	C	
500	Ham, Short Shank (Cured)	10-14	14-17	17-20	18
501	Ham, Short Shank (Cured and Smoked)	10-14	14-17	17-20	19
502	Ham, Short Shank, Skinned (Cured)	10-14	14-17	17-20	19
503	Ham, Short Shank, Skinned (Cured and Smoked), Fully-Cooked	10-14	14-17	17-20	19
504	Ham, Skinless, Partially Boned (Cured and Smoked)	8-10	10-12	12-14	19
505	Ham, Boneless (Cured and Smoked), Fully-Cooked	8-10	10-12	12-14	20
505A	Ham, Boneless, Tied (Cured and Smoked, Fully-Cooked	8-10	10-12	12-14	20
508	Ham, Boiled, Boneless (Cured), Fully-Cooked	8-10	10-12	12-14	20
509	Ham, Boneless (Cured and Smoked), Fully-Cooked, Special	5-11	11-16		21
510	Ham, Honey Cured (Smoked), Partially Boned, Spiral Cut	8-10	10-12	12-14	21
511	Ham, Chunked and Formed (Cured), Fully-Cooked	8-10	10-12	12-14	21
511A	Ham, Chunked and Formed (Cured and Smoked), Fully-Cooked	8-10	10-12	12-14	22
512	Ham, Diced (Cured)	As Specified by Purchaser			22
512A	Ham, Diced (Cured and Smoked)				22
514	Pork, Diced (Cured)				23
515	Shoulder (Cured)	8-12	12-16	16-20	24

Foodservice Items					
Item No.	Product Name	Weight Ranges (pounds)			Page #
		A	B	C	
516	Shoulder (Cured and Smoked)	8-12	12-16	16-20	24
517	Shoulder, Skinned (Cured)	8-12	12-16	16-20	25
518	Shoulder, Skinned (Cured and Smoked)	8-12	12-16	16-20	25
525	Shoulder Picnic (Cured)	4-6	6-8	8-12	25
526	Shoulder Picnic (Cured and Smoked)	4-6	6-8	8-12	25
527	Shoulder, Picnic (Cured and Smoked), Boneless, Tied	6-10	8-10	10-12	26
530	Shoulder, Butt, Cellar Trimmed, Boneless (Cured and Smoked)	1.5-3	3-5	5-8	26
531	Boston Butt, Boneless (Cured and Smoked), Special	2-4	4-6	6-8	26
535*	Belly, Skin-On (Cured)	10-12	12-14	14-16	27
536*	Bacon, Slab (Cured and Smoked), Skin-On, Formed	10-12	12-14	14-16	27
537*	Belly, Slab (Cured and Smoked) Skinless, Formed	10-12	12-14	14-16	27
538*	Bacon, Slab, Center-Cut (Cured and Smoked), Skinless, Formed	8-10	10-12	12-14	27
538A*	Bacon, Sliced, Center-Cut (Cured and Smoked)	Number of Slices per Pound 12-14; 14-18; 18-22; 22-26; 26-30; 38-32; or as Specified			28
539*	Bacon, Sliced (Cured and Smoked) Skinless				29
540*	Bacon, Sliced Cured and Smoked), Fully-Cooked, Skinless				30
541*	Bacon, Sliced (Cured and Smoked), Ends and Pieces	5 and 10 Pound Containers or as Specified			31
545	Loin (Cured and Smoked)	10-14	14-17	17-20	31
546	Loin, Bladeless (Cured and Smoked)	10-14	14-17	17-20	31
547	Center Loin, 11 Ribs (Cured and Smoked)	5-7	7-10	10-12	32
547A	Center Loin, Boneless (Cured and Smoked)	3-5	5-7	7-10	32
548	Center-Cut Loin, 8 Ribs (Cured and Smoked)	4-6	6-8	8-11	32
548A	Loin, Center-Cut, Boneless (Cured and Smoked)	2-4	4-6	6-10	32
550	Canadian Style Bacon (Cured and Smoked), Unsliced	3-4	4-6	5-6	33
550A	Canadian Style Bacon (Cured and Smoked), Sliced	5 and 10 Pound Containers or as Specified			33
555*	Jowl Butts, Cellar Trim (Cured)	1-2.5	2.5-4		33
556*	Jowl Squares (Cured and Smoked)	0.8-2	2-3		34
558*	Spareribs, Fully-Cooked	1.5-3	3-5	5-up	34
559*	Spareribs (Cured and Smoked)	1.5-3	3-5	5-up	34
559A*	Spareribs, Fully-Cooked, St. Louis Style	1.5-2	2-3	3-up	34
559B*	Spareribs (Cured and Smoked), St. Louis Style	1.5-2	2-3	3-up	34

Foodservice Items					
Item No.	Product Name	Weight Ranges (pounds)			Page #
		A	B	C	
560*	Hocks, Ham (Cured and Smoked)	0.5-1	1-1.5	1.5-2.5	35
561*	Hocks, Shoulder (Cured and Smoked)	0.5-1	1-1.5	1.5-2.5	35
562*	Clear Fatback (Cured)	6-8	8-10	10-12	35
563*	Feet, Front (Cured)	0.8-1.5			35
Portion Cuts					
1513	Ham Patties (Cured), Fully-Cooked	3-5 Ounce	As Specified by Purchaser		35
1531	Ham Steaks (Cured and Smoked), Boneless	5-12 Ounce	As Specified by Purchaser		36
1545	Loin Chops (Cured and Smoked)	3-8 Ounce	As Specified by Purchaser		36
1547	Loin Chops, Center Cut (Cured and Smoked)	3-8 Ounce	As Specified by Purchaser		36
1548	Loin Chops, Boneless, Center Cut (Cured and Smoked)	3-8 Ounce	As Specified by Purchaser		37
1596*	Pork Patty, Pre-Cooked	3-8 Ounce	As Specified by Purchaser		37

*Style option not applicable to this item

3.6 Netting & Tying

Many of the item descriptions require roasts to be netted or tied to facilitate institutional style cookery methods. The purchaser may specify the netting and tying requirements for such items as needed.

When tying is required, stretchable netting (or any other equivalent material) must be used to make roasts firm and compact. Unless otherwise specified, roasts must be netted so that all portions are held intact, without any portions protruding through the ends of the netting. Conversely, excess netting at the portion ends must be no more than 2.0 inches (5.0 cm) in length. Alternatively, roasts may be string tied by loops of twine uniformly spaced at no more than approximately 2.0 inch (5.0 cm) intervals along the items length). When tying does not make roasts firm and compact, lengthwise tying may be used. For net weight verification, netting and tying material must be included along with packaging materials when determining tare weight.

3.7 Packaging & Packing

Purchaser must specify packaging and packing for delivery of product. (See IMPS GR.)

3.8 Quality Assurance

The purchaser may consult the IMPS QAP for options regarding production examination and lot acceptance criteria in terms of acceptable AQLs.

4.0 USDA Certification & Verification

4.1 Contact Information

When requested, the purchaser must specify within a contract or purchase order that product must be certified or that the producer is operating under an approved IMPS Process Verified Program by the USDA, AMS, LP Program, SSD. The IMPS QAP,

<https://www.ams.usda.gov/sites/default/files/media/QualityAssuranceProvisionsIMPS.pdf>

will be used to determine compliance. Purchasers desiring these services should contact:

USDA, AMS, LP Program
1400 Independence Ave, SW, Room 3953, Stop 0258
Washington, DC 20250
Phone: (202) 720-5705

5.0 Material Requirements

All products offered must comply with the following material requirements and the individual item descriptions. For certification, product must be evaluated in accordance with the IMPS QAP.

6.0 Quality

6.1 Excellent Condition

Hams, loins, shoulders, shoulder picnics, Boston butts, and pork side (belly) must 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 must be moderately uniform in thickness and moderately long in relation to their width.

Cuts must be at least moderately thick and plump with no more than a small amount of intermuscular (seam) fat. The lean meat must be firm and have a bright reasonably uniform cured color (slightly two-toned is permissible). The

meat must 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 that 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.

6.2 Lean Quality

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

6.2.1 PFF Requirement

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. For certain products to meet the labeling regulations established by FSIS, the product must comply with the minimum PFF percentage listed in TABLE II.

Unless otherwise specified in the purchaser's contract, the producer/vendor must 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 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 minimum required PFF percentages listed in TABLE II must cause rejection of the involved lot. See the IMPS QAP for detailed sampling procedures.

Contractors producing items listed below that have no minimum PFF value are not be required to provide laboratory analysis/ verification of the PFF value to the purchaser. This type of product must 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 must be made by FSIS personnel.

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

The USDA, AMS, LP Program, QAD must only certify PFF values when specifically designated to do so in the purchaser's contract or purchase order.

Index of Products and Minimum PFF Percentages	
Cooked Ham, Cooked Loin	20.5
Cooked Ham, Cooked Loin (with natural juices)	18.5
Cooked Ham, Cooked Loin (water added)	17.0
Cooked Ham, Cooked Loin (and water product)	< 17.0
Cooked Shoulder, Picnic	20.0
Cooked Shoulder, Picnic (with natural juices)	18.0
Cooked Shoulder, Picnic (water added)	16.5
Cooked Shoulder, Picnic (and water product)	< 16.5
Uncooked Cured Ham, or Loin	18.0
Uncooked Cured Ham, or Loin (and water product)	< 18.0
Uncooked Cured Shoulder, Picnic	17.5
Uncooked Cured Shoulder, Picnic (and water product)	< 17.5
Ham Patties, Cured	19.5
Ham Patties, Cured (with natural juices)	17.5
Ham Patties, Cured (water added)	16.0
Ham Patties, Cured (and water product)	< 16.0

6.3 Workmanship

The cutting, trimming, and boning of cuts must be accomplished with sufficient care to allow each cut to retain its identity and to avoid objectionable scores in the lean. Ragged edges must be removed close to the lean surfaces. Except for cuts that are separated through natural seams, all cut surfaces must form approximate right angles with the skin surface. With the exception of specifically defined cut separations, no more than a slight amount of lean, fat, or bone must be removed or included from an adjacent cut.

Chops must 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 must be sliced from end to end, and all suitable portions must be included. Portion cut items must be practically free of: (1) fractures, (2) tag ends, and (3) knife scores. Individual chops must remain intact when suspended ½-inch (13 mm) from the outer edge.

Unless otherwise specified, all boneless cuts must be completely 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 that have been excessively trimmed to meet specified weights or 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

6.4 Fat Trimming

Trimming of external fat must 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 fat limitations are: (1) maximum fat thickness at any one point and (2) average fat thickness. Fat thickness requirements may apply to surface fat (external and/or exterior fat in relationship to the item) and seam fat (fat between adjacent muscles within an item) as specified by the purchaser or within the detailed item description.

Maximum Average Fat Thickness	Maximum Fat Thickness at Any One Point
¼-inch (6 mm)	½-inch (13 mm)
Practically free (75% lean exposed)	¼-inch (6mm)

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

6.4.1 Peeled/Denuded

The term "peeled" implies surface fat and muscle separation through natural seams so that the resulting cut's seamed surface ("silver" or "blue" tissue) is exposed with remaining "flake" fat NTE 1.0 inch (25 mm) in the longest dimension and/or 1/8-inch (3 mm) in depth at any point. The term "denuded" implies all surface fat is removed so that the resulting cut's seamed surface ("silver" or "blue tissue") is exposed with remaining "flake" fat NTE 1.0 inch (25 mm) in any dimension and/or 1/8-inch (3 mm) in depth at any point.

6.4.2 Peeled/Denuded, Surface Membrane Removed

Peeled/denuded, surface membrane removed requires the surface membrane ("silver" or "blue" tissue) to be removed (skinned); the resulting cut surface must expose at least 90 percent lean with remaining "flake" fat NTE 1/8-inch (3 mm) in depth.

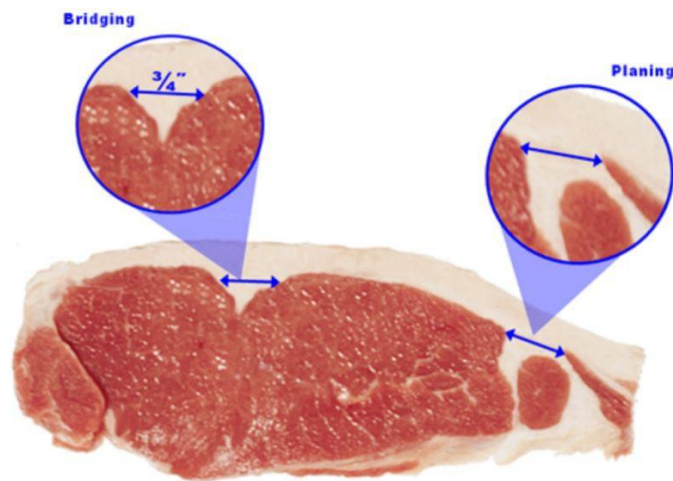
6.4.3 Cuts & Roast Items

For cuts and roast items, the maximum fat thickness at any one point is evaluated by visually determining the area of a cut that has the most fat thickness and measure the thickness (depth) at this point. The average fat thickness is evaluated by visually determining the areas of surface fat and taking multiple measurements in these areas only. The average must be determined by evaluating the amount of surface area that each thickness represents (e.g., if one-third of the fat surface was 0.2 inch in depth, one-third was 0.3 inch in depth, and one-third was 0.4 inch in depth, then the average would be 0.3 inch).

The actual measurements of fat are made on the edges of the cut and by probing or scoring the overlying surface fat as necessary in a manner that reveals the actual fat thickness and accounts for any natural depression or seam that could affect the measurement.

6.4.4 Bridging & Planing

When a natural depression occurs in a muscle, only the fat above the portion of the depression that is more than 3/4-inch (19 mm) in width is considered (this method is known as "bridging"). When a seam of fat occurs between adjacent muscles only the fat above the level of the involved muscles is measured (this method is known as "planing"). However, when fat limitations for Peeled/Denuded or Peeled/Denuded, Surface Membrane Removed are specified, the bridging method must be used for evaluating fat above a natural



depression in a muscle and fat occurring between adjacent muscles.

6.4.5 Seam Fat

For the purpose of measuring seam fat, when specified, the maximum fat thickness at any one point is evaluated by visually determining the areas of fat between layers of lean (muscles) on any side of the cut that have the thickest (widest) deposits of fat and measuring the width in these areas. The average fat thickness is evaluated by visually determining the various areas of seam fat and taking multiple measurements in these areas. The average must be determined by evaluating the areas that each thickness (width) represents.

However, when fat limitations for Peeled/Denuded or Peeled/Denuded, Surface Membrane Removed are specified, the bridging method must be used for evaluating surface fat above a natural depression in a muscle and fat occurring between adjacent muscles.

6.5 Objectionable Materials

All pork must be free of organ tissue, heavy connective tissue, significant glandular tissue, spinal cord, and foreign materials. All pork must be free of skin unless specified in the foodservice cut descriptions below. Boneless pork must be free of bones and cartilages.

6.6 Curing & Thermal Processing

FSIS regulates the amount of nitrite allowed in cured pork products. In accordance with 9 CFR 424.21(c) 200 ppm of nitrite or less is allowed in cured pork products other than bacon. In accordance with 9 CFR 424.22(b) 120 ppm of nitrite or less is allowed in injected and immersion-cured bacon. Additionally,

cured pork products must be produced in accordance with 9 CFR 319.104-107 regarding raw materials and finished product weights.

Products that are fully-cooked must be produced in accordance with 9 CFR 431.3 for thermal processing.

7.0 Cut Descriptions

7.1 Myology

A reference for identification of muscles is the University of Nebraska's "Porcine Myology & Muscle Profiling" website (<http://porcine.unl.edu>) produced by the National Pork Board (<http://pork.org>) on behalf of the Pork Checkoff Program. Information regarding muscles in specific foodservice cuts can be found in IMPS Fresh Pork Series 400.

7.2 Foodservice Cut Descriptions

Ham items may be prepared from pork leg in the 401A, 402A, and 402C series or any preceding like Item No.

Item No. 500 - Ham, Short Shank (Cured). – The ham, short shank 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 (3.8 cm) from the anterior edge of the aitch bone. The foot must be removed at or slightly above the hock joint. The tail, vertebrae, flank muscle (*M.rectus femoris*), *M. cutaneous trunci*, prefemoral lymph gland, and any exposed lymph gland must be removed. The skin and collar fat over the inside muscle (*M. semimembranosus*) must 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 of the quadriceps group must be removed and fat overlying the quadriceps group and pelvic area must be removed close to the lean. Unless otherwise specified by the purchaser, the fat thickness beneath the ham face measured at the skin edge directly under the bone must not exceed that indicated in the following schedule. Purchaser to specify packaging specifications. This product must conform to applicable regulatory requirements for curing.

Weight Range	Maximum Fat Thickness
17-20 pounds (7.7-9.1 kg)	1½ inches (38 mm)
20-28 pounds (9.1-12.7 kg)	1¾ inches (44 mm)
28 pounds (12.7 kg) - up	2 inches (50 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 must be smoked. This product must conform to applicable regulatory requirements for curing.

Item No. 502 - Ham, Short Shank, Skinned (Cured). – The skinned short shank ham must conform with the requirements specified for a Ham, Short Shank, (Cured) – Item 500, except that the ham must have a well-rounded skin collar in which the skin is removed at or posterior to the stifle joint on a line that is parallel with the loin-ham separation. Remaining fat on the skinned surface shall be no less than 1.5 inches (38 mm) from the edge of the skin collar and must not exceed an average depth of 0.25 inch (6 mm) with a maximum depth of 0.5 inch (13 mm) at any point. Fat along the butt end must be neatly beveled to meet the lean. This product must conform to applicable regulatory requirements for curing.

Item No. 503 – Ham, Short Shank, Skinned (Cured and Smoked), Fully-Cooked. – The skinned (cured and smoked), fully-cooked ham must conform with the requirements for Ham, Short Shank, Skinned (cured) Item No. 502, except that in addition to curing, the ham must be smoked and cooked using a dry-heat method unless otherwise specified. 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 must be handled as necessary to remove rendered surface fat and extraneous matter. After cooking, the fully cooked ham must be properly chilled (28°F to 40°F) prior to packaging which is to be specified by the purchaser. This product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 504 – Ham, Skinless, Partially Boned (Cured and Smoked). – The skinless, partially boned ham (cured and smoked) must conform with the requirements specified for Ham, Short Shank (Cured and Smoked) – Item No. 501, except that the ham must be made completely skinless and the shank must 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) must 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 aitch bone and overlying flesh and shank bones must be removed without undue scoring or other damage to the ham, leaving the femur bone intact in the ham. The ham must be encased in an artificial casing, producing a smooth, plump, elongated, oval-shaped, skinless, partially boned, cured and smoked ham. This product must conform to applicable regulatory requirements for curing.

Item No. 505 – Ham, Boneless (Cured and Smoked), Fully-Cooked. – The skinless, completely boneless (cured and smoked) fully-cooked whole muscle ham must be free of exposed lymph glands, the popliteal lymph gland, and exposed, heavy (opaque) connective tissue. The femur bone must 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) must be removed by a straight cut made at a right angle to the shank. Naturally attached shank meat may be included and must be folded into the femur bone cavity as a plug. The ham must be fully cooked using a dry-heat method unless otherwise specified. All surface fat in excess of 0.25-inch (6 mm) depth at any point must be removed. The prepared cured ham must 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 must 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 must 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). This product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 505A – Ham, Boneless, Tied (Cured and Smoked), Fully-Cooked. – This ham is the same as Ham, Skinless, Boneless (Cured and Smoked) – Item No. 505, except that the ham must not be encased in an artificial casing. The boneless ham must be netted or string tied. This product must conform to applicable regulatory requirements for curing and thermal processing.

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 must not exceed FSIS regulations. The finished product may be Pullman- or pear-shaped, 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 must be free from holes, and the exterior of the encased ham must be free from gelatinous material, rendered fat, extraneous matter, and mechanical fasteners. If canning is specified, the cans must 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 must be so noted in the labeling nomenclature. This product must conform to applicable regulatory requirements for curing and thermal processing.

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED		
<u>Type</u>	A.	Canned (if selected must be referenced in label)
	B.	Polyethylene plastic bag style container
<u>Shape</u>	A.	Pear-shaped
	B.	Pullman-shaped
<u>Flavoring</u>	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 *M. semimembranosus* (inside) and associated muscles or *M. 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 must not exceed FSIS regulations. The lean must be trimmed of all fat including seam fat and must be practically free from exposed heavy (opaque) connective tissue. A cross section of this item must have the appearance of whole muscle systems (excluding binder) that is of an even uniform color across the entire cut surface (two tone color not permitted). This product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 510 – Ham, Honey Cured (Smoked), Partially Boned, Spiral cut. –

This item must be prepared as described in Item 504, except honey must be included in the curing process compliant with FSIS regulations and policies. The ham must be spiral cut (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, plastic bag. This product must conform to applicable regulatory requirements for curing.

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 must not exceed FSIS regulations. The ham must be free from bones, cartilage, skin, heavy connective tissue, air, or gelatin pockets, and lymph glands. A cross-sectional cut of this item must 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 must be fully enclosed in a polyethylene liner and unless otherwise specified must be formed and canned Pullman style. This product must conform to applicable regulatory requirements for curing and thermal processing.

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 cured the ham must be stuffed into an artificial casing and smoked. This product must conform to applicable regulatory requirements for curing and thermal processing.

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 must be practically free from shank and heel meat (inner shank), fat, bones, cartilage, skin, connective tissue, and lymph glands. The meat must be either hand diced or mechanically diced (grinding is not permitted). At least 75 percent, by weight, of the resulting pieces must 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 must be done prior to freezing or dicing (a sample unit must be 10 pounds of adjacent product and the sample size must be as specified in QAP Table I-A). Piece size and packaging requirements must be at the option of the purchaser. This product must conform to applicable regulatory requirements for curing.

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED		
<u>Piece Size Options:</u>	A.	¼ inch x ¼ inch x ¼ inch long (6 mm x 6 mm x 6 mm long)
	B.	½ inch x ½ inch x ½ inch long (13 mm x 13 mm x 13 mm long)
	C.	½ inch x ½ inch x 1 inch long (13 mm x 13 mm x 25 mm long)
	D.	½ inch x ½ inch x 2½ inches long (13 mm x 13 mm x 68 mm long)
	E.	Other, as specified by purchaser
<u>Packaging Options:</u>	A.	Individual Servings (size 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

must 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). This product must conform to applicable regulatory requirements for curing.

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED		
<u>Piece Size Options:</u>	A.	¼ inch x ¼ inch x ¼ inch long (6 mm x 6 mm x 6 mm long)
	B.	½ inch x ½ inch x ½ inch long (13 mm x 13 mm x 13 mm long)
	C.	½ inch x ½ inch x 1 inch long (13 mm x 13 mm x 25 mm long)
	D.	½ inch x ½ inch x 2½ inches long (13 mm x 13 mm x 68 mm long)
	E.	Other, as specified by purchaser
<u>Packaging Options:</u>	A.	Individual Servings (size 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 that will meet the end item requirements. Shank meat and jowls must be excluded. Dices must be free of shank meat, bones, cartilage, skin, heavy connective tissue, and lymph glands. The meat must be either hand diced or mechanically diced (grinding is not permitted). At least 75 percent, by weight, of the resulting pieces must comply with the designated size and fat requirement. Dices must not exceed 0.25 inch (6 mm) in maximum depth of surface fat. Dices must 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 must be done prior to freezing or dicing (a sample unit must be 10 pounds of adjacent product and the sample size must be as specified in QAP Table I-A). Piece size and packaging requirements must 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 must be so noted in the labeling nomenclature (i.e., smoke flavoring added). This product must conform to applicable regulatory requirements for curing.

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED		
<u>Piece Size Options:</u>	A.	¼ inch x ¼ inch x ¼ inch long (6 mm x 6 mm x 6 mm long)
	B.	½ inch x ½ inch x ½ inch long (13 mm x 13 mm x 13 mm long)
	C.	½ inch x ½ inch x 1 inch long (13 mm x 13 mm x 25 mm long)

	D.	½ inch x ½ inch x 2½ inches long (13 mm x 13 mm x 68 mm long)
	E.	Other, as specified by purchaser
<u>Flavoring:</u>	A.	Smoke flavoring NOT added
	B.	Smoke flavoring added (if selected, must be reflected on label, i.e. smoke flavoring added)
<u>Packaging Options:</u>	A.	Individual Servings (size specified by purchaser)
	B.	Bulk Pack (size as specified by purchaser)

Shoulder items may be prepared from pork shoulder in the 403, 405, 405A, 406B, and 406 series or any preceding like Item No.

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 1.0-inch (25 mm) posterior to the elbow joint, but not exposing the elbow joint and continuing across the hog side. The neckbones, ribs, breastbones, cartilage, intercostal meat, exposed lymph glands, and breast flap must be removed. The shoulder must be suitably faced without appreciable scoring or undue removal of lean. The foot must 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 must 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 must 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, must not exceed that indicated in the following schedule. This product must conform to applicable regulatory requirements for curing.

Weight Range of Shoulder	Maximum Fat Thickness
8 – 12 pounds (3.6 – 5.4 kg)	½ inch (13 mm)
12 – 16 pounds (5.4 – 7.3 kg)	¾ inch (19 mm)
16 – 20 pounds (7.3 – 9.1 kg)	1 inch (25 mm)

Item No. 516 – Pork Shoulder (Cured and Smoked). – The cured and smoked shoulder must conform to the requirements specified for Shoulder, (Cured) – Item No. 515, except that in addition to curing, the shoulder must 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). This product must conform to applicable regulatory requirements for curing.

Item No. 517 – Pork Shoulder, Skinned (Cured). – The partially skinned shoulder (cured) must conform to the requirements specified for a Shoulder (Cured) – Item No. 515, except that the shoulder must be partially skinned leaving a well-rounded skin collar. The skin must 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. Remaining fat on the skinned surface shall be no less than 1.5 inches (38 mm) from the edge of the skin collar and must not exceed an average depth of 0.25 inch (6 mm), and must be beveled to approximately meet the lean at the butt end and on both sides. At least traces of false lean must be exposed. This product must conform to applicable regulatory requirements for curing.

Item No. 518 – Pork Shoulder, Skinned (Cured and Smoked). – The skinned shoulder (cured and smoked) must conform with the requirements specified for Shoulder, Skinned (Cured) – Item No. 517, except that in addition to curing, the shoulder must 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). This product must conform to applicable regulatory requirements for curing.

Item No. 525 – Pork Shoulder, Picnic (Cured). – The cured shoulder picnic is prepared as described in IMPS Item No. 405. The shoulder picnic is separated from the butt by a straight cut dorsal to the shoulder joint at an approximate right angle with the belly side. The jowl must be removed by a straight cut approximately parallel with the belly side that is not more than 1.0 inch (25 mm) anterior from the half moon muscle (*M. pectorales profundi*) measured on the butt side. The foot must 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 must 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 must not exceed the following schedule. This product must conform to applicable regulatory requirements for curing.

Weight Range of Shoulder Picnic	Maximum Fat Thickness
4 – 6 pounds (1.8 – 2.7 kg)	¼ inch (6 mm)
6 – 8 pounds (2.7 – 3.6 kg)	½ inch (13 mm)
8 – 12 pounds (3.6 – 5.4 kg)	¾ inch (19 mm)

Item No. 526 – Pork 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 must 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). This product must conform to applicable regulatory requirements for curing.

Item No. 527 – Pork Shoulder, Picnic (Cured and Smoked), Boneless, Tied.

– This item is prepared from Item No. 526, except that the picnic must be made completely boneless and skinless. The arm bone and blade bone must be removed closely without unduly scoring or damaging the Shoulder Picnic. Tendinous ends of the shank must be trimmed to expose at least 75% lean. Surface fat in excess of 0.25-inch (6 mm) maximum at any point must 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 must be netted or tied. This product must conform to applicable regulatory requirements for curing.

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 must be removed, and surface fat in excess of 0.25 inch (6 mm) in depth must be removed. The blade bone and overlying lean must be removed. At least traces of *M. trapezius* (false lean) must be exposed, and the fat must be beveled to meet the lean. The jowl must 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 must expose the *M. supraspinatus* with no more than a slight enlargement of the tendons. The trimmed, boneless shoulder butt must 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 must be handled as necessary to remove grease and extraneous matter. This product must conform to applicable regulatory requirements for curing.

Item No. 531 – Pork Shoulder, Butt, Boneless (Cured and Smoked), Special.

– All bones, skin, and *M. trapezius* must be removed. The loin side of the butt must expose the *M. longissimus* equal to or larger than the combined areas of the *M. splenius* and *M. semispinalis capitis*. The picnic side must expose a cross-section of the *M. supraspinatus* with no more than a slight enlargement of tendons. This item must be trimmed practically free of all surface fat (i.e. at least 75% lean must be exposed, and any remaining fat must not exceed 0.25 inch (6 mm) maximum depth at any point). The jowl must be removed by a straight cut approximately parallel with the loin side and immediately posterior to the ear dip. The trimmed, boneless butt must 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 must be handled as necessary to remove grease and extraneous matter. This product must conform to applicable regulatory requirements for curing.

Belly and bacon items may be prepared from pork 408 series or any preceding like Item No.

Item No. 535 – Pork 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 must be removed. Practically all leaf fat must be removed. The belly must 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 must be reasonably straight and parallel. No one side of the belly may be more than 2.0 inches longer than its opposing side. The width of the *M. rectus abdominus* (flank muscle) must be at least 25 percent of the width of the belly on the ham end. The belly must be free of enlarged soft, porous, or seedy mammary tissue, pizzle recesses, scores, and other damage affecting the end product. There must be no area of exposed fat on the face of the belly below the scribe line that exceeds 8.0 square inches. This product must conform to applicable regulatory requirements for bacon curing.

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

Item No. 537 – Pork Bacon, Slab (Cured and Smoked), Skinless, Formed. – The skinless slab bacon must conform with the requirements specified for Bacon, Slab (Cured and Smoked), Skin-on, Formed – Item No. 536 except that the finished product must 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 must be pressed and formed after smoking and cooling. This product must conform to applicable regulatory requirements for bacon curing.

Item No. 538 – Pork Bacon, Slab, Center Cut (Cured and Smoked), Skinless, Formed. – The smoked and cured slab must be prepared as specified in Item No. 537, except that the fat back must 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 must be removed by a straight cut dorsal to the teat line. The belly must be squared on all edges and with approximately straight and parallel sides and ends. There must be no area of exposed fat on the face side of the belly that exceeds 4.0 square inches. The skinless slab bacon must

be pressed and formed after smoking and cooling. Maximum thickness of the formed slab must not exceed 2.25 inches. Minimum thickness of the slab must not be less than 0.75 inch (19 mm). This product must conform to applicable regulatory requirements for bacon curing.

Item No. 538A – Pork Bacon, Sliced, Center Cut (Cured and Smoked). – The slices must be produced only from skinless slab bacon Item No. 538. The bacon slices must be approximately uniform in length, ranging from 7 to 9 inches without underfolding. Maximum width of the slices must not exceed 2.25 inches. Minimum width of the slices must be not less than 0.75 inch (19 mm). The surface lean on the face side of the slice (opposite of skin side) must 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 must be excluded. One part slice may be used per package to make exact weight (part slice must not be considered when determining defects). The individual packages of sliced bacon must be of the number of slices per pound as specified. (See weight range table). This product must conform to applicable regulatory requirements for bacon curing.

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 must not exceed 61 percent, the salt must 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 must be determined in accordance with the Official Methods of the AOAC International at a FSIS approved laboratory designated by the vendor. The vendor must 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.

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED			
<u>Packaging Options:</u>	A.		Individual 1.0-pound packages
		1.	Lay 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.	Lay out packed – Individual sliced 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
<u>Analytical Content Options:</u>	A.		Fat
	B.		Moisture
	C.		Salt

Item No. 539 – Pork 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, must 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) must 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 must be excluded. One part slice may be used per package to make exact weight (part slice must not be considered when determining defects). The individual packages of sliced bacon must be of the number of slices per pound as specified. (See weight range table). This product must conform to applicable regulatory requirements for bacon curing.

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 must not exceed 61 percent, the salt must 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 must be determined in accordance with the Official Methods of the AOAC International, at a FSIS approved laboratory designated by the vendor, who must 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.

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED			
<u>Packaging Options:</u>	A.		Individual 1.0-pound packages
		1.	Lay 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.	Lay out packed – Individual sliced 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
<u>Analytical Content Options:</u>	A.		Fat
	B.		Moisture
	C.		Salt

Item No. 540 – Pork Bacon, Sliced, Fully-Cooked (Cured and Smoked), Skinless. – The fully cooked sliced bacon must be prepared from a bacon belly that meets all the requirements necessary to produce Item No. 539. After cooking, the yield of the finished product must not exceed 40 percent. In addition, the slices must be uniform in appearance and not less than 5.0 inches (12.5 cm) or more than 7.0 inches (17.5 cm) long. The slices must not be cut or torn for more than one-half the width of the slice and must not be over-cooked or have any burnt edges or areas measuring more than 0.3 inch (7.6 mm) in any dimension. The slices must not break or crack when the ends are brought together. There must be no evidence of any off-odors or flavor. The finished product must also adhere to all required standard of identity requirements such as antioxidants, salt, moisture, and protein content. This product must conform to applicable regulatory requirements for bacon curing and thermal processing.

Packaging must consist of 15 slices laid out on parchment-type paper, unless otherwise specified by the purchaser. Purchasers may specify the product to be delivered in cartons, pouches, or cans of up to 300 slices. Pouches and cans must be properly cartoned. As an option, the purchaser may specify the cooked bacon in a round slice shape appropriate for sandwich bun use. If so, certain requirements listed above such as length and packaging may not be applicable

and are subject to agreement between purchaser and supplier.

Item No. 541 – Pork 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. This product must conform to applicable regulatory requirements for bacon curing.

Loin items may be prepared from pork loin in the 410, 411, 412, 412B, 412C, and 414 series or any preceding like Item No.

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, leg, belly, skin, and fat back, leaving a portion of the blade bone with its overlying flesh and at least two (2) sacral, but no caudal vertebrae, in the loin. The shoulder and ham must be separated from the loin by straight cuts reasonably perpendicular to the split surface of backbone. The outer tip of the *M. subscapularis* must not extend past the center of the medial ridge of the blade bone. The line of separation of the loin from the belly must be reasonably straight extending from a point that is ventral to but not more than 3.0 inches (7.5 cm) from the *M. longissimus* on the shoulder end, to a point on the ham end that is ventral to but not more than 0.5 inch (13 mm) from the tenderloin (a slight dorsal curvature is acceptable). Surface fat must be trimmed to an average depth of 0.25 inch (6 mm) or less except in the hip bone area. The hip bone area that has no measurable fat requirement is defined as the area contained within two (2) parallel lines, 2.0 inches (5.0 cm) on either side of the anterior end of the hipbone and related cartilage. Fat in the hip bone area must be trimmed to the same contour as the rest of the trimmed surface of the loin. At least 2.0 inches (5.0 cm) of the false lean (*M. trapezius*) must be exposed. Lumbar and pelvic fat must not exceed 0.5 inch (13 mm) 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 must remain intact. The diaphragm and hanging tender must be removed. The spinal cord groove must be evident on at least 75 percent of the vertebrae, and all exposed spinal cord portions must be removed. This product must conform to applicable regulatory requirements for curing.

Item No. 546 – Pork Loin, Bladeless (Cured and Smoked), Bone-In. – The bladeless (cured and smoked) loin must 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 must be removed and excluded. The loin/shoulder separation must show a cross section of the *M. longissimus dorsi* that has a diameter of at least 1.0 inch (25 mm) across. This product must conform to applicable regulatory requirements for curing.

Item No. 547 – Pork Loin, Center-Cut, 11 Ribs (Cured and Smoked), Bone-In. – This loin is prepared from Item No. 545. The shoulder end separation must be made from a point that leaves not more than 11 ribs on the loin. Floating rib(s) that do not show a cross section at the belly are exempt. The ham end must be removed immediately anterior to the hip bone and related cartilage and must expose the *M. gluteus medius*. This product must conform to applicable regulatory requirements for curing.

Item No. 547A – Pork Loin, Center-Cut (Cured and Smoked), Boneless. – This item is prepared from item No. 547. The tenderloin, all bones, and cartilage must be removed. On the blade end, the diameter of the exposed *M. longissimus* must be at least 2.0 inches (51 mm). The sirloin must be removed by cutting immediately anterior to the hip bone cartilage exposing the *M. gluteus medius*. The belly must be removed by a cut from a point ventral to, but not more than, 3.0 inches (7.5 cm) from, the *M. longissimus* at the blade end to a point on the sirloin end ventral to, but not more than, 3.0 inches (7.5 cm) from the *M. longissimus*. 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. This product must conform to applicable regulatory requirements for curing.

Item No. 548 – Pork Loin, Center-Cut, 8 Ribs (Cured and Smoked), Bone-In. – 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 hip bone and associated cartilage. The blade portion must be removed to leave not more than eight (8) ribs present. Floating rib(s) that do not show a cross-section at the belly side are exempt. The belly must 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 *M. longissimus* at the blade end to a point on the sirloin end, which is ventral to, but not more than, 3.0 inches (7.5 cm) from the *M. longissimus*. Surface fat must be trimmed to not exceed 0.25 inch (6 mm) in depth. Lumbar fat must be trimmed to not exceed 0.5 inch (13 mm) in depth. The tenderloin must remain intact. The spinal cord groove must be evident on at least 75 percent of the vertebrae, and all exposed spinal cord portions must be removed. This product must conform to applicable regulatory requirements for curing.

Item No. 548A – Pork Loin, Center-Cut, 8 Ribs (Cured and Smoked), Boneless. – This item is prepared from Item No. 548. The tenderloin, all bones, and cartilage must be removed. On the blade end, the diameter of the exposed *M. longissimus* must be at least 2.0 inches (51 mm) across. The sirloin is removed anterior to the hip bone cartilage and must expose the *M. gluteus medius*. The belly must be removed by a cut ventral to, but not more than, 4.0

inches (101 mm) from the *M. longissimus* at the blade end to a point on the sirloin end ventral to, but not more than, 3.0 inches (7.5 cm) from the *M. longissimus*. 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. This product must conform to applicable regulatory requirements for curing.

Item No. 550 – Pork Canadian Style Bacon (Cured and Smoked), Unsliced.

– The Canadian back includes the *M. longissimus*, *M. spinalis dorsi*, *M. multifidus dorsi*, *M. complexus*, and *M. 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 dorsal and ventral side of each end of each of the Canadian Style Bacon must not be more than 1.0 inch (25 mm) difference in length. The blade end must show a cross sectional cut of the loin with the *M. longissimus* having a diameter of at least 2.0 inches (58 mm) or more. The shoulder and sirloin ends must be removed by straight cuts approximately parallel to each other. All bones and cartilage must be removed. The surface fat must be trimmed to 0.3 inches thick at any point. 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. This product must conform to applicable regulatory requirements for curing.

Item No. 550A – Pork Canadian Style Bacon (Cured and Smoked), Sliced. –

Sliced Canadian style bacon must be produced from the cured and smoked Canadian back Item No. 550. The slices must be uniform in thickness and diameter. Thickness may range from 7-9 slices per linear inch. Slicing must be at approximate right angles to the major muscle. Insofar as practical, the slices must 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 must not be included. This product must conform to applicable regulatory requirements for curing.

ORDERING DATA: THE PURCHASER MUST SPECIFY OPTIONS DESIRED		
Packaging Options:	A.	Individual 1.0-pound packages
	B.	Bulk packed (weight specified by purchaser)

Item No. 555 – Pork Jowl Butts, Cellar Trim (Cured). – Cured jowl butts must be of standard cellar trim and reasonably square with ragged ends smoothly removed and excluded. The product must not exude more than a slight amount moisture. Individual pieces of the product delivered dry salted must be coated with clear granulated salt; however, loose and encrusted salt must be removed and excluded. The finished product must not exhibit evidence of over or under curing or of improper storage. This product must conform to applicable

regulatory requirements for curing.

Item No. 556 – Pork Jowl Squares (Cured and Smoked). – Jowl squares must be reasonably rectangular in shape and at least reasonably squared on the sides and ends, being reasonably symmetrical and smooth on all surfaces. They must be faced by close removal, before smoking, of surface glandular and loose tissue, and bloody discoloration. This product must conform to applicable regulatory requirements for curing.

Spareribs items may be prepared from pork spareribs in the 416 and 416A series or any preceding like Item No.

Item No. 558 – Pork Spareribs, Fully-Cooked. – Spareribs must contain at least 11 ribs. The fully cooked ribs may include portions of the costal cartilage with or without portions of the sternum and the diaphragm. The membranous portion of the diaphragm must be removed close to the lean. Any portion of the diaphragm not firmly attached must be removed close to the lean. The lean must 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 must not exceed 0.25 inch (6 mm) average depth. Leaf fat over the diaphragm **and** *M. transverse abdominis* must be trimmed practically free. This product must conform to applicable regulatory requirements for thermal processing.

Item No. 559 – Pork Spareribs (Cured and Smoked). – The spareribs must conform with the requirements specified for Spareribs Fully-Cooked – Item No. 558, except that the spareribs must be cured and smoked. This product must conform to applicable regulatory requirements for curing.

Item No. 559A – Pork Spareribs Fully-Cooked, St. Louis Style. – The spareribs must be as described in Item No. 558 except the sternum and the ventral portion of the costal cartilage **must be removed along with the flank portion. The breast must be removed at a point that is dorsal to the curvature of the** costal cartilage. When specified, the diaphragm must be removed and the spareribs must be separated into two approximate equal portions by a lengthwise cut. This product must conform to applicable regulatory requirements for thermal processing.

Item No. 559B – Pork Spareribs (Cured and Smoked), St. Louis Style. – The spareribs St. Louis Style (cured and smoked) must conform to the requirements specified for St. Louis Style Spareribs Fully-cooked – Item No. 559A, except that the spareribs must be cured and smoked. This product must conform to applicable regulatory requirements for curing.

Hock and feet items may be prepared from pork hock and feet in the 471A, 417B, and 420 series or any preceding like Item No.

Item No. 560 – Pork Ham Hocks (Cured and Smoked). – The ham hocks must be separated from the hind foot by a cut at or above the hock joint toward the ham and must be at least 2.0 inches (5.0 cm) in length. This product must conform to applicable regulatory requirements for curing.

Item No. 561 – Pork Shoulder Hock (Cured and Smoked). – The shoulder hocks (cured and smoked) must be cut through or above the knee and must be at least 2 inches (5.0 cm) in length. To differentiate from ham hocks, shoulder hocks will not exhibit the Achilles tendon. This product must conform to applicable regulatory requirements for curing.

Item No. 562 – Pork Clear Fat Back (Cured). – The cured clear fat backs must be produced from the fatty portion of the back after the removal of the loin. They must be relatively short and thick, and the thickness must be relatively uniform throughout. All edges must be reasonably squared. The cured product must be drained and reasonably free from loose and encrusted salt. This product must conform to applicable regulatory requirements for curing.

Item No. 563 – Pork Front Feet (Cured). – Feet must be removed from the shoulder at least slightly above the knee joint. They must be practically free of hair and hair roots. This product must conform to applicable regulatory requirements for curing.

PORTION CUT ITEMS

Item No. 1513 – Pork 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 must be fully-cooked. The ham patties must be free from bones, cartilage, skin, heavy connective tissue, and lymph glands. Product must be initially examined prior to grinding in accordance with the QAP defect Table 500N. The boneless ham must 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 must 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 must not be mixed after final grinding. Initial reduction in size, blending, final grinding, and packaging must be a continuous sequence. This product must conform to applicable regulatory requirements for curing. This product must conform to applicable regulatory requirements for thermal processing.

Fat Content – Unless otherwise specified, the fat content must 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 must be determined at a FSIS-approved and certified laboratory designated by the vendor, who must 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 must meet or exceed FSIS regulations applicable to each style of product being produced. Failure of any analyzed sample to meet or exceed the FSIS required PFF value must cause rejection of the involved lot. PFF percentages must be determined at a FSIS-approved and certified laboratory designated by the vendor, who must 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 must 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 must be done prior to freezing or slicing.

Item No. 1531 – Pork Ham Steaks (Cured and Smoked), Boneless. – This item may be prepared from Item No. 505, 508, or 509. The ham steaks must be free from all skin, bruises, blood clots, lymph glands, bone, cartilage, and surface fat. Steaks must be sliced from hams perpendicular to the long axis of the ham. Portions must be sliced as specified. Slices must be approximately round and exhibit a cured and smoked appearance. The lean meat must 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. This product must conform to applicable regulatory requirements for curing.

Item No. 1545 – Pork Loin Chops (Cured and Smoked). – The chops are prepared by slicing Item No. 545. Chops must 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 must be sliced from end to end, and all suitable portions must be included. Chops must be practically free from: (1) fractures, (2) tag ends, and (3) knife scores. Individual chops must remain intact when suspended 0.5 inch (13 mm) from the outer edge. This product must conform to applicable regulatory requirements for curing.

Item No. 1547 – Pork Loin Chops, Center Cut (Cured and Smoked). – The center cut chops meeting this requirement may be cut from Item No. 547 or 545.

Surface fat must not exceed 0.25 inch (6.0 mm) at any point. Chops must be cut at an approximate right angle to length of the loin and be practically free from fractures, tag ends, bruises or blood clots, and knife scores. This product must conform to applicable regulatory requirements for curing.

Item No. 1548 – Pork Loin Chops, Boneless, Center Cut (Cured and Smoked), Boneless. – The chops are prepared by slicing Item No. 547A or 548A. Chops must 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 must be sliced from end to end, and all suitable portions must be included. Chops must 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 must 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) must not exceed 25 percent of the total cut surface area on either side of the chop. Individual chops must remain intact when suspended 0.5 inch (13 mm) from the outer edge. This product must conform to applicable regulatory requirements for curing.

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 must 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 must be removed so that a cross-sectional cut exposes at least 75 percent lean. Product must be initially examined prior to grinding in accordance with the QAP 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 must 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 must be not more than 24 percent nor less than 14 percent. The fat content of the coarse ground pork must be determined at a FSIS-approved laboratory designated by the vendor, who must 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 USDA, the purchaser may specify the fat content analysis to be determined on a composite analysis or average analysis (as defined within the IMPS QAP). If no preference is stated by the purchaser, an average analysis must be performed.

Spices may be added at the option of the purchaser and must 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 must not be mixed after the final grind. The ground mixture must 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 must be done prior to freezing or slicing. The patties must be fully cooked in accordance with FSIS regulations and must 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 must be determined on an average of 10 patties. The declared patty weight must be multiplied by 10. The value for 10 declared patty weights must be multiplied by 0.05 (5%). Five percent of the value of 10 declared patty weights must 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 must 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.