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Programs

Raisin Dehydrators

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Marketing
Service

Inspection Instructions

Specialty
Crops
Program

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Specialty
Crops
Inspection
Division

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These instructions contain information and guidelines to help personnel of the U.S. Department of Agriculture's (USDA) Specialty Crops Inspection (SCI) Division uniformly apply and interpret U.S. grade standards, other similar specifications, and special procedures.

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Inspection instructions are issued by USDA after careful consideration of all data and views submitted. The Department welcomes suggestions for improving the inspection instructions in future revisions.

Comments may be submitted to:

Director, Specialty Crops Inspection Division
Specialty Crops Program
USDA, Agricultural Marketing Service
1400 Independence Avenue, SW, STOP 0240
Washington, DC 20250

These instructions replace the Inspection and Paperwork Manual for Raisin Dehydrators dated August 2005, and include, but not limited to, all previous correspondence, memos, inspection instructions, or procedures.

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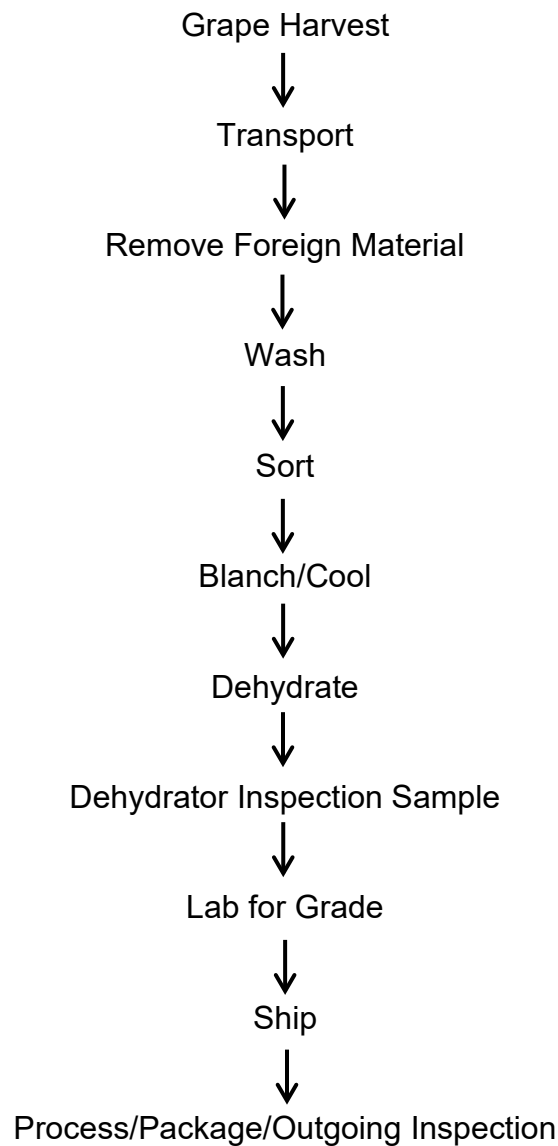
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GENERAL

PRODUCT DESCRIPTION

The term “Dehydrated Raisins” means raisins produced from any variety grape, dried by artificial means using dehydrating equipment or dehydrators. The most common types of dehydrated raisins are Golden Seedless and Dipped Seedless. The following instructions apply to inspections performed at a raisin dehydrator facility.

PRODUCTION FLOW



SAMPLING

The number of containers to be represented by each sample will be determined by agreement between dehydrator management and USDA personnel. Draw an equal quantity of raisins from each container as they are being filled until a total of 20 pounds minimum is reached. Using the in-plant triple splitter, mix and split samples of raisins into the 8-pound sub-samples. Ensure the sample is mixed thoroughly using the following procedure:

- Dump the sample into the top unit of the splitter.
- Recombine the entire sample after splitter completes process.
- Dump the sample into the top unit of the splitter a second time.
- Remove the middle container in the framework of the splitter, replace it with an empty container.
- Dump contents of middle container into the splitter the final time.
- Combine the raisins in the bottom two containers to obtain a minimum 8-pound sub sample.
- After the sample is split, approximately 8 pounds will be placed in a bag and labeled with all pertinent information such as: date, pallet control card (PCC) number, lot number, sample number, defects, number of containers, and the inspector's name. The remainder of the sample is returned to the container.
- Send the sample to the on-site USDA lab or the Fresno, CA Area Office at the address below:

Fresno, CA Area Office
Specialty Crops Inspection (SCI) Division Field Office
2202 Monterey Street, Suite 102-A, Fresno, CA 93721-3175.
PH: 559- 487-5210; FAX: 559-485-5914

INSPECTION AND GRADING

EQUIPMENT, INSPECTION AIDS, AND INSTRUCTIONS

- [U.S. Standards for Grades of Raisins](#)
- AIM Inspection Series Manuals
 - [Foreign Material Manual](#)
 - [General Processed Procedures Manual](#)
 - [Sampling Manual](#)
 - [Sanitation Manual](#)
 - [Technical Procedures Manual](#)
- [FDA Food Defect Action Level](#)
- [Processed Raisins Tally Sheet SC-364-167](#) (intranet link)
- [Sanitation Score Sheet for Raisin Dehydrators SC-416-8](#) (intranet link)
- [RAC Forms](#)

INSPECTOR RESPONSIBILITIES

Inspectors are responsible for performing plant sanitation inspections throughout the day following procedures outlined in the [Sanitation Manual](#).

Samples must be drawn from each container acquired, processed, stored, and shipped. Defects must be continuously monitored and annotated according to the [Foreign Material Manual](#).

Records of all containers meeting or failing must be maintained.

USDA employees must follow Good Manufacturing Practices (GMPs) and wear bump caps, hair nets, and safety vests while on official duty inside processing facilities in accordance with GMPs outlined in the [General Processed Procedures Manual](#).

Other uniform requirements for official duty inside processing facilities can be found in the [Workplace Dress and Uniform/Apparel Policy](#) (intranet link).

PAPERWORK – RECORDS AND REPORTS

SANITATION SCORE SHEET

Complete the SC-416-8 Sanitation Score Sheet ([Appendix I](#)) when conducting sanitation inspections. It serves as:

- A checklist to guide you on the sanitation inspections.

- Written notice to the plant management describing sanitation conditions in the plant for that day.
- A closer measure of control by the inspector.
- A written, detailed record of the plant sanitation.

The Sanitation Score Sheet ([Appendix I](#)) is to be filled out with an original and two copies being distributed as follows:

- Original: Plant Management
- First Copy: Inspector's File
- Second Copy: Scan and email original to the Fresno Area Office

Orally report any serious deviation or condition affecting sanitation promptly to the responsible person in charge (quality assurance (QA) personnel, plant manager, etc.). Oral reports are confirmed in writing on the Sanitation Score Sheet ([Appendix I](#)), even if corrective action has been taken. If no corrective action is taken, notify your supervisor.

More information about in-plant sanitation can be found in the [Sanitation Manual](#).

DEHYDRATOR DAILY INSPECTION RECORD

This inspection record should be completed daily. Containers must be logged each day and filed, reflecting the most recent at the front of the file cabinet drawer. The letters below correspond to the Dehydrator Inspection Record Example ([Appendix II](#)) and are as follows:

- a. Plant & No.: Name and number of the dehydrator, e.g., "D - (plant number)."
- b. Date: Date inspection is made.
- c. Variety: Variety being inspected.
- d. Inspector: Signature of inspector and initials of lab aide(s).
- e. Lot No.: Number assigned to the lot being inspected.
- f. No. of Containers: Enter number, size, and type of containers inspected.
- g. P.C.C. Nos: List Pallet Control Card (PCC) numbers identifying the lot being inspected.

- h. Moisture: Enter moisture percentage by weight.
- i. Graded For: Enter color graded for, e.g., Reasonably Well Colored (RWC). Dash through block (-) if doing minimum color.
- j. Off Color %: Enter percentage by weight of off color.
- k. Actual Color: Enter color, e.g., Fairly Well Colored (FWC). Check (✓) if meeting minimum color.
- l. Damage – Mech: Enter percentage by weight of mechanical damage.
- m. Damage – Other: Enter percentage by weight of other damage.
- n. Mold: Enter percentage by weight.
- o. Foreign Material: Identify if any, e.g., sandburs, rocks, etc.
- p. Sub: Enter percentage by weight of Substandard from airstream.
- q. B or Better: Enter percentage by weight of B or Better from airstream.
- r. Uncured Berries: Enter percentage by weight.
- s. Flavor and Odor: Enter a check (✓) if raisins have a flavor and odor characteristic of the varietal type. If raisins are not characteristic of the varietal type, enter (F) for Fails and describe the problem in remarks. Consult with the USDA supervisor.
- t. Grade: Enter M for Meets or F (in Red) for Fails
- u. Ledger Page No.: Enter the Reference Number from the RAC-14 database.
- v. Remarks: Use this area for any notes needed to keep track of the lot.
- w. Sulfur Results: Record sulfur results for the day, if any. Dash through block (-) if there are no results.
- x. Micro Numbers: Record micro numbers for the day.
- y. Remarks: Any additional notes about lots inspected during the day.

Record all Ball Checks for the Airstream Sorter on the Dehydrator Daily Inspection Record ([Appendix II](#)), using the line directly below the most recent sample entry.

CORRECTIONS

Make corrections on the Dehydrator Daily Inspection Record ([Appendix II](#)), draw a line through the incorrect figures or words, insert the correction, initial, and date the change. Corrections in the RAC-14 Database are to be made by following the instructions provided on the database.

CONTROL

As the containers are being sampled, they must be identified with yellow Raisin Administrative Committee (RAC) Pallet Control Cards (PCC) (RAC-11-B) ([Appendix III](#)).

If during the inspection, an individual container has obvious defects, it should be tagged with a red and white PCC (RAC-11) and moved to a secure location.

If tagged raisins are found to be off grade during the detailed lab inspection, the red PCC (RAC-11) should be attached to all bins or pallets of the failing lot.

LAB ANALYSIS

EQUIPMENT

The following equipment will be used to perform the inspection:

- Flat enameled pan
- Gram scale
- Scoop
- Scale check weights
- Gram conversion chart
- Certified Lamp

PROCEDURE

- Weigh 1,000 grams.
- Clean and separate the raisins before using the airstream sorter (A/S) for substandard (SUB) and B or better (BB) raisins.

The airstream sorter is a piece of equipment that is used to determine the maturity of raisins.

There are two types of sorters used:

- Substandard airstream sorter is used to determine the percentage of substandard raisins.
- B or Better air stream sorter is used to determine the percentage of B or better raisins.
- Use the drops from the substandard sample run through the airstream sorter. “Drops” are the portion of the raisins that are dropped into the non-substandard category after running through the airstream sorter. The “drops” from the substandard sample are the raisins that would be described as C grade maturity or better.
- Weigh 227 grams and place them on the enameled pan. Segregate the raisins for the various defects for which percentage tolerances must be determined by weight.
- After the sample is segregated, the raisins in each category are weighed using the gram scale. Using the gram conversion chart ([Appendix IV](#)), determine the percentage defective and record on the Dehydrator Daily Inspection Record ([Appendix II](#)).

COLOR ANALYSIS

For color analysis, use 100 grams of raisins from the drops of the substandard airstream sorter. Place the sample under a light box (Macbeth) or equivalent to observe the true color.

MICROANALYSIS “MICRO” SAMPLES

At the beginning of the season, a dehydrator will be put on “MICRO HOLD.” This means that a microanalysis (micro) sample will be submitted for each lot coming out of the dehydrator until all the trays have been used once, or the supervisor releases them. During a microanalysis, raisins are inspected for flies, eggs, and maggots (microscopic insects, such as eggs, larvae, pupae, adults, and insect parts and light filth, such as rodent hairs, feather barbs, and barbules. While on MICRO HOLD, raisins may not be shipped or acquired until they have been cleared for release.

Micro samples are to be prepared from the drops of the substandard airstream sorter, 681 grams for MICRO HOLDS or 227 grams for routine micro samples.

Place the sample in a dehydrator micro sample bag, annotating the name and number of the dehydrator, sample number(s), date sampled, pallet card number(s), and the inspector's name. Routine micro samples are to be labeled with the word "ROUTINE." MICRO HOLD samples should be labeled "RUSH" so that they are analyzed first by the micro department.

Complete and send SC-637 "Laboratory Sample Submittal Sheet" ([Appendix V](#)) with sample(s) to Fresno Area Office. See Micro Labels Example ([Appendix VI](#)).

MICRO HOLD samples may represent up to 12,000 pounds of raisins. After the first micro samples of the season are cleared (free from defects), the dehydrator will then submit routine micro samples. The routine samples will be prepared once per day, randomly selected from those that have come into the lab.

Raisins will also be held for microanalysis if the inspector or the supervisor believes that the raw product being used or the plant's sanitation conditions will materially affect the finished product. Raisins may also be held for microanalysis if they are stored for more than 48 hours without proper protection against potential rodent or insect contamination.

SULFUR SAMPLES

When requested by the dehydrator management, sulfur samples will be sent to the Fresno, CA Area Office for analysis.

Sulfur samples are to be prepared from the drops of the substandard airstream sorter. Select 227 grams for sulfur samples. Place the sample in a dehydrator micro sample bag annotating the name and number of the dehydrator, sample number(s), date sampled, pallet card number(s), and the inspector's name. Sulfur samples are to be labeled with the word "SULFUR." Complete and send SC-637 Laboratory Sample Submittal Sheet ([Appendix V](#)) with sample(s) to Fresno Area Office. See Micro Labels Example ([Appendix VI](#)).

MEETING AND FAILING LOTS LEDGER RAC-14

The RAC-14, also known as the Incoming Raisin Database, generates the RAC-14 Meeting and Failing Lots Ledger. The RAC-14 ledger is used to bill for all dehydrator inspections, as well as for handler and contract dehydrators. If the raisins are transferred to another plant or dehydrator for reconditioning, then [Incoming and Reconditioning Procedures](#) will apply.

MEETING LOTS

Meeting lots at a handler dehydrator will be entered in the Incoming Raisin Database as RAC-16. USDA will be paid based on the Handler's Acquisition Report. These lots will be listed on the RAC-16 report. Meeting lots in a contract dehydrator will be entered

into the RAC-14 database, allowing a Dehydrator Shipping Report ([Appendix VII](#)) to be generated. USDA will be paid for the inspection based on the receiving handler's acquisition report. If USDA is not paid, then the meeting entry for a contract dehydrator will not be completed and will not appear on any ledger.

FAILING LOTS

Failing lots at a handler dehydrator will be entered in the Incoming Raisin Database as RAC-17. USDA will be paid based on the Handler's Acquisition Report. These lots will be listed on the RAC-17 report. Failing lots in a contract dehydrator will be entered into the RAC-14 database so that a Dehydrator Shipping Report ([Appendix VII](#)) can be generated. USDA will be paid for the inspection based on the receiving handler's acquisition report. If USDA is not paid, then the failing entry at a contract dehydrator will not be completed and will not appear on any ledger.

DEHYDRATOR SHIPPING REPORT

When the lot is to be acquired at another location, it will be transferred under surveillance with a Dehydrator Shipping Report ([Appendix VII](#)). The Dehydrator Shipping Report is used to record the lots shipped and certify their grade, quality, and condition. Print three copies from the RAC-14 database and have them signed by the inspector. Two copies will go with the load, and one will stay at the dehydrator in the inspector's files. File with the most recent shipment at the front of the folder and keep it in a separate folder for each acquiring plant.

When the lot is loaded, USDA personnel will check the pallet control cards (PCCs) ([Appendix III](#)) attached to each bin against the PCC numbers listed on the Dehydrator Shipping Report ([Appendix VII](#)). PCCs should have a check mark above their numbers. and the receiver will circle the number, then sign and date the report.

Place two copies of the Shipping Report in a sealed envelope addressed to the USDA inspector at the receiving plant. Contact the inspector at the receiving plant when each load is shipped. Contact the Fresno, CA Area Office if the inspector cannot be reached.

SURVEILLANCE RECORD

The Surveillance Record ([Appendix VIII](#)) is used to track off-grade lots being reconditioned. Instructions to complete a failing surveillance record are as follows:

- a. Producer: Enter the producer's name.
- b. W/S No. or Lot No.: Enter the lot number, if any.
- c. Scale Tag No.: Enter scale tag number.

- d. Net. Wt.: Enter net weight.
- e. Ref. No.: Enter reference number if different from the original reference number.
- f. Original Reference Number (Orig. Ref. No.): Enter the original reference number.
- g. Variety: Enter the variety.
- h. Defects: Enter the defects
- i. Number of Containers: Enter the number/type of containers.
- j. Date Reconditioning/Shipping: Enter the starting date of action.
- k. Date Completed: Enter the date all action is complete i.e. lab work.
- l. Aide or Inspector: Person doing the inspection or surveillance must sign.
- m. Action Taken: Record the action taken during reconditioning.
- n. Pallet Card Numbers: Enter the pallet card numbers of containers being reconditioned.
- o. Attached Pallet Card: If bins are being reconditioned, the card numbers may be circled as they are removed in area letter (j). Also, in this area, the new pallet cards will be recorded.
- p. Residual Pallet Card Numbers.: Record tag numbers on residual containers, if any.
- q. Held For: Record in this area the defect or defects the lot is being held for by marking with an (X).
- r. Lab Results: Record the lab results for any item notated with an (X).

SANITATION

Sanitation is an integral part of inspection. The inspector will monitor plant sanitation to verify that conditions are clean and sanitary.

Become familiar with the dehydrator layout, premises, machinery, and equipment. Alert and inform dehydrator management of any developing deficiencies that could lead to product contamination. Refer to the [Sanitation Manual](#) for detailed plant sanitation

requirements. During sanitation tours, the following areas are checked, and conditions are annotated on the Sanitation Score Sheet ([Appendix I](#)).

A. Premises

1. General: The general appearance of the dehydrator should be neat and clean.
2. Waste Disposal: The waste disposal areas should be cleaned regularly, and the sump pumps should be clean and well drained. Wet residual should be kept away from the finished product.
3. Add in any additional information.

B. Receiving Department

1. Raw Materials: The raw material must be clean, which means relatively free of rotten bunches, rodents, and visible vinegar fly infestation that may materially affect its wholesomeness.
2. Storage: The handling and storage of the raw product must be done in a proper manner to ensure a clean finished product.
3. Floors and Gutters: The floors and gutters may need washing on a regular basis to keep raw product juice to a minimum. The receiving area may need spraying or fogging regularly to keep vinegar flies under control.
4. Add any additional items checked.
5. Add any additional items checked.

C. Preparation Department

Before each day's operation, the preparation department must be checked for cleanliness.

1. Dump Tank: Check the dump tank to see that it is free of grapes, stems, mold, leaves, and that it is filled with fresh, clean water.
2. Belts and Shakers: Make sure that belts, shakers, framework, and underside are clean and free of mold build-up.
3. Hot Tank: The hot water tank should be filled with clean, fresh water each day.

4. Rinse Tank: The rinse tank should be filled with clean, fresh water each day.
5. Trays: Trays should be free of dust, dirt, mold, and any rodent contamination.
6. Tray Washer: Check to see that the tray washer is clean and free of mold build-up.
7. Sulfur Houses: Sulfur houses should be free of dirt and kept free of fruit syrup build-up on the floors.
8. Floors and Gutters: Floors and gutters must be free of grape and leaf debris from the previous day in order to prevent vinegar flies.
9. Add any additional items checked.
10. Add any additional items checked.

D. Dehydrating Department

1. Tunnels: Check the tunnels to see that they are free of dirt and fruit syrup build-up.
2. Floors and Gutters: Floors, tracks, and gutters should be reasonably free of raisins, dirt, and any other debris.
3. Add any additional items checked.
4. Add any additional items checked.
5. Add any additional items checked.

E. Boxing Department

1. Scrapers and Belts: Scrapers and all belts must be free of any raisin residue and in good condition. Dip pan for scraper tools need to be cleaned and the water changed frequently.
2. Containers: Containers to be thoroughly checked for cleanliness before filling.
3. Floors and Gutters: Floors and gutters must be clean with no raisins present from the previous day. Floors should be swept and kept free of raisin build-up during the day's operation.

4. Add any additional items checked.

F. Warehouse

1. Floors: Floors should be kept reasonably clean.
2. General Housekeeping: The warehouse should be in good repair to keep the finished product free of contamination.
3. Stacks: Stacks should be orderly so that different lots can be readily identified.
4. Add any additional items checked.

G. Rest Rooms

1. Supplies: There should be an adequate supply of soap and paper towels.
2. Wash Basins: There should be an adequate supply of hot and cold running water.
3. Toilets and Urinals: All facilities should be clean and in good working order.
4. Floors and walls: All facilities should be clean and in good working order.
5. Add any additional items checked.

H. Personnel

1. Cleanliness: Ensure hands are washed or sanitized before starting or returning to work.
2. Head Covering: Verify that personnel are wearing proper head coverings and appropriate attire. Tank tops are not permitted.
3. Smoking: There should be no smoking around the product.
4. Add any additional items checked.

I. Other

1. Any additional findings of unsanitary conditions not listed above.
2. Any additional findings of unsanitary conditions not listed above.

3. Any additional findings of unsanitary conditions not listed above.
4. Any additional findings of unsanitary conditions not listed above.
5. Any additional findings of unsanitary conditions not listed above.

ACQUIRING AND RECEIVING

Any fruit not acquired within 120 days must be RTP (Returned to Producer) on an RAC-14 or RAC-17 and have a completely new incoming inspection before it can be acquired.

RECEIVING MEETING FRUIT AT AN ACQUIRING PLANT

Obtain the Dehydrator Shipping Report ([Appendix VII](#)) from the trucker. Check all pallet card numbers listed on the report against all pallet card numbers on the truck prior to unloading. Report discrepancies to the shipping inspector for correction. If all pallet card numbers and the box count correspond, the shipment may be unloaded.

Fill in the scale tag number and net weight on the Dehydrator Shipping Report ([Appendix VII](#)). The copy will be retained in the inspector's files and the original will be given to the receiving plant office.

The information on the Dehydrator Shipping Report is to be entered in the Incoming Raisin Database RAC-16. This will certify that the fruit is meeting and that the handler is acquiring the fruit.

ACQUIRING MEETING FRUIT AT A HANDLER DEHYDRATOR

As lots are found to be meeting, enter them in the Incoming Raisin Database RAC-16. The information will be taken from the Dehydrator Daily Inspection Record ([Appendix II](#)) or the shipping report from the dehydrator.

Go back to the inspection tally sheet or shipping report and enter the reference number.

MEMORANDUM (MEMO) STORAGE

Memo Storage is used to define raisins that are meeting incoming requirements but are not acquired by the handler. Raisins are placed in "memo storage" until acquired by the handler. Lots must be acquired within 120 days.

Only meeting lots may be held under Memo Storage. The lots placed on Memorandum Storage will be entered into the Incoming Raisin Database until released from Memorandum Storage by the plant or industry. All Dehydrator Shipping Reports or

copy of the Dehydrator Daily Inspection Record will be held in the “Memo Storage” folder until acquired.

OFF-GRADE

Off-grade refers to loads of raisins that are failing the incoming requirements. This is generally for defects, maturity, mold, sand, contamination, foreign material, or moisture.

Any time the raisins are found to be off-grade, the inspector must immediately notify the dehydrator management. The fruit will then be identified with red and white PCCs (RAC-11) ([Appendix III](#)).

BLENDING OF OFF-GRADE

The dehydrator may blend their failing fruit with raisins that have not been previously inspected if the defect is **not** a Food and Drug Defect (mold or foreign material). The blending must be conducted so that the inspector can obtain a final blended sample. Dehydrator management will make all decisions on blending. Keep a surveillance record of fruit being blended.

RECONDITIONING OF OFF-GRADE

Dehydrators may recondition their failing lots and the inspector must maintain surveillance and obtain a new sample. The inspector must also identify and record residual containers on the Surveillance Record ([Appendix VIII](#)).

BILLING, REPORTING, AND CLEARING OF OFF-GRADE

All off-grade fruit is reported on the Meeting and Failing Lots Ledger (RAC-14) in the Incoming Raisins Database. The dehydrator is billed for inspection of off-grade fruit from this ledger. It is not necessary to weigh off-grade lots. The weight may be estimated at 1,050 pounds per bin. All off-grade fruit that is reported must also be cleared. The fruit might be blended back into the line, reconditioned on its own, dumped into a distillery, or shipped to another plant to be reconditioned under surveillance. Whatever the case, the fruit must be accounted for. Record the final disposition of Failing Lots on the Dehydrator Daily Inspection Record ([Appendix II](#)) and attach the Surveillance Record ([Appendix VIII](#)) showing the action taken.

SHIPPING AND RECEIVING OFF-GRADE

If a failing lot is transferred to another plant for reconditioning, the inspector will print the Dehydrator Shipping Report in the same way as for a meeting lot. Record the transfer on the Dehydrator Daily Inspection Record.

When the lot is received at the reconditioning plant, the inspector will verify all pallet control numbers and container counts on the load. Then follow all regular [Incoming Reconditioning Instructions](#).

MOISTURE

Golden seedless, dipped seedless, and other seedless sulfured raisins that are made from Thompson or similar variety grapes are not to exceed 14 percent moisture.

Other seedless varieties, including Ruby, Flame, Black Imperial, Beauty, and Blush that are artificially dried, are not to exceed 16 percent moisture.

Raisins that exceed moisture tolerances may be returned to the dehydrating tunnels the same day as inspection in bins that require identification or certification. If raisins are returned to the tunnels in trays, they do not need to be identified or certified.

If the raisins are not returned to the tunnels the same day, they will be identified by red and white Pallet Control Cards and held under surveillance until final disposition. If held for more than 48 hours under improper storage conditions, the raisins will be resampled and held for microanalysis.

UNCURED BERRIES

Not more than 5 percent by weight of the raisins may be uncured, also referred to as frog belly. These are raisins that are excessive in moisture to the extent that they are little more than withered grapes.

Score as uncured if moisture drips from the berry when squeezed. The presence of one or two uncured berries in a handful of raisins indicates that the moisture may exceed tolerance.

COLOR – GOLDEN SEEDLESS ONLY

To meet minimum grade requirements, raisins must be characteristically colored, meaning that the golden color may be variable, but not more than 15 percent by weight may be definitely dark. Definitely dark color would be characteristic of natural sun-dried raisins.

An inspection for detailed color separation will be performed on each sample or lot. The dehydrator management must inform the inspector in advance of the color class to be separated, and the inspector can only drop one grade below or above the facility color class.

Each container that does not meet requirements for the designated color must be segregated. The inspector will be informed as to the policies and procedures involved. See color key ([Appendix IX](#)). Lots cannot be failed for color.

ABSENCE OF DEFECTS

Not more than 10 percent by weight of the raisins may be damaged, provided there is no type of damage that exceeds 5 percent. On the Dehydrator Daily Inspection Record ([Appendix II](#)), mechanical damage will be recorded separately, while all other types of damage will be combined and recorded as “other damage.”

MECHANICAL DAMAGE

Raisins that have broken skins; whether cut, broken, or chopped, if the flesh is exposed, the raisin is considered mechanically damaged.

SMOKE DAMAGE

Smoke damage is characterized by the presence of many tiny particles of soot on the raisins. Smoke damage may affect the color and flavor of the raisins.

SUNBURN OR CARMELIZATION

Carmelization in raisins is usually characterized by dark color and “burnt sugar” or caramelized flavor. Serious sunburn results in the raisins becoming puffed with small bubbles entrapped in the tissue. This is caused by overheating the raisins in the tunnels. The tunnels are extremely hot, and when left in for too long (or at too hot a temperature), the raisins burn.

EMBEDDED LEAF

A leaf is considered embedded if it is adhering to a raisin and cannot be removed by normal processing. Before failing a lot for this defect, run a sample through the automatic sand washer to simulate processing. Then determine the percentage by weight of the embedded material.

DISCOLOR

Discolor is the brown to dark brown discoloration at the capstem end of the raisins that equals or exceeds the area of a circle 1/8 inch in diameter. This type of damage normally occurs only when mature grapes are exposed to rain before harvest.

MOLD

Moldy raisins should not exceed 5 percent by weight. There are three types of mold that may be found in dehydrated raisins. Do not certify or definitively identify mold type on the tally sheet/inspection report; mold types can only be reported by the lab after positive identification. The three types of mold, along with scoring guides, are as follows:

- **Nodular (Black) Mold:** Nodular (black) mold is sometimes found in the capstem basin. Score each unit that equals or exceeds the area of a circle 1/8 inch in diameter.
- **Split Mold:** Split mold, as the name implies, is a crack in the berries' skin containing black mold. Score the raisins with split mold when the split or crack is 1/2 the length or more of the berry.
- **Putrid Mold:** Putrid mold is usually sticky and dirty looking with a white web-like structure on its surface. Score the raisins with putrid mold when 1/2 or more of the berry is affected.

MATURITY

SUBSTANDARD/UNDEVELOPED

The percentage of substandard raisins allowed changes from year to year in the raisin industry. The inspector will be informed by the Fresno, CA Area Office Management as to the tolerances, policies, and procedures involved.

A substandard raisin possesses large, deep wrinkles and generally shows a pronounced lack of sugar or fleshiness. Also included in the substandard percentage are the worthless raisins. These raisins are extremely light, completely shriveled, and hard. They possess fine wrinkles on smaller units and moderately deep wrinkles on slightly larger units. The substandard percentage will be determined using the airstream sorter.

B OR BETTER

The percentage by weight of B or Better requirements may change from year to year. The inspector will be informed by the Fresno, CA Area Office Management as to the tolerances, policies, and procedures involved. The determination of the B or better percentage by weight will be made by using the airstream sorter.

FOREIGN MATERIAL

There is no tolerance for objectionable material such as sandburs, puncture vine seeds, eucalyptus pods or leaves, visible infestation, or deleterious material.

When deleterious material such as glass, excrement, animal carcasses larger than a mouse, etc. are encountered, the inspector will do the following:

- Do not sample the container(s).
- Notate all the findings in the tally sheet remarks.
- State the defect on a red and white PCC (RAC-11) ([Appendix III](#)) and attach it to the container. With chalk, write on the container(s) "NOT FOR HUMAN CONSUMPTION."
- Container(s) CANNOT be reconditioned or Returned to Producer.
- Notify the Inspector-in-Charge or Supervisor of all deleterious material.

FLAVOR AND ODOR

The raisins should possess a normal and characteristic flavor and odor for each varietal type. If the raisins do not possess the normal characteristics, they should be certified as failing to meet requirements, indicating the specific reasons for failing. Consult your supervisor first.

[Electronic version of SC-416-8 Sanitation Score Sheet](#) (intranet link)

Inspection Instructions for Raisin Dehydrators (May 2026)

[Electronic version of SC-R105 Dehydrator Daily Inspection Record](#) (intranet link)

Inspection Instructions for Raisin Dehydrators (May 2026)

APPENDIX III – PALLET CONTROL CARDS

Red and White PCC

Form RAC11
**RAISIN ADMINISTRATIVE
 COMMITTEE**
**PALLET CONTROL CARD
 IDENTIFICATION**

DATE _____
 WORKSHEET NO. _____
 NO. CONTAINERS _____

U060265


 U060265

INFESTED ☐
Memo Storage ☐
 Card may be removed by plant
 employee at stemmer-hopper.

**PALLET CONTROL CARD
 OFF-GRADE RAISINS or
 UNINSPECTED RAISINS**


 U060265

U060265

Worksheet No. _____
**To be removed by U.S.D.A.
 personnel only**

Yellow PCC

Form RAC 11-B
**RAISIN ADMINISTRATIVE
 COMMITTEE**
**PALLET CONTROL
 CARD**
 Dehydrator

Date _____
 Dehydrator No. _____
 Pallet No. _____

Red PCC

Form RAC 11A
**RAISIN ADMINISTRATIVE
 COMMITTEE**
PALLET CONTROL CARD
 OFF-GRADE RAISINS
 or
 UNINSPECTED RAISINS

G 82501

DATE _____
 WORKSHEET NO. _____

NO. BOXES ☐ SWT
☐ BINS

**TO BE REMOVED BY USDA
 PERSONNEL ONLY**

APPENDIX IV – GRAM CONVERSION CHART

Gram Conversion Chart 16 oz. (1 lb.)

GM	%	GM	%	GM	%	GM	%	GM	%	GM	%	GM	%	GM	%	GM	%
0.1	0.1	2.6	0.6	5.1	1.1	7.6	1.7	10.1	2.2	12.6	2.8	15.1	3.3	17.6	3.9	20.1	4.4
0.2	0.1	2.7	0.6	5.2	1.1	7.7	1.7	10.2	2.2	12.7	2.8	15.2	3.3	17.7	3.9	20.2	4.4
0.3	0.1	2.8	0.6	5.3	1.2	7.8	1.7	10.3	2.3	12.8	2.8	15.3	3.4	17.8	3.9	20.3	4.5
0.4	0.1	2.9	0.6	5.4	1.2	7.9	1.7	10.4	2.3	12.9	2.8	15.4	3.4	17.9	3.9	20.4	4.5
0.6	0.1	3.1	0.7	5.6	1.2	8.1	1.8	10.6	2.3	13.1	2.9	15.6	3.4	18.1	4.0	20.6	4.5
0.7	0.2	3.2	0.7	5.7	1.3	8.2	1.8	10.7	2.4	13.2	2.9	15.7	3.5	18.2	4.0	20.7	4.6
0.8	0.2	3.3	0.7	5.8	1.3	8.3	1.8	10.8	2.4	13.3	2.9	15.8	3.5	18.3	4.0	20.8	4.6
0.9	0.2	3.4	0.7	5.9	1.3	8.4	1.9	10.9	2.4	13.4	2.9	15.9	3.5	18.4	4.1	20.9	4.6
1.0	0.2	3.5	0.8	6.0	1.3	8.5	1.9	11.0	2.4	13.5	3.0	16.0	3.5	18.5	4.1	21.0	4.6
1.1	0.2	3.6	0.8	6.1	1.3	8.6	1.9	11.1	2.4	13.6	3.0	16.1	3.5	18.6	4.1	21.1	4.6
1.2	0.3	3.7	0.8	6.2	1.4	8.7	1.9	11.2	2.5	13.7	3.0	16.2	3.6	18.7	4.1	21.2	4.7
1.3	0.3	3.8	0.8	6.3	1.4	8.8	1.9	11.3	2.5	13.8	3.0	16.3	3.6	18.8	4.1	21.3	4.7
1.4	0.3	3.9	0.9	6.4	1.4	8.9	2.0	11.4	2.5	13.9	3.1	16.4	3.6	18.9	4.2	21.4	4.7
1.5	0.3	4.0	0.9	6.5	1.4	9.0	2.0	11.5	2.5	14.0	3.1	16.5	3.6	19.0	4.2	21.5	4.7
1.6	0.4	4.1	0.9	6.6	1.5	9.1	2.0	11.6	2.6	14.1	3.1	16.6	3.7	19.1	4.2	21.6	4.8
1.7	0.4	4.2	0.9	6.7	1.5	9.2	2.0	11.7	2.6	14.2	3.1	16.7	3.7	19.2	4.2	21.7	4.8
1.8	0.4	4.3	0.9	6.8	1.5	9.3	2.0	11.8	2.6	14.3	3.1	16.8	3.7	19.3	4.3	21.8	4.8
1.9	0.4	4.4	1.0	6.9	1.5	9.4	2.1	11.9	2.6	14.4	3.2	16.9	3.7	19.4	4.3	21.9	4.8
2.0	0.4	4.5	1.0	7.0	1.5	9.5	2.1	12.0	2.6	14.5	3.2	17.0	3.7	19.5	4.3	22.0	4.8
2.1	0.5	4.6	1.0	7.1	1.6	9.6	2.1	12.1	2.7	14.6	3.2	17.1	3.8	19.6	4.3	22.1	4.9
2.2	0.5	4.7	1.0	7.2	1.6	9.7	2.1	12.2	2.7	14.7	3.2	17.2	3.8	19.7	4.3	22.2	4.9
2.3	0.5	4.8	1.1	7.3	1.6	9.8	2.2	12.3	2.7	14.8	3.3	17.3	3.8	19.8	4.4	22.3	4.9
2.4	0.5	4.9	1.1	7.4	1.6	9.9	2.2	12.4	2.7	14.9	3.3	17.4	3.8	19.9	4.4	22.4	4.9
2.5	0.6	5.0	1.1	7.5	1.7	10.0	2.2	12.5	2.8	15.0	3.3	17.5	3.9	20.0	4.4	22.5	5.0

APPENDIX V – SC-637: LABORATORY SAMPLE SUBMITTAL SHEET

[Electronic version of SC-637 Laboratory Sample Submittal Sheet](#) (intranet link)

U.S. DEPARTMENT OF AGRICULTURE AGRICULTURAL MARKETING SERVICE SPECIALTY CROPS PROGRAM LABORATORY SAMPLE SUBMITTAL SHEET		To	
APPLICANT		FROM	
RECEIVER		NO. OF SAMPLES	
		☐ Individual ☐ Individual to be composited Composite	☐ Original ☐ Reserve
PRODUCT	TYPE	STYLE	
ANALYSIS REQUESTED			
CONTRACT NO.	LOT NO.	SAMPLE NO.	
SPECIFICATION AND AMENDMENT	EFFECTIVE DATE	NO. AND TYPE OF CASES	
		NO. OF POUNDS	
RESULTS AND BILLING TO		SUBMITTED BY <i>(Inspector's Signature - Print and Sign)</i>	
		DATE SIGNED	
TO BE COMPLETED BY LAB			
DATE RECEIVED	LAB NO.	CONDITION OF SAMPLE	
SHIPPING METHOD			
RESULTS			
CHARGES	☐ MEETS ☐ FAILS <i>(If fails, explain below)</i>		
SUBCENTER NUMBER	ANALYZED BY <i>(Print and Sign)</i>		DATE SIGNED
SC-637			

APPENDIX VI – SC-R107: DEHYDRATOR MICRO LABELS

[Electronic version of SC-R107 Dehydrator Micro Labels](#) (intranet link)



United States
Department of
Agriculture

[Clear Form](#) [Save](#) [Print](#)

**SPECIALTY CROPS INSPECTION DIVISION
DEHYDRATOR MICRO LABELS**

DEHYDRATOR MICRO SAMPLE DEHYDRATOR _____ SAMPLE NO. _____ DATE _____ PALLET CARD NOS. _____ INSPECTOR _____	DEHYDRATOR MICRO SAMPLE DEHYDRATOR _____ SAMPLE NO. _____ DATE _____ PALLET CARD NOS. _____ INSPECTOR _____
DEHYDRATOR MICRO SAMPLE DEHYDRATOR _____ SAMPLE NO. _____ DATE _____ PALLET CARD NOS. _____ INSPECTOR _____	DEHYDRATOR MICRO SAMPLE DEHYDRATOR _____ SAMPLE NO. _____ DATE _____ PALLET CARD NOS. _____ INSPECTOR _____
DEHYDRATOR MICRO SAMPLE DEHYDRATOR _____ SAMPLE NO. _____ DATE _____ PALLET CARD NOS. _____ INSPECTOR _____	DEHYDRATOR MICRO SAMPLE DEHYDRATOR _____ SAMPLE NO. _____ DATE _____ PALLET CARD NOS. _____ INSPECTOR _____

SC-R107

APPENDIX VII – SC-R106: DEHYDRATOR SHIPPING REPORT

[Electronic version of SC-R106 Dehydrator Shipping Report](#) (intranet link)

 United States Department of Agriculture		Save Print Clear Form	
SPECIALTY CROPS INSPECTION DIVISION DEHYDRATOR SHIPPING REPORT			WSN:
PRODUCER		DEHYDRATOR	
VARIETY		SCALE TAG	
CONTAINERS	RE-INSPECT AFTER	NET WEIGHT	
INSP. DATE		LOAD STATUS	
SHIPPED TO PLANT NUMBER			
PCC			
RECEIVING USDA INSPECTOR (print and sign)			DATE
LAB RESULTS			
MOISTURE		TOTAL MOLD	RECEIVING COMMENTS
SUB STANDARD		MECHANICAL DAMAGE	
5 OR BETTER		EMBEDDED LEAVES	
COLOR		CARMELIZATION	
OFF COLOR		UNCURED BERRIES	
SULFUR (PPM)		SUNBURN	
OTHER		OTHER	
REMARKS			
GRADE			
OFFICE ADDRESS		SHIPPING USDA INSPECTOR (print and sign)	
2202 Monterey Street, Suite 102A Fresno, CA 93721			

SC-R106

Inspection Instructions for Raisin Dehydrators (May 2026)

APPENDIX VIII – SC-R43: SURVEILLANCE RECORD, EXAMPLE

[Electronic version of SC-R43 Surveillance Record](#) (intranet link)

 United States Department of Agriculture								
Surveillance Record								
Producer (a)			W/S No. or Lot No. (b)					
Scale Tag No. (c)		Net Wt. (d)		Ref. No. (e)		Orig. Ref. No. (f)		
Variety (g)			Defects (h)					
Number of Containers (i)		Date Reconditioning/Shipping (j)			Date Completed (k)			
Aide or Inspector (l)								
Action Taken (m)								
Pallet Card Numbers (n)								
Attached Pallet Card	Number	Container	Attached Pallet Card	Number	Container	Attached Pallet Card	Number	Container
1 (o)			24			47		
2			25			48		
3			26			49		
4			27			50		
5			28			51		
6			29			52		
7			30			53		
8			31			54		
9			32			(p) Residual		
10			33			Pallet Card Numbers	Number	Container
11			34					
12			35					
13			36					
14			37					
15			38					
16			39			(q) Held For	X	(r) Lab Results
17			40			Moisture		
18			41			Substandard		
19			42			B or B		
20			43			Mold		
21			44			Sand		
22			45			Damage		
23			46			Other		
Remarks								

SC-R43 USDA is an equal opportunity provider, employer, and lender.

APPENDIX IX – COLOR KEY

NATURAL CONDITION USE ONLY

KEY COLORS

- 1)** Yellow, Golden or Light Amber
- 2)** Greenish – Yellow
- 3)** Light Greenish Amber and Amber
- 4)** Dark Greenish Amber and Dark Amber
- 5)** Definitely Dark Berries

COLOR CLASSES

WELL COLORED

Not LESS than: 75 percent of 1
Not MORE than: 5 percent of 3, 4 & 5
½ percent of 5

REASONABLY WELL COLORED

Not LESS than: 90 percent 1 & 2
Not MORE than: 3 percent of 5

FAIRLY WELL COLORED

Not LESS than: 80 percent of 1, 2 & 3
Not MORE than: 6 percent of 5

COLORED

Not LESS than: 85 percent of 1, 2, 3 & 4
Not MORE than: 15 percent of 5