



Federal Purchase Program Specification Oven-Roasted 8 Piece Cut-up Chicken: April 2024

I. Purpose

This document provides the procedures USDA, AMS graders (graders) will utilize with the certification of oven roasted 8-piece cut-up chicken to the [April 2024 Federal Purchase Program Specification \(FPPS\)](#). The grader must read this procedure carefully and note what items must be observed during formulation, sampling, packaging and packing, labeling, loading and shipping, and the preparation of worksheets and certificates. The grader will not proceed until their supervisor has reviewed the [QAD 620: USDA FPPS – Poultry General Requirements](#) and this procedure with them.

Oven-Roasted 8- Piece Cut-up Chicken (110080) must be processed and packed as outlined in the FPPS. The commodity must not be processed and packaged more than 90 calendar days prior to the first day of the delivery period for each sales order. The chilled commodity must be processed, packaged, packed, and placed in a freezer within 7 calendar days after the date of harvest.

Under the [Supplement for Chicken Products Distributed for Federal Food and Nutrition Assistance Programs](#) the contractor is able to select Option A: Grading-Based Monitoring and Certification or Option B: Audit Based Verification for contract compliance and certification of the commodity. Regardless of which option is chosen, all raw material must be graded or certified by the USDA, AMS grader. For all processing steps following raw material collection, the contractor may request the use of either option. These procedures apply for contractors selecting Option A.

II. Procedures

A. Processing & Fabrication

1. Raw Meat Requirements

The commodity must be prepared from freshly harvested ready-to-cook broilers/fryers. Chicken from other plants may be utilized provided they meet the FPPS requirements in section 530. Frozen or previously frozen chicken may not be utilized.

2. Grading Requirements

Prior to marination, graders must check 30 parts (at least 3 of each individual part) for U.S. Grade A to determine compliance with the FPPS requirements using the sampling frequency and acceptance criteria found in SPL-1. Results must be recorded on the LP-232L1.

3. Weight Range

WOG weights must be checked by weighing ten WOGs for weight requirements of 2.5 to 5.0 pounds, as outlined in the FPPS, and according to procedures established in [QAD 648: Poultry Weight Range Certification](#). Samples found with weights outside the allowable tolerances (+/- 10% per [QAD 607:](#)



[Portion Control and Weight Range Certification](#)) will be recorded as a defect. AQL checks exceeding allowable tolerances will require retention of product representing the sampling interval. Results must be recorded on the LP-232L2.

Oven roasted chicken product must be packed in natural proportion. If natural proportion cannot be verified refer to section 622 of the FPPS for pack tolerances.

4. Product Formulation Verification

The contractor has the option available to provide the grader with a statement from the spice manufacturer certifying that the spices and seasonings formulation is in compliance with the FPPS requirements. If spices are not pre-blended, graders must personally observe the formulation of the marinating solution ingredients to certify compliance with the requirements at the frequency stated in [QAD 604: Formulation Certification](#). Results of the formulation verification must be documented on the LP-232L2. Formulations found that do not meet requirements in section 560 of the FPPS cannot be used and will necessitate additional verification checks.

Water (minimum)	88.75%
Seasoning (up to)	8.00%
Phosphate (sodium or potassium up to)	3.25%

5. Marination and Glazing Percentage Verification

Determine the percentage of marinade pickup according to the procedures outlined in [QAD 606: Percent Gain Marinated-Sauce Products](#). Retain the product representing any sampling interval that exceeds the applicable FPPS maximum of 15%. The marinating, cooking, and individual freezing of the commodity will be a continuous and sequential process as described in section II. J. of [QAD 620: USDA FPPS Poultry General Requirements](#).

6. Organoleptic Requirements

The ready to cook chicken and chicken parts must be examined on a continuous basis in accordance with [QAD 614: Organoleptic Examination](#) and FPPS requirements stated in section 550.

B. Fully Cooked Product Checks

1. Cooked Temperature

Graders must follow the procedures for temperature verification in [QAD 608: Cooking Temperature Certification](#). The temperature must be checked on a sampling interval basis or more frequently if conditions warrant. All products must be fully cooked in accordance with USDA, FSIS Regulations.



2. Color Defects

The cooked chicken will be sampled and examined for color defects per [QAD 641: Poultry Products Color Defects](#). Online sampling will be performed on randomly selected product after the cooking operation and prior to freezing. Results must be recorded on the LP-232L2. Compliance with the color uniformity requirements will be determined by checking 10 random parts. The color must be within the light and dark color tolerance range shown on the chart “*Color Control on Oven Roasted Chicken*” dated July 2010. A copy of this document can be made available by request sent to the National Poultry Office.

3. Organoleptic Examination

The ready to cook chicken parts must be examined on a continuous basis in accordance with [QAD 614: Organoleptic Examination](#) and FPPS requirements stated in section 566.

The fully cooked product will be sampled and examined for organoleptic defects to determine compliance with FPPS requirements. Online sampling will be performed on randomly selected product after the cooking operation and prior to freezing. Results (*Satisfactory “S” or Unsatisfactory “U”*) must be recorded on the LP-232L2 reverse side.

The fully cooked product will be examined for organoleptic defects by visual examination and smelling for each sampling interval product is produced. This examination must include checking for defects such as overcooked, scorched, undercooked, and areas of dehydration. If such defects are found in the sample, the lot of product the sample represents must be retained. Sample size will be 10 random parts examined for the applicable criteria.

4. Freezing Requirements

The chilled commodity must be processed, packaged, packed and placed in a freezer within 7 calendar days after the date of harvest. All cooked product must be frozen in a manner to bring the internal temperature of the product at the center of the package to 10 °F, or below within 24 hours from the time of entering the freezer. Specific guidelines on freezing and holding temperature requirements are outlined in [QAD 613: Frozen Product Examination](#).

C. Finished Product Checks

1. Metal Detection

All finished product must be examined by a metal detection device. Procedures and sensitivity levels are outlined in [QAD 609: Metal Detection](#). Results (Satisfactory “S” or Unsatisfactory “U”) must be recorded on the LP-232L2 reverse side.



2. Net Weight

Online sampling procedures found in [QAD 611: Net Weight Examination](#) can be used to ensure each finished shipping container weighs at least 30 pounds. Each delivery unit must consist of 1200 shipping containers weighing 30 pounds each with a total net weight of 36,000 pounds. Three 10-pound bags will be packed in each shipping container in accordance with the FPPS.

3. Packaging and Packing/Tamper-Evident

The packaging and packing material must be “tamper-evident.” Tamper-evident is defined as packaging or packing materials with one or more indicators or barriers to entry, which, if breached or missing, can reasonably be expected to provide visible evidence that tampering has occurred. Examples include damage to the box from tape being removed, or a hole in the plastic bag from it being torn or cut open that would be obvious to a person inspecting the product. Determination of whether the material meets these requirements may be made by the supervisor. At time of shipment, each lot will undergo an examination for packaging and packing defects per [QAD 617: Packaging and Packing](#).

4. Labeling

Contractors have the option to use commercial or USDA labeling. Labeling must meet all requirements in section 700 of the FPPS. Child Nutrition (CN) labeling information or a product formulation statement demonstrating product contribution to the National School Lunch Program meal pattern requirements is required. Each shipping container must be identified with a USDA Contract Compliance stamp with the applicable certificate number or production date. An AMS grader or other authorized personnel under the supervision of the AMS grader must stamp one end of each shipping container at the origin facility. If there is inadequate space available on either end of the shipping container, the stamp may be applied to a side of the container. As an alternative to stamping, the contractor may preprint the stamp on the shipping container or label. Prior approval by the Poultry National Office is required before using this alternative method.

The sodium content of the cooked chicken parts should be no more than 230 mg per 86 gram serving as evidenced by the Nutrition Facts Panel.

D. Certification and Delivery

1. Temperature Requirement

At time of shipment, product must be 2°F or below. In lieu of drilling into the product, it is acceptable to sandwich the temperature probe between two unopened bags of product until the temperature stabilizes. Product with internal temperatures exceeding 2°F and up to 5°F will be tentatively rejected. Tentatively rejected product may be returned to the freezer and re-offered for shipment one time only. Product exceeding 5°F, or product that was tentatively rejected and exceeds 2°F when reoffered, must be rejected. Sampling levels will be according to the processors current freezing history. As an option



to checking product at time of shipment, and upon review and approval by the supervisor, plants may use the alternate verification procedures as described in [QAD 613: Frozen Product Examination](#).

2. Certification

Any product not meeting the outlined criteria, or any other specified requirement must be retained. An LP-210P: *USDA Poultry Products Grading Certificate* must accompany each shipment. The Purchase Order number, Sales Order number, Sales Order Item number, and Seal numbers must be stated. See attached certificate examples.

3. Contractor Checkloading

Contractors have the option to utilize Contractor Checkloading as described in section II. S of [QAD 620: USDA FPPS - Poultry General Requirements](#).

Exhibits:

Exhibit I - LP-210P Certificate Example – Oven Roasted Chicken

Exhibit II - LP-210P Certificate Example – Split Delivery

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