

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

***SAUSAGE PRODUCTS
SERIES 800***

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Institutional Meat Purchase Specifications

Sausage Products - Series 800

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1.0 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
Mechanical Tenderization
Aging

Grade and Special Requirements

State of Refrigeration (See IMPS GENERAL REQUIREMENTS.)

Chilled
Frozen

Fat Limitations

Portion Cut Weight, Thickness, and Shape Weight

Range

Netting and Tying

Packaging and Packing (See IMPS GENERAL REQUIREMENTS.)

Quality Assurance (See IMPS QUALITY ASSURANCE PROVISIONS.)

Method of examination
Acceptable Quality Levels (AQLs) Certification - (See IMPS GR and QAP.)

3.0 Ordering Data to be Specified by the Purchaser

Option	Shape	Option	State of Refrigeration
A	Rectangular	A	Chilled: 28 to 40°F (-2.2 to 5oC)
B	Round	B	Frozen: 0°F or Lower (-17.8oC)
Option	Class	Option	Cooking
A	Smoked	A	Baked
B	Unsmoked	B	Cooked
C	Browned in Hot Oil	C	Uncooked Fresh (No Cure Added)
		D	Uncooked Fermented (Cure Added)
Option	Casing	Option	Type
A	Artificial Casings (Inedible)	A	Unsliced
B	Hog or Sheep Casings, Linked (Natural)	B	Sliced (Purchaser Must Specify a Slice Count per Pound)
B1	Hog or Sheep Casings, Unlinked (Natural)	C	Patty
C	Skinless (Mechanically Formed)	D	Crumbles
D	Collagen Casings (Edible)	E	Linked
E	Cloth Bags	F	Bulk
F	Bulk		
Option	Patty Diameter		
A	2.0 inches (50 mm)		
B	2.5 inches (63 mm)		
C	3.0 inches (75 mm)		
D	3.5 inches (88 mm)		
E	4.0 inches (100 mm)		

Option	Major Ingredients	Option	Major Ingredients
A	Beef and pork in any combination	G	Pork
A1	Formula A plus nonfat dry milk and/or calcium-reduced dried skim milk	G1	Formula G plus nonfat dry milk and/or calcium-reduced dried skim milk
B	Beef, pork (beef is predominant)	G2	Pork, beef, pork heart meat (pork is predominant)
B1	Formula B plus nonfat dry milk and/or calcium-reduced dried skim milk	G3	Formula G2 plus nonfat dry milk and/or calcium-reduced dried skim milk
C	Pork, beef (pork is predominant)	G4	Pork, beef, veal (pork is predominant)

Option	Major Ingredients	Option	Major Ingredients
C1	Formula C plus nonfat dry milk and/or calcium-reduced dried skim milk	G5	Formula G4 plus nonfat dry milk and/or calcium-reduced dried skim milk
D	Beef	G6	Pork, veal (pork is predominant)
D1	Formula D plus nonfat dry milk and/or calcium-reduced dried skim milk	G7	Formula G6 plus nonfat dry milk and/or calcium-reduced dried skim milk
L	Formula, lower fat formulation	V	Pork livers, pork (pork liver is predominant)
P	Beef and turkey (beef is predominant)	V1	Formula V plus nonfat dry milk and/or calcium-reduced dried skim milk
P1	Beef and chicken (beef is predominant)	V2	Pork livers, pork with smoked jowls and/or bacon ends and pieces (pork liver is predominant)
P2	Pork and turkey (pork is predominant)	V3	Formula V2 plus nonfat dry milk and/or calcium-reduced dried skim milk
P3	Pork and chicken (pork is predominant)	X	Veal
H	Beef and pork in any combination plus beef heart meat	X1	Formula X plus nonfat dry milk and/or calcium-reduced dried skim milk
H1	Beef and pork in any combination plus any one or combination of beef tripe, beef heart meat, pork heart meat, beef tongue meat, and pork tongue meat	X2	Veal, pork (veal is predominant)
H2	Formula H1 plus nonfat dry milk and/or calcium-reduced dried skim milk	X3	Formula X2 plus nonfat dry milk and/or calcium-reduced dried skim milk
H3	Beef, beef heart meat (beef is predominant)	Y	Ham
H4	Beef, pork, beef heart meat (beef is predominant)	Y1	Formula Y plus nonfat dry milk and/or calcium-reduced dried skim milk

NOTE: Unless specifically authorized by the purchaser, use of artificial colors in the manufacture of any sausage item is not permitted.

3.1 Item Number, PSOs, & 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 Added Ingredients

The use of ingredients, method of addition, and product labeling shall comply with the Food Safety and Inspection Service's (FSIS) Regulations and Policies.

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

3.3 Fat Limitations

3.3.1 Fat Content Verification

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

Option No.	Fat Content
1	Fat content shall be declared on the product label along with a nutrition facts panel in accordance with FSIS regulations
2	Contractor shall 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 Patty Weight & Thickness

The purchaser shall 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 shall 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)

Portion Weight Tolerances		
Specified Weight	Weight Tolerance	Thickness Uniformity*
Less than 6.0 ounces (170 g)	+/- ¹ / ₄ oz. (7 g)	³ / ₁₆ -inch (5 mm)
6.0 (170 g) to 12.0 ounces (340 g)	+/- ¹ / ₂ oz.(14 g)	¹ / ₄ -inch (6 mm)
12.01 (341 g) to 24.0 ounces (680 g)	+/- ³ / ₄ oz.(21 g)	³ / ₈ -inch (9 mm)
24.01 ounces (681 g) or more	+/- 1 oz. (28 g)	¹ / ₂ -inch (13 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 patty.

3.4.2 Shape

Unless otherwise specified, patties shall be round and uniform in size. Patty diameter must be +/- ¹/₂-inch (12 mm) of the specified diameter.

3.5 Weight Range

Purchaser shall specify IMPS item number, product name, and weight range to be purchased. The following weight ranges are intended as guidelines. Other weights or ranges may be specified.

Weights for canned luncheon meat reflect their drained weight. Draining must be accomplished on a conventional rack or shelf; and, at the time of weighing, the product shall be practically free of dripping pickle.

<u>Item #</u>	<u>Product Name</u>	<u>Suggested Weight Range</u>	<u>Page #</u>
800	Frankfurters	4, 6, 8, 10, or 12 Links per Pound	15
801	Bologna	1 to 12 Pound Units 16, 18, 20, or 25 Slices per Pound	15
802	Pork Sausage	1, 2, 3, 4, 5, or 6 Pound Rolls 6, 8, 10, 12, 14, or 16 Links per Pound 2, 3, 5, or 7 Pound Bags 5, 6, 7, 8, 9, 10, or 12 Pound Units	15
802A	Pork Sausage, Patties	2.5 or 3 Ounce Patty	15
802B	Pork Sausage, Fully-Cooked	1.5 or 2 Ounce Patty 2, 3, 5, or 7 Pound Bags	15
802C	Whole Hog Pork Sausage	1, 2, or 3 Pound Rolls 6, 8, 10, 12, 14, or 16 Links per Pound 2, 3, 5, or 7 Pound Bags 5, 6, 8, or 10 Pound Units 1.5, 2, 2.5, or 3 Ounce Patty	16
803	Liver Sausage	5 to 8 Pounds	16
804	Cooked Salami	7 to 12 Pounds 16, 18, 20, or 25 Slices per Pound	16
805	Minced Luncheon Meat	5 to 10 Pounds 16, 18, 20, or 25 Slices per Pound	17
806	Lebanon Bologna	5 to 10 Pounds 16, 18, 20, or 25 Slices per Pound	17
807	Thuringer	4 to 8 Pounds 18, 20, 25, or 30 Slices per Pound	17
808	Dry Salami	2 to 5 Pounds 20, 25, or 30 Slices per Pound	17
809	Cervelat	2 to 5 Pounds 20, 25, or 30 Slices per Pound	18
810	Breakfast Sausage	1, 2, or 3 Pound Rolls 8, 10, 12, 16, or 19 to 21 Links per Pound 5, 6, 7, 8, or 10 Pound Units	18
811	Smoked Sausage	6, 8, 10, 19-21, or 48-51 Links per Pound	18
812	New England Brand Sausage	5 to 10 Pounds 16, 18, 20, or 25 Slices per Pound	18
813	Polish Sausage	3 to 5 or 11 to 13 Inches in Length	19
814	Meat Loaves	4 to 8 Pound Loaves 16, 18, 20, or 25 Slices per Pound	19
815	Meat Food Product Loaves	4 to 8 Pound Loaves 16, 18, 20, or 25 Slices per Pound	19
816	Knockwurst	5, 6, 7, or 8 Links per Pound	20
817	Breakfast Sausage, Fully-Cooked	19 to 21 Links per Pound	20

<u>Item #</u>	<u>Product Name</u>	<u>Suggested Weight Range</u>	<u>Page #</u>
818	Italian Sausage	4, 6, 7, or 8 Links per Pound 1, 5, 6, 8, or 10 Pound Units 2, 2.5, or 3 Ounce Patty	21
819	Ham Links	14 to 15 Links per Pound	21
820	Head Cheese	4 to 8 Pounds 16, 18, 20, or 25 Slices per Pound	21
821	Pepperoni	1 to 2 Pound Sticks 10 to 15 Slices per Ounce	21
822	Bratwurst	4, 6, 7, or 8 Links per Pound	22
822A	Bratwurst Patty	2.5 or 3 Ounce Patty	22
824	Pork Rib Shape Patty	3.0, 4.0, or 5 Ounce Patty	22
825	Canned Luncheon Meat	30 Ounce or 6 Pound Cans	23
826	Scrapple	1, 5, or 10 Pounds	23
827	Capocollo, Fully-Cooked		24
828	Summer Sausage		24
829	Genoa Salami	2 to 5 Pounds	24
830	Mortadella		25

3.6 Packaging & Packing

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

3.7 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 and Verification

4.1 Contact Information

When requested, the purchaser shall specify within a contract or purchase order that product shall be certified or that the producer is operating under an approved IMPS Process Verified Program by the USDA, AMS, LP, SSD. The IMPS QAP, <https://www.ams.usda.gov/sites/default/files/media/QualityAssuranceProvisionsIMP S.pdf>

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

USDA, AMS, LP Program
1400 Independence Ave, SW, Room 3932, Stop 0258

5.0 Material Requirements

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

Presence of one or more of any of the following conditions shall cause rejection of the involved production lot.

- Product that exhibits any evidence of being moldy (note exception to dry and semi-dry sausage), stale, slimy, oily, sticky, sour, or discolored.
- Product not of the meat formula, color, style, class, or state of refrigeration as specified by the purchaser.
- Nonformula ingredients not as specified.
- Presence of foreign flavor (e.g., moldy, sour, or stale).
- Presence of foreign odor (e.g., acidic, putrid, stale, sour, or rancid).
- Presence of foreign material.

Determination of wholesomeness and acceptability of meat with respect to the presence of foreign material (e.g., glass, dirt, insect parts, hair, wood, or metal) must be made by FSIS personnel.

6.0 Quality

6.1 Excellent Condition

Product items must contain only those kinds of meats specified by the purchaser and must reflect the appropriate style, formula, shape, weight range, and state of refrigeration (as applicable). Amounts and kinds of all ingredients must be within the tolerances permitted by the applicable USDA FSIS inspection regulations.

As applicable, curing, cooking, smoking, and flavoring of product must be typical of the particular kind of product being produced. The color and aroma of the finished sausage item must also be characteristic of the product being produced. For example, there must be no evidence of greening, streaking, or other discoloration (a slightly two toned or iridescent color is permissible). Product must be practically free from bone, cartilage, string, air holes, pockets of moisture, fat caps, rendered fat, gelatin caps, and must be totally free from odor or flavor foreign to the product, including, acidic odor, rancidity, mold (dry and semi-dry

sausage items may not have more than a very slight amount of "dry" surface mold present except for those products characterized by surface mold), or any other deterioration or damage. In addition, sliced product must be free of all casing material. Product must show no evidence of having been frozen and defrosted or otherwise mishandled in any way.

6.2 Workmanship

Smoked Products

Smoked products must have an acceptable flavor and aroma, fairly bright uniform smoked color, and be practically free of extraneous material, including encrusted salt and smokehouse residue (except the natural smoke color). The product must be fairly dry on the exterior of the casing but not scorched. Except for loaf items, smoke flavoring or artificial smoke flavoring is permissible in lieu of smoking unless otherwise specified by the purchaser.

6.3 Ingredient/Formula Certification

Ingredient/Formula Certification

Ingredient and meat content verification of sausage products in this specification, except as otherwise stated, must be the responsibility of FSIS personnel. However, the purchaser and/or AMS agent reserve the right at any time to verify the ingredients and/or meat species included in the sausage item(s) using approved testing methods.

IMPORTANT NOTE: The product name of combination red meat and poultry formulated sausage items must be labeled as follows:

<u>Formula</u>	<u>Labeling Requirement</u>
P	Beef and Turkey IMPS NAME (Frankfurter, etc.)
P1	Beef and Chicken IMPS NAME (Bologna, etc.)
P2	Pork and Turkey IMPS NAME (Salami, etc.)
P3	Pork and Chicken IMPS NAME (Frankfurter, etc.)

EXAMPLE - If the purchaser wishes to purchase an IMPS 802 Bologna formula P2, the product would be labeled:

IMPS No. 802, Pork and Turkey Bologna

Lower Fat Formulations

In the interest of providing a lower fat formulation option for the institutional purchaser, **Formula L** in this 800 Series document is listed for several different sausage items. If the purchaser desires to purchase a particular sausage item with a lower fat content, the following procedures shall be followed:

(1) Specify the individual IMPS Item to be produced that has a Formula L option included. (EXAMPLE: IMPS Item 800)

(2) Specify Formula L on the contract or purchase order.

(3) Specify one additional meat or meat and poultry formula from those listed in each item description that is to be manufactured with a lower fat content. (EXAMPLE: The purchaser would select Formula L initially and then select the desired meat or meat and poultry ingredient such as formula A or B or C, etc., from those listed with each item). **If the purchaser should fail to specify the meat or meat and poultry component to be used in Formula L, the meat ingredient must be all beef.**

(4) Total fat content of the finished sausage item being produced for Formula L must not exceed 20 percent regardless of the meat or meat and poultry component specified by the purchaser. The purchaser may specify a maximum fat limitation lower than 20 percent and may also specify discount ranges.

(5) Any additional ingredients used in **Formula L** (soy, carrageenan, etc.) may be specified or disallowed by the purchaser and must be formulated and identified in the ingredients statement in accordance with all FSIS regulations. For IMPS, regardless of the sausage item being produced, the maximum amount of added ingredients must not exceed **30 percent** of the formula.

(6) Product produced as Formula L must be labeled as follows:

IMPS ITEM NAME, X% ADDED INGREDIENTS

(X= no more than 30%)

EXAMPLE: **Frankfurter, 25% Added Ingredients** (see IMPS General Requirements for additional container marking criteria)

(7) The fat content must be determined at an FSIS-approved and certified laboratory designated by the vendor. The vendor is responsible for supplying official documentation of the fat analysis results of each production lot to the purchaser.

Alternatively, if the purchaser wishes the analytical content to be certified by USDA AMS, the purchaser MUST specify that option in the contract or purchase order. When the purchaser requests fat content to be certified by USDA, an average sample must be drawn by the AMS agent and shall be sent to the USDA AMS laboratory for fat analysis.

NOTE: Detailed sampling procedures and defect applications are specified in the **IMPS QAP**.

Spices and Seasonings

When a spice, or seasoning is specifically required within the individual item description, that particular seasoning or ingredient must be **individually depicted** on the manufacturers label of ingredients.

6.4 Curing, Thermal Processing & Standards of Identity

FSIS regulates the amount of nitrite allowed in cured products and thermal processing of fully-cooked products.

FSIS regulates standards of identity through labeling

<u>Code of Federal Regulations</u>	<u>Item No.</u>
9 CFR 319.141	802
9 CFR 319.143	810
9 CFR 319.145	818
9 CFR 319.180	800, 801, 816
9 CFR 319.182	803
9 CFR 319.260	825
9 CFR 319.261	814, 815
9 CFR 319.280	826

7.0 Item Descriptions

7.1 Foodservice Item Descriptions

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

ORDERING DATA: OPTIONS AND FORMULA DESIRED MUST BE SPECIFIED BY THE PURCHASER WITHIN THE CONFINES OF STANDARDS OF IDENTITY ALREADY ESTABLISHED BY THE CODE OF FEDERAL REGULATIONS AND FSIS.

Item No. 800 – Frankfurters – Frankfurters are a smoked, cooked, and linked sausage. Frankfurters must be less than 30 percent fat and must not contain more than 40 percent of a combination of fat and added water. Frankfurters may be skinless or stuffed in sheep or collagen casings. The red meat or red meat and poultry components must be very finely comminuted. The interior cut surface must be smooth, fine-textured, light to moderately dark pink in background color,

and finely mottled with evenly distributed light to dark red flecks. Frankfurters must have a fine smooth exterior surface that is free of splits, cracks, casing material, and must be uniform in length and diameter. Links must be 5 to 6 inches (12.7 to 15.2 cm) in length. This product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 801 – Bologna – Bologna is a smoked, cooked sausage. Bologna must be less than 30 percent fat and must not contain more than 40 percent of a combination of fat and added water. The red meat or red meat and poultry components must be very finely comminuted and stuffed into artificial or natural casings. The interior cut surface is smooth, fine-textured, light to moderately dark pink in background color, and finely mottled with evenly distributed light to dark red flecks. Sticks must have a uniform diameter measuring from 4 to 5 inches (10.2 to 12.7 cm). The 1 to 1½ pound (0.5 to 0.7 kg) size must be ring style. This product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 802 – Pork Sausage – Pork sausage is a fresh all-pork product that is grayish-pink to grayish light red in color. This product does not include pork cheeks. Pork sausage has 50 percent fat or less and up to 3 percent added water. The meat is chopped or ground to a moderately coarse texture and thoroughly blended and mixed with salt and spices. Pork sausage may be packed in bulk, formed mechanically, or stuffed in artificial or natural casings. The links, rolls, and bags must be moderately uniform in length and diameter. For product in unlinked hog or collagen casings, no more than one piece must be less than 12 inches (30.5 cm) in length in a primary container.

Item No. 802A – Pork Sausage Patties – This item is as described for Item 802 except that the fresh pork sausage must be ground or chopped and, unless otherwise specified by the purchaser, mechanically formed into approximately round 4 inches (10.2 cm) diameter patties. The finished product must be uniform in weight, thickness, and diameter.

Item No. 802B – Pork Sausage, Cooked – This item is as described for Item 802 or 802A except that the pork sausage must be fully-cooked. The cooked pork sausage may be produced either as a patty or crumbled for use as a pizza topping, whichever is specified by the purchaser. If this item is produced as a cooked patty, specific diameter size requirements specified for Item 802A do not apply. However, the finished cooked patties must be required to be uniform in thickness and diameter. **NOTE:** The particular type selected by the purchaser must follow the IMPS name (EXAMPLE: Pork Sausage, Cooked, Crumbles). This product must conform to applicable regulatory requirements for thermal processing.

Item No. 802C – Whole Hog Pork Sausage – This item is as described for Item 802, 802A or 802B except that it must contain all of the primal parts of the hog in

natural proportions (controlled by FSIS personnel). Meat by-products (heart, tongue, etc.), which otherwise must be declared in the ingredient statement, are not to be authorized in this item. Unless otherwise specified by the purchaser, the product (except for crumbles that must be cooked) must be uncooked and bulk packed into 10 pound (4.5 kg) units. **NOTE:** The particular type and cooking option (when applicable) selected by the purchaser shall follow the IMPS name (EXAMPLE: Whole Hog Pork Sausage, Links, Cooked). If this item is cooked, it must conform to applicable regulatory requirements for thermal processing.

Item No. 803 – Liver Sausage (Braunschweiger) – Liver sausage is a cooked sausage with a smoked characteristic (a smoked characteristic may be imparted by smoking, by adding smoked meats to the formula, or a combination of both). Onion must be included as a seasoning. The meat components consist of pork with smoked jowls and/or bacon ends included in some formulas. These are combined with at least 30 percent pork, beef, and/or veal livers, less than or equal to 10 percent water, and very finely comminuted and stuffed in artificial or natural casings. The interior cut surface is smooth, fine-textured, and light reddish-brown in color. Unless otherwise specified by the purchaser, sticks must have a uniform diameter measuring from 2 to 3 inches (5.1 to 7.6 cm) and must weigh from 5 to 8 pounds (2.3 to 3.6 kg). This product must conform to applicable regulatory requirements for thermal processing.

Item No. 804 – Salami, Cooked – Cooked salami is a smoked, cooked sausage. Seasonings, unless otherwise specified, must include garlic and whole black peppercorns (at least a portion of a peppercorn must be in evidence on either sliced surface). The meat components consist of moderately coarse-cut pork and finely comminuted beef with finely comminuted beef heart meat included in some formulas. Alternatively, a moderately coarse-cut beef or red meat and poultry formulation may be specified. The interior cut surface is moderately coarse in texture and light to dark reddish-brown in color. Salami is stuffed in artificial casings and has a moisture protein ratio of 1.9:1 or less. Salami has a uniform diameter measuring from 3½ to 4½ inches (8.9 to 11.4 cm) (unless otherwise specified by the purchaser). Sticks must weigh from 7 to 12 pounds (3.2 to 5.4 kg) and must be moderately uniform in length. This product must conform to applicable regulatory requirements for thermal processing.

Item No. 805 – Minced Luncheon Meat – Minced luncheon meat is a smoked, cooked sausage. The meat components consist of moderately coarse-cut pork and finely comminuted beef with pork heart meat included in some formulas. The interior cut surface is moderately fine-textured and light pink in color. The product is stuffed into artificial casings. The finished product must be uniform in diameter. Stuffed round casings must measure from 3½ to 4½ inches (8.9 to 11.4 cm) in diameter (unless otherwise specified by the purchaser). When the stuffed casings are formed into rectangular shapes by wire or metal molds, they must measure from 3 to 4 inches (7.6 to 10.2 cm) in width and depth (unless otherwise specified by the purchaser). Product must weigh from 5 to 10 pounds (2.3 to 4.5 kg). This

product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 806 – Lebanon Bologna – Lebanon bologna is a "semi-dry," smoked, uncooked, all beef sausage. Lebanon bologna must be less than 30 percent fat and may not contain more than 40 percent of a combination of fat and added water. No binder, extenders, or hearts are permitted. The product has a characteristically sharp (fermented) flavor. The meat component is finely comminuted beef stuffed in artificial casings. The interior cut surface is fine-textured and exhibits a uniform dark reddish-brown background color with fine particles evenly distributed. A very slight amount of dry surface mold is natural on this product and may be present on this item. The finished product must be uniform in diameter. If the moisture to protein ratio is 3.1:1 with a pH of 5.0 or less, no refrigeration is required. Sticks are from 3½ to 4½ inches (8.9 to 11.4 cm) in diameter (unless otherwise specified by the purchaser) and must weigh from 5 to 10 pounds (2.3 to 4.5 kg).

Item No. 807 – Thuringer – Thuringer is a "semi-dry," smoked, uncooked, or cooked sausage. The product has a characteristically sharp (fermented) flavor. The interior cut surface is moderately coarse-textured and has a uniform dark reddish-brown color. No binders or extenders are permitted. Thuringer is stuffed in artificial casings and has a moisture protein ratio of 3.7:1. When stuffed, sticks measure from 2½ to 3½ inches (6.4 to 8.9 cm) in diameter (unless otherwise specified by the purchaser). Sticks must weigh from 4 to 8 pounds (1.8 to 3.6 kg). The finished product shall be uniform in diameter. This product must conform to applicable regulatory requirements for thermal processing.

Item No. 808 – Dry Salami – Dry salami is a uncooked, "dry" sausage. The meat components consist of moderately coarse-cut beef with moderately coarse-cut pork and/or beef heart meat included in some formulas. The product seasoning includes garlic. The interior cut surface is firm, moderately coarse-textured with a uniform distribution of white fat particles throughout a medium to dark reddish-brown background color. A very slight amount of dry surface mold is natural on this product and may be present on this item. Dry salami is stuffed in artificial or natural casings with a moisture protein ratio of 1.9:1 or less. Dry salami should measure from 2 to 3 inches (5.1 to 7.6 cm) in diameter (unless otherwise specified by the purchaser) and is processed to produce a firm, hard product. Sticks must weigh from 2 to 5 pounds (0.9 to 2.3 kg). The finished product must be uniform in diameter. This product must conform to applicable regulatory requirements for curing and microbial safety of dry sausage.

Item No. 809 – Cervelat – Cervelat is a cured and cooked sausage that is often "semi-dry," or "dry" sausage. The meat components consist of finely comminuted beef and pork. The interior cut surface is fine-textured and exhibits a uniform medium to dark reddish-brown color. A very slight amount of dry surface mold is natural on this product and may be present on this item. Cervelat is stuffed in

artificial or natural casings and is processed to produce a firm product. Sticks measure from 1½ to 2 inches (3.8 to 5.1 cm) in diameter (unless otherwise specified by the purchaser) and must weigh from 2 to 5 pounds (0.9 to 2.3 kg). The finished product shall be uniform in diameter. This product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 810 – Breakfast Sausage – Breakfast sausage is a fresh product that may or may not be frozen. The meat components consist of predominately pork with smaller amounts of beef and/or veal. Alternatively, an all-beef or red meat and poultry formulation may be specified. The meat is chopped or ground to a moderately coarse texture. Breakfast sausage must have less than 50 percent fat and 3 percent added water. Breakfast sausage may be packed in bulk or stuffed in a collagen or hog casings. The links and rolls are moderately uniform in length and diameter. For product in unlinked hog or collagen casings, no more than one piece must be less than 12 inches (30.5 cm) in length in a primary container.

Item No. 811 – Smoked Sausage – Smoked sausage is a smoked, cooked, linked sausage. The meat components consist of all pork or pork and beef with beef tripe, beef and pork heart meat, and beef and pork tongue meat included in some formulas. The meat is chopped or ground to a moderately coarse texture. The interior cut surface is moderately coarse in texture (formulas D and D1 may be moderately fine-textured). Smoked sausages are either skinless or stuffed in hog or collagen casings and are moderately uniform in length and diameter. This product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 812 – New England Brand Sausage – New England Brand sausage is a smoked, cooked sausage. The meat components consist predominately of pork chunks with a small amount of finely comminuted beef. The texture of the interior cut surface is variable, 70 to 80 percent of the area consists of pork chunks, and the remaining portion is fine-textured. The product is stuffed in artificial or natural casings with a uniform diameter of between 3½ to 4½ inches (8.9 to 11.4 cm) (unless otherwise specified by the purchaser). Individual sausages must weigh from 5 to 10 pounds (2.3 to 4.5 kg). This product must conform to applicable regulatory requirements for thermal processing.

Item No. 813 – Polish Sausage – Polish sausage is a smoked, cooked, linked sausage. The meat components consist of moderately coarse-cut pork, moderately coarse-cut pork with finely comminuted beef, or beef and veal. Alternatively, a moderately coarse-cut beef or red meat and poultry formulation may be specified. The interior cut surface is moderately coarse in texture with a uniform distribution of light colored particles throughout a medium to dark reddish-brown background color. Seasonings must include garlic. The product is stuffed in hog casings or equivalent diameter collagen casings (specified by the purchaser). Links must be moderately uniform in length and diameter. Links must be 3 to 5 inches (7.6 to 12.7 cm) long (unless otherwise specified by the

purchaser). This product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 814 – Meat Loaves – Meat loaves are baked (dry heat) or cooked (moist heat) products (as specified). The meat components are finely comminuted and may be rectangular or rounded in shape. Less than or equal to 3 percent added water is permitted in this product. The exterior surface may be smoked, unsmoked, or browned in hot oil. The interior cut surface is smooth, fine-textured, light pink in background color, and finely mottled with evenly distributed light to dark red flecks. Meat loaves must weigh from 4 to 8 pounds (1.8 to 3.6 kg). The individual loaves are encased or wrapped in grease and moisture resistant paper or plastic film. The finished product must be uniform in diameter. This product must conform to applicable regulatory requirements for thermal processing.

Item No. 815 – Meat Food Product Loaves – Meat food product loaves are baked (dry heat) or cooked (moist heat) products. Beef, pork, and veal may be used singularly or in any combination. Other ingredients, such as meat by-products, pickles, pimentos, cheese, nuts, etc., are added as applicable except that lungs, spleens, tripe, udders, blood, skin, cracklings, brains, lips, ears, snouts, kidneys, tongue trimmings, and meat and meat by-products from lamb, yearling mutton, mutton, and goats must not be used in preparing the loaf. Nonfat dry milk and/or calcium reduced dried skim milk may be added. The exterior surface may be smoked, unsmoked, or browned in hot oil. The other ingredients, pimento, pickle's, olive's, cheese, pepper, etc., (actual ingredients are to be identified and controlled by FSIS personnel) as applicable, must be of a quantity and size large enough to be easily distinguished at the cut surface and must be reasonably well distributed throughout the item. Pimento juice, pickle juice, olive juice, etc., must not be substitutable for the fruit itself. The individual loaves must be encased or wrapped in grease and moisture resistant paper or plastic film. Individual loaves must weigh from 4 to 8 pounds (1.8 to 3.6 kg). The finished product must be uniform in diameter. This product must conform to applicable regulatory requirements for thermal processing.

Meat food product loaves must be specified by name (for example: pickle loaf, ham and cheese loaf, etc.). Any meat food product loaf not listed below may be ordered. However, if the name is inadequate to appropriately identify the product, the purchaser may be requested to furnish additional information to establish a definite basis for identification.

Formula (major condiment ingredients)

- A. Pimento Loaf (sweet red peppers are not substitutable)
- B. Pickle and Pimento Loaf
- C. Pickle Loaf
- D. Olive Loaf (use of stuffed olives is not acceptable)

- E. Pepper Loaf (contains cracked black pepper)
- F. Cheese Loaf
- G. Macaroni and Cheese Loaf
- H. Liver Loaf
- I. Pickle and Pimiento Loaf (sweet red peppers)

Item No. 816 – Knockwurst – Knockwurst is a smoked, cooked, linked sausage. The meat components consist of very finely comminuted beef or beef and pork. Alternatively, a red meat and poultry formulation may be specified. The interior cut surface is smooth, fine-textured, and light to moderately dark pink in color (not artificially colored). Knockwurst must be less than 30 percent fat and must not contain more than 40 percent of a combination of fat and added water. Knockwurst may be either skinless or stuffed into hog or collagen casings (as specified by the purchaser). The links must be moderately uniform in length and the diameter shall be 4 to 5 inches (10.2 to 12.7 cm) in length. This product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 817 – Breakfast Sausage, Cooked – Breakfast sausage is a cooked, linked sausage. Antioxidants and no more than 3 percent added water are permitted in this product. The meat components consist of moderately coarse-cut pork and/or beef. Alternatively, a moderately coarse-cut red meat and poultry formulation may be specified. The interior cut surface is moderately coarse in texture. The links must either be skinless or stuffed into collagen casings (as specified by the purchaser) and must be uniform in length and diameter. This product must conform to applicable regulatory requirements for thermal processing.

Item No. 818 – Italian Sausage – Italian sausage is a fresh, uncooked, linked product (unless otherwise specified). Italian sausage contains fennel, anise, or a combination of the two. The meat components must be chopped or ground to a moderately coarse texture. The sausage itself (or interior cut surface of links) is moderately coarse in texture with a uniform color ranging from medium to dark reddish-brown with evenly distributed fat particles. Unless otherwise specified by the purchaser, the sausage shall be flavoring style B. The links (unless otherwise specified) must be in a natural hog or collagen casing 5 to 6 inches (12.7 to 15.2 cm) in length. Links must be moderately uniform in length and diameter. Patties must be uniform in diameter. NOTE: The particular type and cooking option (when applicable) selected by the purchaser must follow the IMPS name (EXAMPLE: **Italian Sausage, Crumbles, Cooked**).

FLAVORING A – Hot (Must contain crushed or ground red pepper and ground coriander in the formula)

B – Mild (NO crushed or ground red pepper or ground coriander in the formula)

C – Sweet (Contains increased amounts of sugar or sweetener)

Item No. 819 – Ham Links – Ham links are a smoked, fully-cooked, linked, skinless sausage. The meat components consist of chopped or ground ham or ham trimmings exhibiting a moderately fine-textured internal appearance. The interior cut surface is light pink to light red in color with darker pinkish-red particles distributed throughout. Links must have a fine smooth exterior surface 4 to 5 inches (10.2 to 12.7 cm) in length. The links must be uniform in length and diameter. This product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 820 – Head Cheese – Head cheese is a cooked product. The meat components may consist of all pork head meats or predominately pork head meats with pork, cured pork, and/or other pork by-products included, except that ears, livers and spleens are prohibited. The meat is coarse-cut to fine-cut. Onion must be included as a seasoning. Head cheese may have gelatin added. The interior cut surface is resilient and very coarse-textured with an even distribution of ingredients. The finished product is stuffed in artificial or natural casings or molds and must weigh from 4 to 8 pounds (1.8 to 3.6 kg) with a uniform diameter. This product must conform to applicable regulatory requirements for thermal processing.

Item No. 821 – Pepperoni – Pepperoni is a moderately coarse-textured "dry" sausage prepared from pork or pork and beef. Pepperoni must contain no extenders, binders, or by-product.

The interior cut surface is moderately coarse in texture with a uniform color ranging from medium to dark brownish-red. A very slight amount of dry surface mold is natural on this product and may be present on this item. Pepperoni is processed to produce a firm, hard product that is moderately uniform in length and diameter. Pepperoni must have a moisture protein ratio of 1.6:1 or less. Unless otherwise specified by the purchaser, the sticks must measure 1½ inches (2.5 cm) to 2 inches (5.1 cm) in diameter. This product must conform to applicable regulatory requirements for curing and microbial safety of dry sausage.

Item No. 822 – Bratwurst – Bratwurst may either be a cooked or an uncooked (as specified) link sausage. The meat components may range from fine to slightly coarse comminuted pork, veal, pork and beef, or veal and pork. Alternatively, a fine to slightly coarse comminuted red meat and poultry formulation may be specified. Spices must include garlic. The interior cut surface is fairly smooth and light to pale pink in color. The interior cut surface of cooked bratwurst is a light to pale gray color. Bratwurst is either skinless or stuffed into natural or collagen casings (as specified by the purchaser). The links must be uniform in length and diameter. Unless otherwise specified by the purchaser, the links must be uncooked and 4½ to 5½ inches (11.4 to 14 cm) in length. If a cured and/or cooked version is specified, it must conform to applicable regulatory requirements

for curing and/or thermal processing.

Item No. 822A – Bratwurst Patty – This item is as described for Item 822 except that the bratwurst, instead of being formed into a link, must be mechanically formed into round 2 to 4-inch (50 - 100 mm) (unless otherwise specified) diameter patties. If this item is produced as a cooked patty, diameter size requirements specified do not apply. The finished product must be uniform in weight, thickness, and diameter. Cooked patty specifications match those described in 802B. If a cured and/or cooked version is specified it must conform to applicable regulatory requirements for curing and/or thermal processing.

Item No. 824 – Pork Rib Shape Patty – Fresh, uncured, boneless pork must be ground one (1) time only through a ¼ inch (6.35 mm) plate, mixed with the appropriate seasonings (if specified), and mechanically formed to give the appearance, consistency, and texture of a natural rib slab with rib protrusions. Alternatively, the item may be produced using any FSIS-approved and labeled restructuring method that will yield an acceptable end item that exhibits the appearance, consistency, and texture of a natural rib slab. The texture of this item must be moderately coarse and must be light pink to light red in color. If desired, the purchaser may further specify the shape dimensions of this item. The fat content must not exceed 25 percent, which must be determined at a FSIS approved and certified laboratory designated by the vendor who must supply official documentation of the fat analysis results of each production lot to the purchaser.

Alternatively, if the purchaser wishes the analytical content to be certified by USDA AMS, the purchaser MUST specify that option in the contract or purchase order. When the purchaser requests that the fat content to be certified by USDA, an average sample must be drawn by the AMS agent and sent to the USDA AMS laboratory for fat analysis.

Item No. 825 – Canned Luncheon Meat – Carcass pork and/or beef must be the only meat ingredients used and must be chopped or ground slightly coarse to moderately coarse in texture. The finished product must have good cohesion and hold together as an intact unit when removed from the can. The product, depending on the formulation, must have a uniform color ranging from pink to reddish-brown. (Slight variation between internal and external surfaces is permitted). Fat must not cover more than 10 percent of the outer core surface. Hearts, tongues, and other variety meat items must not be allowed. Other ingredients (salt, curing ingredients, sweetening agents, spices, flavorings, etc.) must be as allowed under FSIS regulations.

The filled cans must be vacuum sealed and thermally processed.

Unless otherwise specified, the fat content of the product must not exceed 25 percent. The purchaser may specify discount ranges in the procurement data.

Unless otherwise specified, the salt content of the product must not exceed 1½ percent.

End Item Examination – Product having an internal temperature of 50 to 80°F (10 to 26.7°C) must be randomly selected for an end item examination. For examination, each sample core must be removed from the can intact and examined in accordance with the QAP Table 800D. The sample core must be divided into four (4) approximately equal pieces by three (3) straight cuts perpendicular to the cutting table surface and at an approximate right angle to the core length. The three right hand cut surfaces must be evaluated for all applicable defects listed in the IMPS QAP. If specified by the purchaser, a net weight examination of the filled cans shall be performed. For detailed sampling procedures, see the IMPS QAP.

All cans of product within each lot must bear identical can code markings to make them distinguishable from cans of product in other lots.

Cans. Cans must be commercially acceptable, open-top style, coated with enamel (or other suitable material) inside and outside, and hermetically sealed. One of the following can sizes must be specified by the purchaser:

<u>Net Weight</u>	<u>Size</u>	<u>Shape</u>
30 ounces (850 g)	400 x 411	Cylindrical
30 ounces (850 g)	404 x 404	Cylindrical
6 pounds (2.72 kg)	400 x 400 x 1110	Rectangular
6 pounds (2.72 kg)	402 x 314 x 1200	Rectangular
6 pounds (2.72 kg)	402 x 310 x 1204 to 1210	Rectangular

Item No. 826 – Scrapple – Scrapple is prepared from meats (either pork or beef as specified by the purchaser) and meat by-products, with conventional flavorings/spices and a flour and broth base. Scrapple must be at least 40 percent meat and/or meat by-products. Scrapple must not contain ears, lungs, udders, kidneys, spleens, brains, tongue, cracklings, or cured product. The interior cut surface must be smooth and fine-textured with light to dark flecks and pieces evenly distributed across a moderate to dark grayish-pink background. The finished product must be molded and packaged into a rectangular shape (unless otherwise specified) and must be moderately firm and stable to permit customary slicing.

Item No. 827 – Capocollo, Cooked – A cured and cooked product processed from a pork but that meets the requirements for Item No. 407 Pork Shoulder Butt, Cellar Trimmed, Boneless. The curing process may be by dry curing, immersion

curing, or pump curing. The cured product is coated with spices and paprika before cooking. This product must always be labeled with “Cooked” as part of the product name. The product may be produced and labeled as water-added product if desired. A number of different spellings exist for Capocollo. This product must conform to applicable regulatory requirements for curing and thermal processing.

Item No. 828 – Summer Sausage – Summer Sausage is a fanciful name given to a number of semi-dry or cooked sausages. This derives from the fact that these sausages were originally prepared in the winter for use in the summer. It may be produced from a variety of meat and meat by-product ingredient formulas such as those allowed in other semi-dry or cooked products. By definition, however, Summer Sausage may also include extenders if so desired. Summer Sausage in many cases is a fermented product that displays characteristics similar to Thuringer and Cervelat. This product must conform to applicable regulatory requirements for thermal processing.

Item No. 829 – Genoa Salami – A type of semi-dry salami made primarily from finely chopped pork with some added pork fat, a small amount of beef, and seasonings. Genoa Salami has a moisture protein ratio 2.3:1. This and similar types of salami may display a covering of white mold. It comes in sticks measuring from 2 to 3 inches in diameter (5 to 7.5 cm), which weigh from 2 to 5 pounds (0.9 to 2.3 kg). This product must conform to applicable regulatory requirements for curing.

Item No. 830 – Mortadella – Mortadella is a cooked and smoked sausage that is light in color and similar in texture to bologna. Mortadella is made from finely ground pork, beef, and chunks of pork fat. It is recognizable by large chunks of pork fat and pistachio nuts, up to 1 percent, on its interior cut surface. Other condiments that may be included are sweet red peppers, up to 4 percent, and whole black peppers. Sticks have a uniform diameter measuring from 4 to 5 inches (10 to 12.5 cm). Mortadella may also be produced as a dry or semi-dry product. It may be made with or without pork fat chunks. Mortadella also may be made from poultry and pork fat and may include extenders. This product must conform to applicable regulatory requirements for thermal processing.