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I **NSSTITUTIONAL**

M **EAT**

P **URCHASE**

S **PECIFICATIONS**

**QUALITY ASSURANCE PROVISIONS
APPROVED BY USDA**

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INSTITUTIONAL MEAT PURCHASE SPECIFICATIONS

QUALITY ASSURANCE PROVISIONS

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

General Requirements
Quality Assurance Provisions

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

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

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

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

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

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

I. SCOPE

All IMPS items shall meet the requirements specified in the IMPS Item Descriptions, IMPS General Requirements and purchasing documents. The Quality Assurance Provisions are to be used by the MGCB for certification of compliance with the detailed item descriptions. These provisions are recommended for use by any meat production Quality Control activity. Examination for time limitations and packing and packaging requirements shall be performed as stated in the IMPS General Requirements.

II. DEFINITION OF TERMS

For the purpose of determining acceptance of any IMPS item, the following definitions are provided:

Acceptable Quality Level (AQL). The maximum number of defects per hundred units that, for the purposes of sampling inspection, can be considered satisfactory as a process average.

Acceptance Number (Ac). The number in a sampling plan that indicates the maximum number of defects permitted in a sample in order to consider a lot as meeting a specific AQL.

Boneless. All bone, cartilage, and calcified periosteum shall be considered when evaluating defects for presence of bone and cartilage.

Defect. Any nonconformance of any unit of product with specified requirements.

Defect Classifications. The terms used to denote the severity of a defect. The terms are as follows:

Major defect - A defect that materially affects, or is likely to materially affect, the usability of the item.

Minor defect - A defect of which repeated occurrence would materially affect, or is likely to materially affect, the usability of the item.

Lot. The term is used to mean a collection of units of meat products that are offered for examination for determination of compliance during a single workshift and are of the same item description, weight range, date of acceptance, etc. For the purpose of these provisions the size of a lot shall be expressed in applicable terms of either pounds or pieces.

Random sampling. A process of selecting a sample from a lot whereby each unit in the lot has an equal chance of selection.

Rejection Number (Re). The number in a sampling plan that indicates the minimum number of defects in a sample that will cause a lot to fail a specific AQL.**Sample.** The collective number of sample units for the examination of a lot.

Sample Size. The number of sample units which are to be included in the sample.

Sample unit. An individual item (roast, chop, steak, etc.) or designated quantity of product to be part of a sample.

Slight amount of lean removed. Amount of lean removed from the major muscles of an item that, regardless of the location, is indicative of a product prepared within the limits of good commercial practice and does not materially affect the usability of that item.

Small amount of lean removed. Amount of lean removed from the major muscles of an item that, regardless of the location, materially affects the usability of that item.

Stationary Lot Sampling plan. A plan stating the number of sample units to be included in the sample as well as the corresponding acceptance and rejection criteria. The decision to accept or reject a lot with respect to a specified AQL is made after the inspection of a sample or when the number of defects exceeds the acceptance number.

100-Percent. A method of examination in which all items within a lot are examined. Items not fully complying with the detailed item description shall be rejected.

III. PRODUCT EXAMINATION

Fresh-chilled bone-in or boneless meat shall be examined for excellent condition and detailed item description requirements using either the 100 percent or the stationary lot examination procedure. Certification for excellent condition and detailed item description requirements may be performed separately or at the same time. Certification for excellent condition on ground, flaked, diced or portioned items shall be determined on the applicable raw materials prior to preparation of the product in its final form (i.e., prior to grinding, flaking, dicing, portioning). Certification of excellent condition of sausage items, to be delivered frozen, may be performed on thawed samples after freezing/tempering, provided the producer is a participant in the MGCB sponsored quality control program.

The examination procedure used shall be specified by the contractor and agreed to by the AMS agent. Lot sizes shall be as defined for each procedure. However, the AMS agent may designate a portion of a declared lot as a separate lot, if in the agent's opinion: (1) that portion is not in compliance with any of the specification requirements; (2) if production is seriously interrupted; or (3) if there is excessive recurrence of units not in compliance with detailed item descriptions during 100 percent examination. The AMS agent may specify the examination procedure to be used for such lots.

A. CONTRACTOR'S RESPONSIBILITY

Examination and certification by AMS shall not relieve the contractors of their obligation to deliver product complying with all the requirements of the Institutional Meat Purchase Specifications. The contractor shall assure product compliance prior to submitting it for any examination.

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) shall be made by a Food Safety Inspection Service (FSIS) Meat and Poultry Inspection Operations (MPIO), employee.

B. PROCEDURES FOR EXAMINATION

100-Percent. This procedure may be used to initially examine fresh-chilled bone-in or boneless meat for excellent condition requirements, prior to further processing, provided the meat is in portions of at least 3 pounds (1.4 kg). Lots that contain any meat in portions that are less than 3 pounds shall be examined by the Stationary Lot procedure unless the stationary lot sample size exceeds the lot size.

The 100 percent examination procedure may be used for determining compliance with excellent condition and the detailed item description requirements for carcasses, sides, quarters, and large bone-in or boneless primal cuts (See applicable index for items eligible to be examined 100-Percent). This examination is also allowed for other cut and roast items (except portion cuts) and boneless meat for further processing when the lot size is less than 500 pounds.

All meat in less than excellent condition shall be rejected and cannot be reworked and/or reoffered. Items which do not meet all the detailed item description requirements shall be rejected, but they may be reworked and reoffered one time only.

Stationary Lot. This procedure may be used to examine fresh-chilled bone-in or boneless meat of any size portion (cuts and/or trimmings) for excellent condition and detailed item description requirements. The lot size, expressed in terms of number of pounds, shall be declared to the AMS agent by the contractor. Lot size shall not exceed the amount of product offered in a single workshift. The sampling plans for meat are listed in the Lot Acceptance Criteria section.

The randomly selected sample units shall be evaluated for compliance with the excellent condition criteria (if not previously examined for condition) and applicable defect classification table found in section **IV. DEFECT CLASSIFICATIONS**. Failure of the sample to meet the acceptance criteria as identified in Lot Acceptance Criteria section shall cause rejection of the involved lot.

Rejected product, (except sausage items) may be offered for reexamination once as one stationary lot (refer to Lot Acceptance Criteria section). Meat shall be reworked prior to reexamination. However, lots containing product in less than excellent condition shall be rejected and cannot be reworked and reoffered. Except as otherwise specified, Quality Assurance **TABLE I-B and II-B** shall not be applicable to IMPS 800 Sausage products.

IMPS Quality Control Program (IMPS QCP). The IMPS QCP program, involves the implementation of plant-wide quality control in combination with a USDA, MGCB certification program. Approved IMPS QCP participants shall be authorized to present fresh chilled, or tempered/frozen uncooked sausage IMPS items to the AMS agent for an excellent condition examination and product acceptance determination in its final form (i.e., after tempering/freezing).

IMPS QAP applicants shall submit, in writing, a completed application of their proposed IMPS quality control program (EXHIBIT A) to their local Area Meat Grading Supervisor for review. The Area Meat Grading Supervisor shall then evaluate and approve, or disapprove, each individual proposal based on the following criteria:

1. The application demonstrates that the finished IMPS item will meet all IMPS specification and Quality Assurance requirements.
2. The producer has at least one full time employee responsible for ensuring that the quality control program is strictly enforced and that a responsible employee is fully qualified to supervise a quality assurance program.
3. The producer maintains and makes available for review all manifest, production and quality control records.

MGCB maintains the right to verify any of the information provided by the contractor.

IMPS QCP participants found not to be adhering to the approved quality control plan shall be suspended from the program for a minimum of 6 months or until necessary corrections have been made and approval for reinstatement has been granted by the local Area Meat Grading supervisor. IMPS QCP suspended contractors shall be required to offer all future product for initial examination in the fresh chilled state until the suspension has been lifted.

Randomly selected sample units shall be thawed above 36°F (2.2°C) and shall be evaluated for compliance with the excellent condition criteria and applicable defect classification table. Failure of the sample to meet the acceptance criteria as identified in the Lot Acceptance Criteria section shall cause rejection of the involved lot. Product which has been thawed shall be returned to the vendor and may not be included in the acceptable delivery unit. Contractors shall replace the thawed product with additional product produced for this purpose. Copies of the approved quality control plan shall be maintained at the production plant, and at the Area, Regional, and Washington, D.C., MGCB office.

Product Monitoring - When specified by the purchaser, acceptability of boneless meat for compliance to the material requirements for ground meat and trimmings shall be determined in accordance with a product monitoring program. For certification, the boneless meat product monitoring shall be performed in accordance with MGCB 918 instruction for boneless meat examinations. The applicable IMPS defect classification table shall be used to determine compliance with the material requirements for ground meat and trimmings.

C. LOT ACCEPTANCE CRITERIA

Cuts, roasts and diced items. Unless otherwise specified by the purchaser, the following

AQL's in TABLE I shall be used. Major and minor defects are classified within the applicable defect classification table found in Section **IV. DEFECT CLASSIFICATIONS**. The accept (AC) and reject (RE) criteria for the respective AQL's are within TABLE I-A. TABLE I-B shall be used for examination of cuts, roast, and diced items which have been rejected and re-worked.

The sample size may differ depending on the specified or required AQL. For example, if sample size for Major defects equals 13 sample units and the sample size for Minor defects equals 8, then 8 randomly selected sample units out of the 13 may be examined for both Major and Minor defects and the remaining sample units shall be examined for Major defects only.

Portion cuts. Unless otherwise specified by the purchaser, the AQL in TABLE II shall be used. Major and minor defects are classified within the applicable defect classification table found in Section **IV. DEFECT CLASSIFICATIONS**. The accept (AC) and reject (RE) criteria for the respective AQL are within TABLE II-A. TABLE II- B shall be used for examination of portion cut items which have been rejected and reworked.

IMPS 800 Series Sausage Products

Stick, loaf, sliced, link, crumbled, scrapple, roll, bag, and bulk packaged product - Lot size, sample size, and accept/reject criteria shall be as shown in **TABLE I-A**. The lot size shall be expressed as the number of pounds. A sample unit shall be 1 item or 1 pound (0.45 kg) as specified.

Patty products - Lot size, sample size, and accept/reject criteria shall be as shown in **TABLE II-A**. The lot size shall be expressed as number of pounds. A sample unit shall be 1 portion item.

Reexamination of rejected lots - Except as otherwise specified, Quality Assurance **TABLES I-B and II-B** are not applicable to IMPS Series 800 Sausage products.

STATIONARY LOT SAMPLING PLANS

TABLE I

DEFECT CLASSIFICATION	AQL
MAJOR	6.5
MINOR	25.0

**TABLE I-A
STATIONARY LOT SAMPLING PLAN 1/ 2/ 3/ 4/ 5/ 6/
FOR CUTS AND ROASTS**

AQL'S		4.0		6.5		10		15		25		40	
LOT SIZE (POUNDS)	SAMPLE SIZE (NO. OF SAMPLE UNITS)	AC	RE	AC	RE	AC	RE	AC	RE	AC	RE	AC	RE
1,200 OR LESS	8 13	----	2	1	2	2	3	3	4	5	6	7	8
1,201 TO 3,200	13	1	2	2	3	3	4	5	6	7	8	10	11
3,201 TO 35,000	20	2	3	3	4	5	6	7	8	10	11	14	15
35,001 OR MORE	32	3	4	5	6	7	8	10	11	14	15	21	22

**TABLE I-B
STATIONARY LOT SAMPLING PLAN 1/ 2/ 3/ 4/ 5/ 7/
FOR CUTS AND ROASTS
REEXAMINATION**

AQL'S		4.0		6.5		10		15		25		40	
LOT SIZE (POUNDS)	SAMPLE SIZE (NO. OF SAMPLE UNITS)	AC	RE	AC	RE	AC	RE	AC	RE	AC	RE	AC	RE
1,200 OR LESS	8 13 20	----	2	1	2	1	2	2	3	3	4	5	6
1,201 TO 3,200	13 20	1	2	1	2	2	3	3	4	5	6	8	9
3,201 TO 35,000	20	1	2	2	3	3	4	5	6	8	9	12	13
35,001 OR MORE	32	2	3	3	4	5	6	8	9	12	13	18	19

NOTE: Footnotes 1 - 6 are applicable to TABLES I-A, II-A, Footnotes 1 - 5 are applicable to TABLES II-B, I-B.

- 1/ The finding of any product in less than excellent condition shall cause rejection of the involved lot.
- 2/ When sampling is performed on items that are packed into containers, no more than 2 cuts or roast, and ten portion-cut sample units from one container may be included in the sample.
- 3/ Acceptability of product with respect to presence of foreign material (for example: glass, dirt, insect parts, hair, wood, metal) shall be made by an MPIO employee.
- 4/ Presence of product not within specified quality and/or yield grade, proper identity, or fabricated and/or placed into containers as specified shall cause rejection of the lot.
- 5/ The "----" in the table AQL columns indicates that AC, RE criteria are not available for that AQL. Use the alternate sample size and AC, RE criteria listed for that AQL.
- 6/ When sampling is performed on Series 800 Sausage Items, (except Item No. 802A and 802B - see footnote 2) no more than 5 sample units, from a single primary container may be included in the sample.
- 7/ TABLES I-B and II-B are not applicable to Series 800 Sausage Items.

TABLE II

DEFECT CLASSIFICATION	AQL
MAJOR	6.5
MINOR	25.0

**TABLE II-A
STATIONARY SAMPLING PLAN 1/ 2/ 3/ 4/ 5/
FOR PORTION CUTS**

		AQL'S									
LOT SIZE (POUNDS)	SAMPLE SIZE (NO. OF SAMPLE UNITS)	4.0		6.5		10		15		25	
		AC	RE	AC	RE	AC	RE	AC	RE	AC	RE
500 OR LESS	20	2	3	3	4	5	6	7	8	10	11
501 TO 1,200	32	3	4	5	6	7	8	10	11	14	15
1,201 TO 3,200	50	5	6	7	8	10	11	14	15	21	22
3,201 TO 10,000	50	7	----	10	----	14	----	21	----	21	22
	80	7	8	10	11	14	15	21	22	21	22
10,000 OR MORE	50	----	----	----	----	----	----	----	----	21	22
	80	----	----	----	----	----	----	21	22	----	----
	125	10	11	14	15	21	22	----	----	----	----

**TABLE II-B
STATIONARY LOT SAMPLING PLAN 1/ 2/ 3/ 4/ 5/ 7/
FOR PORTION CUTS
REEXAMINATION**

		AQL'S									
LOT SIZE (POUNDS)	SAMPLE SIZE (NO. OF SAMPLE UNITS)	4.0		6.5		10		15		25	
		AC	RE	AC	RE	AC	RE	AC	RE	AC	RE
500 OR LESS	20			1	2	3	4	5	6	8	9
	32			----	----	----	----	----	----	----	----
501 TO 1,200	32	1	2	3	4	5	6	8	9	12	13
1,201 TO 3,200	50	3	4	5	6	8	9	12	13	18	19
3,201 TO 10,000	50	5	----	8	----	12	----	18	----	18	19
	80	5	6	8	9	12	13	18	19	18	19
10,001 OR MORE	50	----	----	----	----	----	----	----	----	18	19
	80	----	----	----	----	----	----	18	19	----	----
	125	8	9	12	13	18	19	----	----	----	----

NOTE: Footnotes 1 - 6 are applicable to TABLES I-A, II-A, Footnotes 1 - 5 are applicable to TABLES II-B, I-B.

- 1/ The finding of any product in less than excellent condition shall cause rejection of the involved lot.
- 2/ When sampling is performed on items that are packed into containers, no more than 2 cuts or roast, and ten portion-cut sample units from one container may be included in the sample.
- 3/ Acceptability of product with respect to presence of foreign material (for example: glass, dirt, insect parts, hair, wood, metal) shall be made by an MPIO employee.
- 4/ Presence of product not within specified quality and/or yield grade, proper identity, or fabricated and/or placed into containers as specified shall cause rejection of the lot.
- 5/ The "----" in the table AQL columns indicates that AC, RE criteria are not available for that AQL. Use the alternate sample size and AC, RE criteria listed for that AQL.
- 6/ When sampling is performed on Series 800 Sausage Items, no more than 5 sample units, (except Item No. 802A and 802B - see footnote 2) from a single primary container may be included in the sample.
- 7/ TABLES I-B and II-B are not applicable to Series 800 Sausage Items.

D. FAT CONTENT ANALYSIS

When fat content is to be certified, the purchaser may specify fat content to be determined by either composite analysis or average analysis. If not specified, the fat content shall be determined by average analysis.

For the purpose of determining fat content, the following terms shall be defined as follows:

Composite sample. A single sample that is composed of two or more individual samples from a lot.

Ave Fat Content Analysis rage. The percent of fat derived from averaging results of 2 or more individual fat content analyses.

Composite Fat Content Analysis. Composite fat analysis is the result obtained by determining the percent fat in a sample that has been drawn from two or more thoroughly blended samples.

Procedures for sample withdrawal for fat content analysis. For bulk ground products, the AMS agent shall randomly select from each production lot 1 filled bag from each of 4 randomly selected shipping containers. For trimmings, the AMS agent shall randomly select 4 containers (combo bins or shipping containers) from each lot and designate the location for a core sample to be taken. Fill one bag from each core sample (no less than 6 pounds).

From each of the filled bags the agent shall cut 1 approximately 2-pound section, the position of which was randomly established in the filled bags prior to start of sampling. For patties or flaked and formed steaks, the AMS agent shall randomly select a stack(s) or layer(s) from each of 4 randomly selected shipping containers resulting in 4 approximately 2-pound portions of adjacent patties.

After withdrawal of samples, the contractor shall make correct fills on the boxes sampled by adding the necessary product produced for this purpose.

Composite Fat Content Analysis. The 4 individual 2-pound sections shall be thoroughly mixed together into one composite sample. The composite sample shall be prepared by reducing the consistency to a thoroughly blended mixture. Three (3) individual samples are drawn from the composite sample, and each is assigned the same identification number. One sample shall be sent to the AMS laboratory for analysis. One sample shall be solidly frozen and retained by the AMS agent as a reserve sample. One sample shall be submitted to the contractor.

Average Fat Content Analysis. The 4 individual 2-pound sections shall be independently prepared by reducing the consistency of the section to a thoroughly blended mixture. From each mixture, 3 samples shall be pulled and assigned the same identification number: One sample shall be submitted to the AMS laboratory. One sample shall be solidly frozen and retained by the AMS agent as a reserve sample, and the remaining sample shall be submitted to the contractor.

Reserve Samples. The reserve samples shall be used for analyses: (1) when the original

sample is lost; (2) if requested by AMS or the contractor. However, analysis of the reserve samples at the request of the contractor shall not be permitted unless the original analyses indicated that the involved production lot will be rejected (or discounted, if applicable) because of noncompliance with fat analysis requirements. When reserve samples are analyzed, all 4 samples shall be analyzed, and the results of such analyses shall be final. Unused reserve samples shall be returned to the contractor after final acceptance or rejection of the involved production lot.

Sliced bacon fat content analysis. Withdrawal of samples for analytical requirements of sliced bacon shall be as follows: Sample size shall be determined according to the lot size (expressed as pounds), and the number of sample units shall be determined from TABLE II-A of the Quality Assurance Provisions. A sample unit for analytical purposes shall be 7 adjacent slices. The locations of the appropriate number of sample units shall be randomly selected. The slices selected shall be cut into approximate 1.0 inch (25 mm) widths, thoroughly mixed, and ground through a 0.125 inch (1/8 inch, or 3.2 mm) plate or similarly comminuted. The thoroughly mixed sample shall be divided into approximate thirds and distributed as follows:

1. One third to the AMS approved laboratory
2. One third held as a reserve sample
3. One third to the contractor

IMPS 800 Sausage fat content analysis. When the purchaser specifies this option in the contract or purchase order, the AMS agent shall randomly select from each production lot 1 pound (0.45 kg) of adjacent product from each of 4 randomly selected shipping containers, the position of which was randomly established prior to start of sampling.

After withdrawal of samples, the contractor shall make correct fills on the boxes sampled by adding the necessary product produced for this purpose.

Canned Luncheon Meat fat content analysis. After completion of the can filling operation for each lot, eight cans of product shall be randomly selected for analysis. The product from the eight cans shall be formed into a composite sample by thorough mixing. The contents of these cans shall be prepared by reducing the consistency of the composite sample to a thoroughly blended mixture. After the composite sample is prepared, three cans of the sample mix shall be repacked and resealed. All sample cans shall be marked to identify them with the applicable lot and to distinguish them from cans of that lot or cans or samples from any other lot. After thermal processing, these three cans shall be distributed as follows:

1. - One shall be submitted to the laboratory.
2. - One shall be submitted to the contractor.
3. - One shall be retained by the AMS agent as a reserve sample to be used if the original is lost or if requested by AMS or the contractor.

However, analysis of the reserve sample at the request of the contractor shall not be permitted unless the original analysis indicated that the involved production lot will be discounted or rejected because of noncompliance with the fat or salt content requirements. When the reserve sample is analyzed, the results of such analysis shall be considered final. Cans of composite sample mixture, in excess of the three selected above, may be thermal processed and included in the production lot. Unused reserve samples shall be submitted to the contractor.

E. PROTEIN FAT-FREE (PFF) SAMPLE SELECTION/PREPARATION PROCEDURES

When the purchaser's contract or purchase order specifically designates that the PFF values are to be certified by the USDA, MGCB, the AMS Agent shall randomly select 1 ham, shoulder, or loin item from each of 4 randomly selected shipping containers and cut from each of the selected samples an approximate 1-pound section, (remove bone if sample is selected from a bone in item) the position of which was randomly established prior to the start of sampling. Each section shall be independently prepared by reducing the consistency of the section through a 0.125 inch (1/8 inch, or 3.2 mm) plate or similarly comminuted and thoroughly blended. From this mixture, 3 samples shall be drawn: 1 sample shall be sent to a FSIS, MPIO approved and certified laboratory, 1 sample shall be solidly frozen and retained as a reserve sample, and the remaining sample shall be given to the contractor.

If the average of the 4 samples fails to meet or exceed the FSIS, MPIO minimum required PFF percentages listed in TABLE I, the involved lot shall be rejected.

After withdrawal of samples the producer may repackage the sampled product and include in the delivery unit, or replace with extra product from the same production lot.

F. DRAINED WEIGHT EXAMINATION PROCEDURES

Canned Hams. Prior to the defect examination, hams selected for evaluation of finished product defects shall also be used to determine total drained weight. Hams shall be in the temperature range of between 55 °F and 75 °F at the time of the examination. The cooked ham shall be made as free as possible from rendered fat, liquid, and gelatinized juices prior to being weighed. Total net weight shall be determined by subtracting the tare weight from the gross weight. The tare weight shall be determined by weighing an equal number of empty cans, lids, and bags used in packaging the product. The total drained weight must be equal to or greater than 97% of the total actual net weight for pullman style hams, 94% for pear shaped hams, and 98% for hams prepared in a cook-in bag style container. Failure to meet or exceed the drained weight requirements shall cause rejection of the involved lot.

Canned Luncheon Meat. When specified by the purchaser, an examination for drained weight shall be performed on all sample units. Surface fat and dripping moisture shall be removed from cores used in this examination. Also, meat adhering to the can shall be excluded. Meat cores shall be weighed in the aggregate, and the total weight (in ounces) shall be divided by the number of sample units to determine the average drained weight. The total drained weight must be equal to or greater than 85% of the total actual net weight. Total net weight shall be determined by subtracting the tare weight from the gross weight. The tare weight shall be determined by weighing an equal number of empty cans and lids used in packaging the product. Failure to meet or exceed the drained weight requirements shall cause rejection of the involved lot.

G. USDA TEMPERATURE EXAMINATION

If product is to be USDA, MGCB certified for compliance with the 72- or 24-hour temperature requirement, it shall be sampled by randomly selecting at least 3 shipping containers or 3 pieces from each production lot. Any individual sample box exceeding the specified temperature shall cause rejection of the lot.

For USDA, MGCB temperature certification of frozen product at the time of delivery, the AMS agent shall randomly select and examine at least 1 shipping container or 1 piece from each production lot. However, in no case shall there be less than 3 shipping containers or pieces examined from each item or delivery unit. Any individual sample box exceeding the specified temperature shall cause rejection of the lot.

NOTE: A tolerance of +2 °F (16.6 °C) shall be considered as meeting the specification requirements on frozen product only. Final acceptance of frozen product, examined and certified in the chilled state, shall be in accordance with USDA Meat Grading and Certification Branch instructions.

H. NET WEIGHT EXAMINATION

This examination will be performed by randomly selecting and weighing a sample of 10 packed shipping units from each production lot. Net weight shall be determined by subtracting a tare weight from the gross weight. The tare weight shall be determined by weighing empty shipping containers and packaging materials of the same kind and in the same amount applicable to the 10 shipping containers weighed. The total net weight of the sample shall be equal to or greater than the total of the marked net weights in the sample. If the total net weight of the sample is less than the total marked net weights in the sample, the lot shall be rejected. Lots that are rejected may be reworked and submitted for reexamination (one time only). When examining resubmitted lots, a sample of 4 shipping units per lot shall be randomly selected and weighed. The finding of any shipping unit in the resubmitted lot which is less than the marked net weight shall cause rejection of the lot.

SCALES: Scales used in the net weight examination and scales used in the certification of a specified weight range and/or portion size shall be certified in accordance with MGCB Instructions. Depending on the product to be examined, electronic digital scales which weigh to .01 of an ounce may be required.

Net weight examination for canned luncheon meat.

When specified by the purchaser, ten (10) sealed, filled cans of product from each production lot shall be randomly selected and weighed in the aggregate to determine the total net weight of product in the sample. Net weight shall be determined by subtracting a tare weight from the gross weight. The tare weight shall be determined by weighing 10 empty cans and lids used in preparing the product.

The total net weight of the sample must be equal to or greater than the total of the marked net weights in the sample. If the total net weight of the sample is less than the total marked net weights in the sample, the lot shall be rejected. However, lots that are rejected for net weight may be reworked and submitted for reexamination (one time only). When examining resubmitted lots, 4 sealed, filled cans of product per lot shall be selected and individually weighed. The finding of any can in the resubmitted lot which is less than the marked net weight shall cause rejection of the lot.

I. EXTERNAL AND INTERNAL PRODUCT EXAMINATION FOR IMPS SERIES 800 SAUSAGE PRODUCTS

All sample units randomly selected for external product examinations shall also be used for internal product examinations.

1. STICK, LOAF, BAG, ROLL, AND BULK PACKAGED PRODUCTS

For examination of the exterior surface defects of stick, loaf, bag, roll, and bulk packaged products, the exterior of the entire sample unit (1 item) shall be evaluated.

For examination of internal product characteristics on the cut surfaces of stick, loaf, bag, roll, and bulk packaged products, the sample unit (1 item) shall be divided into 2 pieces by a single cut made at a right angle to the long axis which is not less than 2.5 inches (6.4 cm) from either end. The right hand cut surface shall then be evaluated for defects in accordance with the applicable IMPS QUALITY ASSURANCE defect table. The AMS agent may cut a defect from a sliced surface to measure all dimensions.

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

2. LINK PRODUCTS

To examine link products for exterior surface defects, the entire randomly selected 1-pound (0.45 kg) sample unit shall be evaluated.

For examination of the cut surface of link products for internal product characteristics, randomly select 2 links within each 1-pound sample unit and divide the link into 2 pieces by a single lengthwise cut made parallel to the long axis. Evaluate the right hand cut surface of the link for defects in accordance with IMPS QUALITY ASSURANCE PROVISIONS defect TABLE 800B. For evaluation, defects may be cut from a sliced surface to measure all dimensions.

When the purchaser specifies portion weights (links per pound), defects 103 and 103A apply. The total weight of the specified number of links per pound shall be 1 pound (0.45 kg), \pm 0.05 pound (22.68 g) (.95 to 1.05 pound). Any sample unit not meeting the specified links per pound weight requirement shall be scored as a major defect.

NOTE: Length measurements of link items shall be made on the cut surface of the item which has been divided into 2 pieces by a single lengthwise cut made parallel to the long axis. Link items which have a slight natural curvature may be straightened (without breaking or stretching the item) to permit an accurate measurement. After examination of the cut surface the producer shall replace the sampled product with extra product from the production lot.

3. SLICED PRODUCT

To examine sliced products, a randomly selected 1-pound section or 1-pound package (0.45 kg) shall be evaluated on both sides of the slice for defects in accordance with IMPS QUALITY ASSURANCE PROVISIONS defect TABLE 800E. After examination of the sliced surfaces, the producer may repackage the sampled product and include it in the 1 accepted delivery unit, or replace it with extra product from the production lot produced for this purpose.

- a. Each sample unit shall be subject to a slice-count examination.
- b. Slice-count on each selected sample shall be as specified by the purchaser.
- c. The total number of slices per pound, as specified by the purchaser, shall weigh 1 pound (0.45 kg) with a tolerance of + 1 slice. Any sample unit not meeting the specified slice count/weight requirement shall be scored as a major defect.
- d. Examination for internal defects shall be made on both cut surfaces of each slice.
- e. Unless otherwise specified by the purchaser, sliced items shall be manufactured as 1-pound vacuum packages which shall be packed into a master container not to exceed 55 pounds (25 kg).
- f. Slices shall have no evidence of casing material.

4. PORK SAUSAGE PATTY PRODUCTS

For examination of pork sausage patty products, a sample unit shall be 1 randomly selected patty. Each sample unit shall be evaluated for portion weight, examined for all exterior defects and crumbled for an evaluation of the interior defects in accordance with IMPS QUALITY ASSURANCE PROVISIONS defect TABLE 800E. After examination of the product for defects, the producer shall replace the crumbled sample product with extra product from the production lot.

5. CRUMBLED, COOKED, PORK SAUSAGE

To examine crumbled, cooked, pork sausage, a randomly selected 1-pound section shall be evaluated for defects in accordance with IMPS QUALITY ASSURANCE PROVISIONS defect TABLE 800F.

6. SCRAPPLE

For examination of internal product characteristics on the cut surfaces of scrapple, the sample unit (1 item) shall be divided into 2 pieces by a single cut made at a right angle to the long axis. The right hand cut surface shall then be evaluated for defects in accordance with the applicable IMPS QUALITY ASSURANCE PROVISIONS defect TABLE 800G. The AMS agent may cut a defect from a sliced surface to measure all dimensions.

J. Item Count Examination

Item Count Examination - This examination will be performed by randomly selecting 4 packed shipping units from each production lot. Item count shall be determined by calculating the number of items (roasts, cuts, packaged units, or portion cuts) in each of the 4 shipping containers. If the count in any individual sample unit is less than the marked item count, the lot shall be rejected. Lots that are rejected may be reworked and submitted for reexamination (one time only). When examining resubmitted lots, a sample of 10 shipping units per lot shall be randomly selected. The finding of any shipping unit in the resubmitted lot which has an item count less than the marked item count shall cause rejection of the lot.

IV. DEFECT CLASSIFICATIONS

The following tables shall be used for evaluating compliance with the IMPS item descriptions when using the Stationary Lot Examination method. Applicable defects for each individual item description are found in the corresponding lettered table within each series (i.e., 100A - 100S for Fresh Beef items, see index).

Within the individual tables, the defects with 3-digit numbers beginning with the number 1 (i.e., 100, 101, etc.) shall be classified as MAJOR and the defects with numbers beginning with the number 2 (i.e., 200, 201, etc.) shall be classified as MINOR.

INDEX OF IMPS ITEMS

All items may be examined for Material and Detailed Item Description Requirements using the Stationary Lot Examination Method. The 100 percent option is available for those items listed for the item's respective table.

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Item No.	100% Avail.	Defect Table	Item No.	100% Avail.	Defect Table	Item No.	100% Avail.	Defect Table
100	X	100 A	121B		100 F	165A	X	100 L
100A	X	100 A	121C		100 F	165B	X	100 L
100B	X	100 A	121D		100 F	166	X	100 L
101	X	100 A	121E		100 F	166A	X	100 J
102	X	100 A	121F	X	100 D	166B	X	100 J
102A	X	100 E	121G		100 F	167		100 M
102B	X	100 A	122	X	100 D	167A		100 M
103	X	100 B	122A		100 F	167B		100 M
103A	X	100 B	123		100 G	167C		100 M
104	X	100 B	123A		100 G	167D		100 M
107	X	100 B	123B		100 G	168		100 M
107A	X	100 B	123C		100 G	169		100 M
108		100 C	123D		100 F	169A		100 M
109	X	100 B	124		100 G	169B		100 M
109A	X	100 B	125	X	100 D	170		100 M
109B	X	100 C	126		100 E	170A		100 M
109C	X	100 B	126A		100 E	171		100 M
109D	X	100 B	127		100 D	171A		100 M
109E	X	100 B	128	X	100 E	171B		100 M
110		100 C	130		100 G	171C		100 M
111		100 C	130A		100 E	172	X	100 K
112		100 C	132	X	100 D	172A	X	100 K
112A		100 C	133	X	100 E	173	X	100 K
113	X	100 D	134		100 G	174	X	100 K
113A	X	100 D	135		100 H	175	X	100 K
113B	X	100 D	135A		100 H	180		100 N
113C		100 D	135B		100 H	181	X	100 K
114		100 E	136		100 I	181A	X	100 K
114A	X	100 E	136A		100 I	182		100 P
114B	X	100 E	136B		100 I	183		100 P
114C		100 E	136C		100 I	184		100 P
114D		100 E	137		100 I	184A		100 P
114E		100 E	137A		100 I	184B		100 P
115		100 E	138		100 I	184C		100 P
115A		100 E	139		100 H	184D		100 P
115B		100 E	155	X	100 A	184E		100 P
115C		100 E	155A	X	100 L	185		100 P
116		100 E	155B	X	100 A	185A		100 P
116A		100 E	155C	X	100 A	185B		100 P
116B		100 E	157		100 J	185C		100 P
116C		100 E	158	X	100 J	185D		100 P
116D		100 E	158A	X	100 J	186		100 P
116E		100 E	159	X	100 L	189		100 O
117	X	100 D	160	X	100 J	189A		100 O
118	X	100 D	160A	X	100 J	189B		100 O
119		100 E	160B		100 J	190		100 O
120		100 E	161	X	100 L	190A		100 O
120A		100 E	161A	X	100 L	191		100 O
120B		100 E	161B		100 L	191A		100 O
120C		100 E	163	X	100 M	191B		100 O
121	X	100 D	163A	X	100 M	192		100 O
121A		100 F	164	X	100 J	192A		100 O
			165	X	100 L	193		100 L

INDEX OF IMPS BEEF PORTION CUT ITEMS SERIES - 100

Item No.	Defect Table	Item No.	Defect Table	Item No.	Defect Table
1100	100 S	1136B	100 R	1137	100 R
1101	100 S	1136C	100 R	1137A	100 R
1102	100 S			1138	100 R
1103	100 Q			1138A	100 R
1103A	100 R			1138B	100 R
1112	100 R			1150	100 R
1112A	100 R			1167	100 R
1112B	100 R			1167A	100 R
1114D	100 R			1167D	100 R
1116D	100 R			1169	100 R
1121D	100 R			1170A	100 R
1121E	100 R			1173	100 Q
1123	100 Q			1174	100 Q
1136	100 R			1179	100 Q
1136A	100 R			1179A	100 Q

1180	100 R	1180A	100 R
		1184	100 R
		1184A	100 R
		1184B	100 R
		1184D	100 R
		1185A	100 R
		1185B	100 R
		1185C	100 R
		1185D	100 R
		1189	100 R
		1189A	100 R
		1189B	100 R
		1190	100 R
		1190A	100 R
		1190B	100 R
		1190C	100 R

TABLE 100 A

The following defects are applicable to **carcass** Item Nos. 100, 100A, 100B, 101, 102, 102B, 155, 155B, 155C. Sample unit shall be one carcass, side or quarter.

201	The diaphragm, when present, not firmly attached and the membranous portion exceeding 0.25 inch (6 mm) from the lean at any point.	127	Evidence of dark cutting or callused beef.
		140	Maximum fat thickness at any point exceeding specified or required in the item description.
202	Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum average fat thickness exceeding that specified or required in the item description.
		142	Presence of the kidney, kidney knob, and hanging tender. (Item Nos. 100A, 100B, 102B, 155B, 155C)
204	The internal fat covering the lumbar, sacral, pelvic, and tenderloin regions exceeding 1.0 inch (25 mm) in depth at any point. (Item Nos. 100A, 100B, 102B, 155B, 155C)	149	The quarters are not completely or partially separated by a cut following the natural curvature between the 12th and 13th ribs.
103	Sides/quarters are not matched. (Item Nos. 100, 100A, 100B)		
206	All cut separations not forming an approximate right angle with the skin surface.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	293	Blood clot measuring 0.5 inch (13 mm) in the longest dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	294	Presence of any portion of the spinal cord measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	296	Product not within specified weight range.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.		
111	The split surface of chine not exposing the spinal groove to be evident on at least 75 percent of the length of the side.		

TABLE 100 B

The following defects are applicable to **bone-in rib** Item Nos. 103, 103A, 104, 107, 107A, 109, 109A, 109C, 109D, 109E. Sample unit shall be one rib item.

- | | | | |
|-----|---|-----|---|
| 205 | Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2. | 232 | Fat cover extending beyond short plate side 0.5 inch (13 mm) or more. (Item Nos. 109, 109A) |
| 206 | All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams). | | |
| 106 | Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension. (Item Nos. 109, 109A, 109C, 109D) | | |
| 210 | Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension. (Item Nos. 109, 109A, 109C, 109D) | | |
| 107 | A small amount or more of lean removed from major muscle(s). | | |
| 221 | More than a slight amount, but less than a small amount, of lean removed from major muscle(s). | | |
| 108 | Presence of adjacent cut(s) exceeding 4 percent of cut weight. | | |
| 222 | Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight. | | |
| 227 | Presence of the diaphragm and fat on the ventral surface of the vertebrae exceeding 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. | | |
| 112 | The chine bone not removed as specified. (Item Nos. 103A, 104, 107, 107A, 109, 109A, 109C, 109D) | | |
| 113 | Presence of blade bone and related cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. (Item Nos. 104, 107, 109, 109A, 109C, 109D) | | |
| 228 | Presence of blade bone and related cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension. (Item Nos. 104, 107, 109, 109A, 109C, 109D) | | |
| 231 | The fat cover having a hole larger than 2.0 square inches (12.9 sq cm). (Item Nos. 109, 109A) | | |

- 233 The underlying fat covering the longissimus dorsi and spinalis dorsi not trimmed to a uniform thickness for the entire seamed surface (No more than 0.5 inch (13 mm) difference). (Item Nos. 109A, 109C, 109D)
- 115 Presence of chine or feather bone measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. (Item Nos. 109A, 109C, 109D, 109E)
- 234 Presence of chine or feather bone measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension. (Item Nos. 109A, 109C, 109D)
- 116 Presence of fat cover. (Item Nos. 109C, 109D)
- 127 Evidence of dark cutting or callused beef.
- 140 Maximum fat thickness at any point exceeding that specified or required in the item description.
- 141 Maximum average fat thickness exceeding that specified or required in the item description.
- 292 Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 293 Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
- 294 Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
- 295 Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
- 296 Product not within specified weight range.
- 297 Item not properly netted or tied when specified.
- 298 Cut not practically free of bone dust.
- 299 Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 100 C

The following defects are applicable to **boneless rib** Item Nos. 108, 109B ^{1/}, 110, 111, 112, 112A. Sample unit shall be 1 rib item.

205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	116	Presence of fat cover. (Item Nos. 112, 112A)
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	127	Evidence of dark cutting or callused beef.
104	Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	140	Maximum fat thickness at any point exceeding specified or required in the item description.
208	Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum average fat thickness exceeding that specified or required in the item description.
106	Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
210	Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
107	A small amount or more of lean removed from major muscle(s). <u>2/</u>	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s). <u>2/</u>	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight. <u>2/</u>	296	Product not within specified weight range.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight. <u>2/</u>	297	Item not properly netted or tied when specified.
232	Fat cover extending beyond short plate side 0.5 inch (13 mm) or more. (Item No. 110)	298	Cut not practically free of bone dust.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

^{1/} Sample unit for 109B shall be 5 lbs. finished product. The AMS agent shall determine the supervision necessary to assure proper specified origin of all raw materials used.

^{2/} Not applicable to Item No. 109B.

TABLE 100 D

The following defects are applicable to **bone-in forequarter** Item Nos. 113, 113A, 113B, 113C, 117, 118, 121, 121F, 122, 125, 127, 132. Sample unit shall be one roast or item as applicable.

201	The diaphragm, when present, not firmly attached and the membranous portion exceeding 0.25 inch (6 mm) from the lean at any point.	225	Cut dividing the chuck is more than 5.0 inches (12.5 cm) or less than 3.0 inches (7.5 cm) ventral from the longissimus dorsi at the rib end. (Item Nos. 113A, 113B)
202	Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	141	Maximum average fat thickness exceeding that specified or required in the item description.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	296	Product not within specified weight range.
127	Evidence of dark cutting or callused beef.	297	Item not properly netted or tied when specified.
		298	Cut not practically free of bone dust.

TABLE 100 E

The following defects are applicable to **boneless forequarter** Item Nos. 102A, 114, 114A, 114B, 114C, 114D, 114E, 115, 115A, 115B, 115C, 116, 116A, 116B, 116C, 116D, 116E, 119, 120, 120A, 120B, 120C, 126, 126A, 128, 130A, 133. Sample unit shall be one roast or item as applicable.

<p>201 The diaphragm, when present, not firmly attached and the membranous portion exceeding 0.25 inch (6 mm) from the lean at any point.</p> <p>202 Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>205 Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.</p> <p>206 All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).</p>	<p>220 Diameter of blood vessel when only a cross-section is exposed measuring 1.0 inch (25 mm) or more in any dimension or exposed blood vessel that measures 1.0 inch (25 mm) or more in length and 0.5 inch (13 mm) or more in diameter.</p>
<p>104 Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>208 Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>106 Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.</p> <p>210 Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension.</p> <p>212 Presence of tendons on elbow end of shoulder clod protruding more than 0.3 inch (8 mm) from the surface of the lean.</p> <p>213 Heavy connective tissue on the surface of the lower (ventral) edge of the short plate or flank measuring 3.0 square inches (19.4 sq cm) or more. (Item No. 102A)</p> <p>214 The tendinous ends of shanks to a point where a cross-sectional cut exposes less than 75 percent lean tissue.</p> <p>218 Prescapular and/or any exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p>	<p>107 A small amount or more of lean removed from major muscles.</p> <p>221 More than a slight amount, but less than a small amount, of lean removed from major muscle(s).</p> <p>108 Presence of adjacent cut(s) exceeding 4 percent of cut weight.</p> <p>222 Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.</p> <p>127 Evidence of dark cutting or callused beef.</p> <p>224 The hard fat along the sternum edge not trimmed level with the boned surface. (Item No. 120)</p> <p>225 Cut dividing the chuck is more than 5.0 inches (12.5 cm) or less than 3.0 inches (7.5 cm) ventral from the longissimus dorsi at the rib end. (Item Nos. 115, 115C, 116, 126, 126A, 128)</p> <p>238 The clod is less than 1.0 inch (25 mm) thick at any point except within 3/4 inch (19 mm) of the juncture of the trapezius and latissimus dorsi. (Item Nos. 114A, 114B)</p> <p>239 Thin end of clod overlapping more than 1.0 inch (25 mm). (Item Nos. 114A, 114B)</p> <p>140 Maximum fat thickness at any point exceeding that specified or required in the item description.</p> <p>141 Maximum average fat thickness exceeding that specified or required in the item description.</p> <p>292 Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>293 Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.</p> <p>294 Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second</p>

dimension.

- 295 Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
- 296 Product not within specified weight range.
- 297 Item not properly netted or tied when specified.
- 298 Cut not practically free of bone dust.
- 299 Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 100 F

The following defects are applicable to **boneless plate** Item Nos. 121A, 121B, 121C, 121D, 121E, 121G, 122A, 123D. Sample unit shall be one roast or item as applicable.

201	The diaphragm, when present, not firmly attached and the membranous portion exceeding 0.25 inch (6 mm) from the lean at any point. (Item Nos. 121A, 121C, 121G)	108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.
202	Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	226	End of diaphragm not reasonably squared off. (Item No. 121E)
104	Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	127	Evidence of dark cutting or callused beef.
208	Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	138	Less than specified amount of lean exposed or remaining fat exceeds specified depth at any point. (Item Nos. 121D, 121E)
213	Heavy connective tissue on the surface of the lower (ventral) edge of the short plate or flank measuring 3.0 square inches (19.4 sq cm) or more.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
215	The membranous covering from skirts, flanks, and abdominal section of short plates or the membranous portion of the diaphragm measuring 2.0 square inches (12.9 sq cm) or more. (Item Nos. 121B, 121D, 121E)	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	296	Product not within specified weight range.
		298	Cut not practically free of bone dust.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 100 G

The following defects are applicable to **bone-in short rib/beef bones** Item Nos. 123, 123A, 123B, 123C, 124, 130, 134. Sample unit shall be no less than 5 pounds.

124	Short rib consisting of less than 2 or more than 5 ribs or not the number of specified ribs.	250	The serratus ventralis continuous for at least two ribs on the both dorsal and ventral sides. (Item Nos. 123B, 123C)
126	Bones in sample unit not shank, femur, or humerus. (Item No. 134)	251	The latissimus dorsi and exterior fat cover not removed. (Item Nos. 123A, 123B)
128	Marrow not exposed on at least 1 end of each sawed section. (Item No. 134)	256	Ribs exceed specified width (distance between the dorsal and ventral sides) of the rib sections by 0.5 inch (13 mm).
209	The dorsal side of the short rib not at an approximate right angle to the rib bones nor approximately parallel with ventral side.	284	Bone sections exceed specified length by 1.0 inch (25 mm) or more. (Item No. 134)
236	Evidence of cartilaginous junctures of the rib and thoracic vertebrae 1.0 inch (25 mm) or more in any dimension. (Item Nos. 124, 130)	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
244	Evidence of any costal cartilages on the short rib.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
245	Evidence of any portion of the deep pectoral on the short rib.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
246	The latissimus dorsi not continuous across the cut surface on the dorsal side. (Item Nos. 123, 123C)	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
248	Presence of diaphragm, and serous membrane (peritoneum) exceeding 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) in a second dimension on short ribs.	296	Product not within specified weight range.
140	Maximum fat thickness at any point exceeding that specified or required in the item description.	298	Cut not practically free of bone dust.
141	Maximum average fat thickness exceeding that specified or required in the item description.	299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)
249	Serratus ventralis not continuous for at least two ribs on both the dorsal and ventral sides of the short rib. (Item No. 123A)		

TABLE 100 H ^{1/2}

The following defects are applicable to **special trim/diced beef/kabobs** Item Nos. 135, 135A, 135B, 139. Lot and sample unit shall be 5 lbs. finished product.

- 104 Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 208 Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 106 Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.
- 210 Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension.
- 218 Popliteal, prescapular, prefemoral and/or any exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 220 Diameter of blood vessel measuring 0.5 inch (13 mm) or more in any dimension and 0.1 inch (2 mm) or more in a second dimension.
- 127 Evidence of dark cutting or callused beef.
- 230 Presence of two or more pieces that are less than 0.5 inch (13 mm) at any point. (Item No. 139)
- 129 More than 25 percent, by weight, of sample unit consisting of dices which have any individual surface exceeding 2.5 inches (6.3 cm) in length and/or are not of a size equivalent to a 3/4 inch (19 mm) to 1.5 inches (3.8 cm) cube. (Item No. 135)
- 130 More than 15 percent, by weight, of sample unit consisting of dices which have any individual surface exceeding 2.5 inches (6.3 cm) in length and/or are not of a size equivalent to a 3/4 inch (19 mm) to 1.5 inch (3.8 cm) cube. (Item No. 135A)

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| 131 | More than 10 percent, by weight, of sample unit consisting of dices which have any individual surface exceeding 3.0 inches (7.5 cm) in length and/or are not of a size equivalent to a 1.0 inch (25 mm) to 1.5 inches (3.8 cm) cube. (Item No. 135B) | 255 | Presence of two dices having connective tissue measuring more than 0.2 inch (5 mm) in thickness (width) (score one defect per two dices). |
| 132 | More than 10 percent, by weight, of sample unit consisting of dices that have exposed surface and/or seam fat exceeding specified fat thickness at any point. (Item Nos. 135, 135A, 135B) | 258 | Presence of 2 or more acceptable dice size pieces that consist entirely of fat (do not score if defect 132 is scored in the same sample unit). |
| 134 | More than 10 percent, by weight, of the sample unit consisting of pieces having surface area that is less than 8.0 square inches (51.6 sq cm) on one side. (Item No. 139) | 292 | Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. |
| 138 | Less than specified amount of lean exposed or remaining fat exceeds specified depth at any point. (Item No. 139) | 293 | Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension. |
| | | 194 | Presence of any portion of the spinal cord. |
| | | 254 | Presence of heavy opaque connective tissue measuring 3.0 square inches (19.4 sq cm) or more (Item No. 139) |
| | | 295 | Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more. |

- 1/ Presence of shank and/or, unless otherwise specified, heel meat shall cause rejection of the lot.
- 2/ Presence of product having ground appearance shall cause rejection of the lot.

TABLE 100 I

The following defects are applicable to item No. 138 and fresh-chilled boneless beef prior to production of **ground beef** Item Nos. 136, 136A, 136B, 136C, 137, 137A. Sample unit shall consist of a minimum of 10 pounds of adjacent meat. Evidence of beef after final grinding appearing abnormally light in color (i.e., light grayish pink) shall cause rejection of the lot.

104	Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	219	Non Carcass components, cod, udder, kidney, pelvic, or heart fat having a surface area measuring 2.0 square inches (12.9 sq cm) or more and 0.5 inch (13 mm) or more in depth at any point.
208	Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	253	Presence of 2 or more pieces of any size which more than 50 percent of its surface area is composed of heavy opaque connective tissue, bone, or cartilage, (do not score if defects 104, 208, 212, 215, or 254 are scored for those pieces).
106	Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	254	Presence of heavy opaque connective tissue measuring 3.0 square inches (19.4 sq cm) or more.
210	Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inches in one dimension and 0.5 inch (13 mm) or more in a second dimension.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
212	Presence of tendons on elbow end of clod of the shoulder clod protruding more than 0.3 inch (8 mm) from the surface of the lean.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
214	The tendinous ends of shanks, knuckles, and bottom rounds to a point where a cross-sectional cut exposes less than 75 percent lean tissue.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
215	The membranous covering from skirts, flanks, hanging tenders, and abdominal section of short plates or the membranous portion of the diaphragm measuring 5.0 square inches (32.3 sq cm) or more.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
218	Popliteal, prescapular, prefemoral and/or any exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.		

TABLE 100 J

The following defects are applicable to **bone-in round** Item Nos. 157, 158, 158A, 160, 160A, 160B, 164, 166A, 166B. Sample unit shall be one roast or item as applicable.

205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	265	Presence of the lean and fat that overlaid the aitch bone measuring 2.0 square inches (12.9 sq cm) or more and 0.5 inch (13 mm) or more in depth at any point. (Item Nos. 160, 160A, 164, 166A, 166B)
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	268	The shank not removed at the stifle joint and by a cut through the natural seam between the heel (gastrocnemius and superficial digital flexor). (Item Nos. 157, 160, 160A, 164, 166A)
218	Presence of any exposed lymph gland measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.	273	Presence of less than 3.0 inches (7.5 cm) or more than 5.0 inches (12.5 cm) of exposed shank bone and/or evidence of hock joint. (Item No. 166B)
107	A small amount or more of lean removed from major muscle(s).	175	Presence of aitch and/or tail bones measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. (Item Nos. 160, 164, 166A, 166B)
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	275	Presence of aitch and/or tail bones measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension. (Item Nos. 160, 160A, 164, 166A, 166B)
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
127	Evidence of dark cutting or callused beef.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
140	Maximum fat thickness at any point exceeding that specified or required in the item description.	296	Product not within specified weight range.
141	Maximum average fat thickness exceeding that specified or required in the item description.	297	Item not properly netted or tied when specified.
257	Presence of the gambrel cord protruding more than 0.3 inch (8 mm).	298	Cut not practically free of bone dust.
261	Presence of the obliquus abdominis internus (flank muscle).	299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)
263	Presence of sacrosciatic ligament measuring 1.0 square inch (6.5 sq cm) or more. (Item Nos. 160, 160A, 164, 166A, 166B)		
264	Presence of the thick opaque portion of the gracilis membrane measuring 1.0 square inch (6.5 sq cm) or more. (Item Nos. 160, 160A, 164, 166A, 166B)		

TABLE 100 K

The following defects are applicable to **bone-in loin** Item Nos. 172, 172A, 173, 174, 175, 181, 181A. Sample unit shall be one roast or item as applicable.

203	Presence of the kidney, kidney knob, and/or hanging tender.	127	Evidence of dark cutting or callused beef.
204	The internal fat covering the lumbar, sacral, pelvic, and tenderloin regions exceeding 1.0 inch (25 mm) in depth at any point.	261	Presence of the obliquus abdominis internus (flank muscle). (Item Nos. 181, 181A)
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	141	Maximum average fat thickness exceeding that specified or required in the item description.
107	A small amount or more of lean removed from major muscle(s).	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
223	Fat over the inside surface of rib exceeding 0.2 inch (5 mm) in depth at any point.	296	Product not within specified weight range.
115	Presence of chine bone measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. (Item No. 175)	297	Item not properly netted or tied when specified.
234	Presence of chine bone measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension. (Item No. 175)	298	Cut not practically free of bone dust.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 100 L

The following defects are applicable to **boneless hindquarter** Item Nos. 155A, 159, 161, 161A, 161B, 165, 165A, 165B, 166, 193. Sample unit shall be one roast or item as applicable.

- 203 Presence of the kidney, kidney knob, and/or hanging tender.
- 205 Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.
- 206 All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).
- 104 Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 208 Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 214 The tendinous ends of shanks, knuckles, and bottom rounds to a point where a cross-sectional cut exposes less than 75 percent lean tissue.
- 215 The membranous covering from skirts, flanks, hanging tenders, and abdominal section of short plates or the membranous portion of the diaphragm measuring 2.0 square inches (12.9 sq cm) or more.
- 218 Popliteal, prefemoral and/or any exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 220 Diameter of blood vessel when only a cross-section is exposed measuring 1.0 inch (25 mm) or more in any dimension or exposed blood vessel that measures 1.0 inch (25 mm) or more in length and 0.5 inch (13 mm) or more in diameter.
- 107 A small amount or more of lean removed from major muscle(s).
- 221 More than a slight amount, but less than a small amount, of lean removed from major muscle(s).
- 108 Presence of adjacent cut(s) exceeding 4 percent of cut weight.
- 222 Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.
- 127 Evidence of dark cutting or callused beef.

- 261 Presence of the obliquus abdominis internus (flank muscle). (Item Nos. 159, 161, 161A, 165, 165A, 165B, 166)
- 263 Presence of sacrosciatic ligament measuring 1.0 square inch (6.5 sq cm) or more. (Item Nos. 159, 161, 161A, 165, 165A, 165B, 166)
- 264 Presence of the thick opaque portion of the gracilis membrane measuring 1.0 square inch (6.5 sq cm) or more. (Item Nos. 159, 161, 161A, 165, 165A, 165B, 166)
- 265 Presence of the lean and fat that overlaid the aitch bone measuring 2.0 square inches (12.9 sq cm) or more and 0.5 inch (13 mm) or more in depth at any point. (Item Nos. 159, 161, 161A, 165, 165A, 165B, 166)
- 268 The shank not removed at the stifle joint and by a cut through the natural seam between the heel (gastrocnemius and superficial digital flexor). (Item Nos. 161, 161A, 165, 165A, 165B, 166)
- 140 Maximum fat thickness at any point exceeding that specified or required in the item description.
- 141 Maximum average fat thickness exceeding that specified or required in the item description.
- 292 Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 293 Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
- 294 Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
- 295 Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
- 296 Product not within specified weight range.
- 297 Item not properly netted or tied when specified.
- 298 Cut not practically free of bone dust.
- 299 Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 100 M

The following defects are applicable to **boneless round** Item Nos. 163, 163A, 167, 167A, 167B, 167C, 167D, 168, 169, 169A, 169B, 170, 170A, 171, 171A, 171B, 171C. Sample unit shall be one roast or item as applicable.

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| 205 | Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2. | 247 | Presence of loose "skin" tissue on the outside of the peeled knuckle measuring 3.0 square inches (19.4 sq cm) or more. (Item No. 167A) |
| 206 | All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams). | 254 | Presence of heavy opaque connective tissue measuring 3.0 square inches (19.4 sq cm) or more. (Item Nos. 170, 170A, 171B) |
| 104 | Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. | 263 | Presence of sacrosciatic ligament measuring 1.0 square inch (6.5 sq cm) or more. |
| 208 | Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension. | 264 | Presence of the thick opaque portion of the gracilis membrane measuring 1.0 square inch (6.5 sq cm) or more. (Item Nos. 163, 169) |
| 214 | The tendinous ends of shanks, knuckles, and bottom rounds to a point where a cross-sectional cut exposes less than 75 percent lean tissue. | 265 | Presence of the lean and fat that overlaid the aitch bone measuring 2.0 square inches (12.9 sq cm) or more and 0.5 inch (13 mm) or more in depth at any point. (Item Nos. 163, 168, 169) |
| 218 | Popliteal and/or any exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. (Item Nos. 163, 170, 170A, 171B, 171C) | 268 | The shank not removed at the stifle joint and by a cut through the natural seam between the heel (gastrocnemius and superficial digital flexor). |
| 220 | Diameter of blood vessel when only a cross-section is exposed measuring 1.0 inch (25 mm) or more in any dimension or exposed blood vessel that measures 1.0 inch (25 mm) or more in length and 0.5 inch (13 mm) or more in diameter. | 270 | The heel (gastrocnemius) not removed along the natural seam adjacent to the semitendinosus and biceps femoris. (Item Nos. 170A, 171A, 171B) |
| 107 | A small amount or more of lean removed from major muscle(s). | 292 | Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. |
| 221 | More than a slight amount, but less than a small amount, of lean removed from major muscle(s). | 293 | Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension. |
| 108 | Presence of adjacent cut(s) exceeding 4 percent of cut weight. | 294 | Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension. |
| 222 | Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight. | 295 | Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more. |
| 127 | Evidence of dark cutting or callused beef. | 296 | Product not within specified weight range. |
| 140 | Maximum fat thickness at any point exceeding that specified or required in the item description. | 297 | Item not properly netted or tied when specified. |
| 141 | Maximum average fat thickness exceeding that specified or required in the item description. | 298 | Cut not practically free of bone dust. |

299 Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25

mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 100 N

The following defects are applicable to **boneless strip loin** Item No. 180. Sample unit shall be one roast or item as applicable.

203	Presence of kidney, kidney knob, and/or hanging tender.	127	Evidence of dark cutting or callused beef.
204	The internal fat covering the lumbar, sacral, pelvic, and tenderloin regions exceeding 1.0 inch (25 mm) in depth at any point.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	141	Maximum average fat thickness exceeding that specified or required in the item description.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
104	Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
208	Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	296	Product not within specified weight range.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	297	Item not properly netted or tied when specified.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	298	Cut not practically free of bone dust.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 100 O

The following defects are applicable to **tenderloin** Item Nos. 189, 189A, 189B, 190, 190A, 191, 191A, 191B, 192, 192A. Sample unit shall be one roast or item as applicable.

205	Presence of score with a depth of 0.5 inch (13 mm) or more and 1.0 inch (25 mm) or more in length.	242	The lean surface having more than 0.2 inch (5 mm) fat thickness at any point. (Item Nos. 189A, 189B, 190, 190A, 191)
104	Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	243	Presence of surface fat not tapered down from the exposed lymph gland over the psoas major to the anterior end of the tenderloin. (Item Nos. 189, 192)
208	Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	254	Presence of membranous tissue covering the psoas major measuring 3.0 square inches (19.4 sq cm) or more. (Item No. 190A)
220	Diameter of blood vessel when only a cross-section is exposed measuring 1.0 inch (25 mm) or more in any dimension or exposed blood vessel that measures 1.0 inch (25 mm) or more in length and 0.5 inch (13 mm) or more in diameter.	261	Obliquus abdominis internus (flap) (if present) not trimmed level with the fat surface. (Item Nos. 189, 191)
107	A small amount or more of lean removed from major muscle(s).	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	296	Product not within specified weight range.
140	Maximum fat thickness at any point exceeding that specified or required in the item description.	299	Ragged edges exceeding 1.0 inch (25 mm) in length.
141	Maximum average fat thickness exceeding that specified or required in the item description.		

TABLE 100 P

The following defects are applicable to **boneless sirloin** Item Nos. 182, 183, 184, 184A, 184B, 184C, 184D, 184E, 185, 185A, 185B, 185C, 185D, 186. Sample unit shall be one roast or item as applicable.

205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	263	Presence of sacrosciatic ligament measuring 1.0 square inch (6.5 sq cm) or more. (Not applicable to Item No. 184C)
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	272	Presence of underlying connective tissue after removal of the obliquus abdominis internus measuring 3.0 square inches (19.4 sq cm) or more. (Item Nos. 183, 186)
104	Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
208	Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	296	Product not within specified weight range.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	297	Item not properly netted or tied when specified.
127	Evidence of dark cutting or callused beef.	298	Cut not practically free of bone dust.
254	Presence of heavy opaque connective tissue measuring 3.0 square inches (19.4 sq cm) or more.	299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)
140	Maximum fat thickness at any point exceeding that specified or required in the item description.		
141	Maximum average fat thickness exceeding that specified or required in the item description.		

TABLE 100 Q ^{1/}

The following defects are applicable to all **bone-in portion cut** items. Sample unit shall be one portion cut item. No individual defect shall be scored more than once per sample unit.

209	The dorsal side of the short rib not at an approximate right angle to the rib bones nor approximately parallel with ventral side. (Item No. 1123)	164	Presence of any portion of unauthorized muscles or bone exceeding 0.5 inch (13 mm) in any dimension on either side.
110	Backstrap measuring 0.2 inch (5 mm) or more inch in one dimension and 0.5 inch (13 mm) or more in a second dimension.	266	Thickness of portion cut not within tolerance permitted.
118	Exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	267	Thickness uniformity of portion varies more than tolerance.
127	Evidence of dark cutting or callused beef.	169	Diameter of tenderloin less than requirement.
140	Maximum fat thickness at any point exceeding that specified or required in the item description.	271	Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from outer edge.
141	Maximum average fat thickness exceeding that specified or required in the item description.	281	Presence of tag end measuring 1.0 inch (25 mm) or more in any dimension and will not support the weight of the steak when suspended.
249	Serratus ventralis not continuous for at least two ribs on both the dorsal and ventral sides of the short rib. (Item No. 1123)	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
260	Weight of portion cut not within tolerance permitted.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
262	Score more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth.	294	Presence of any portion of the spinal cord.
163	Ventral edge of rib and loin items exceeding requirement by 0.2 inch (5 mm) or more.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
		298	Cut not practically free of bone dust.

^{1/} No more than a small amount of suitable lean may be removed from properly prepared cuts prior to production of respective portion cut items (i.e., strip steaks may not be produced only from the posterior portion of a strip loin or rib steaks produced only from the anterior portion of a rib item). The AMS agent shall determine the supervision necessary to assure all suitable lean is used.

TABLE 100 R ^{1/}

The following defects are applicable to all **boneless portion cut** items except for Item Nos. 1100, 1101, 1102. Sample unit shall be 1 portion cut item. No individual defect shall be scored more than once per sample unit.

- | | | |
|-----|--|---|
| 102 | Bone measuring 0.2 inch (5 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. | requirement by 0.2 inch (5 mm) or more. |
| 109 | Cartilage measuring 0.3 inch (8 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. | |
| 110 | Backstrap measuring 0.2 inch (5 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension. | |
| 215 | The membranous covering from skirts, flanks, hanging tenders, and abdominal section of short plates or the membranous portion of the diaphragm measuring 2.0 square inches (12.9 sq cm) or more. | |
| 118 | Exposed lymph gland measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. | |
| 220 | Presence of blood vessel measuring 0.5 inch (13 mm) or more in one dimension and 0.1 inch (2 mm) or more in a second dimension. | |
| 127 | Evidence of dark cutting or callused beef. | |
| 226 | End of diaphragm not reasonably squared off. | |
| 252 | Presence of unauthorized heavy connective tissue measuring 1.0 inch (25 mm) or more in one dimension and 0.1 inch (2 mm) or more in a second dimension. | |
| 253 | Presence of gluteus medius muscle on both sides of a strip loin steak, center cut (Item No. 1180A). | |
| 260 | Weight of portion cut not within tolerance permitted. | |
| 262 | Score into the lean more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth. | |
| 140 | Maximum fat thickness at any point exceeding that specified or required in the item description. | |
| 141 | Maximum average fat thickness exceeding that specified or required in the item description. | |
| 163 | Ventral edge of rib and loin items exceeding | |

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|-----|--|--|
| 164 | Presence of any portion of unauthorized muscles or bone exceeding 0.5 inch (13 mm) in any dimension on either side. | support the weight of the steak when suspended. |
| 266 | Thickness of portion cut not within tolerance permitted (for 1136, 1136A, 1136B, 1136C, 1137, 1137A thickness does not meet thickness requirements from resulting plate size). | 289 Ground beef patty or flaked and formed steak having color that is abnormally light (i.e., light grayish pink). |
| 267 | Thickness uniformity of portion varies more than tolerance. | 290 Presence of green/brown/gray areas 1.0 square inch (6.5 sq cm) or more. (Item No. 1138A) |
| 271 | Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from outer edge. (Not applicable to Item Nos. 1136, 1136A, 1136B, 1136C, 1137, 1137A) | 292 Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. |
| 277 | Folds in steaks resulting in overlap on more than 20 percent of the surface area. (Item No. 1138A) | 293 Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension. |
| 279 | Specified dimensions (e.g., diameter, length and width) of portion cut not within 0.5 inch (13 mm). | 294 Presence of any portion of the spinal cord. |
| 281 | Presence of tag end measuring 1.0 inch (25 mm) or more in any dimension and will not | 295 Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more. |
| | | 298 Cut not practically free of bone dust. |

1/ No more than a small amount of suitable lean may be removed from properly prepared cuts prior to production of respective portion cut items (i.e., strip steaks may not be produced only from the posterior portion of a strip loin or rib steaks produced only from the anterior portion of a rib item). The AMS agent shall determine the supervision necessary to assure all suitable lean is used. Raw materials used for ground beef patties, flaked and formed steaks, and sliced and formed steaks shall be examined in accordance with items described in respective item description.

TABLE 100 S ^{1/}

The following defects are applicable to Item Nos. 1100, 1101, 1102. Sample unit shall be 1 portion cut item. No individual defect shall be scored more than once per sample unit.

102	Bone or cartilage measuring 0.2 inch (5 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
109	Cartilage measuring 0.3 inch (8 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum average fat thickness exceeding that specified or required in the item description.
110	Backstrap measuring 0.2 inch (5 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	269	Surface and/or seam fat measuring 0.1 inch (2 mm) or more in thickness exceeding 50 percent of total circumference of the steak. (Item No. 1102)
118	Exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	270	Surface and/or seam fat exceeding 15 percent of total area on either side of the steak. (Item Nos. 1100, 1101)
220	Presence of blood vessel measuring 0.5 inch (13 mm) or more in one dimension and 0.1 inch (2 mm) or more a second dimension.	271	Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from outer edge.
252	Presence of heavy opaque connective tissue on outer edge of steaks measuring 1.0 inch (25 mm) or more in one dimension and 0.3 inch (8 mm) or more in a second dimension.	278	Knitting of two or more pieces together. (Item Nos. 1101, 1102)
255	Presence of intermuscular heavy connective tissue measuring 0.2 inch (5 mm) or more in thickness.	279	Specified dimensions (e.g., diameter, length and width) of portion cut not within 0.5 inch (13 mm).
260	Weight of portion cut not within tolerance permitted.	281	Presence of tag end measuring 1.0 inch (25 mm) or more in any dimension and will not support the weight of the steak when suspended.
262	Score more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
127	Evidence of dark cutting or callused beef.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
266	Thickness of portion cut not within tolerance permitted.	194	Presence of any portion of the spinal cord.
267	Thickness uniformity of portion varies more than tolerance.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq cm) or more.
		298	Cut not practically free of bone dust.

^{1/} The AMS agent shall determine the supervision necessary to assure proper specified origin of all raw materials used.

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200B.....	200 A	229.....	200 A	234B.....	200 I
202.....	200 A	229A.....	200 A	234C.....	200 I
203.....	200 A	230.....	200 A	234D.....	200 I
204.....	200 B	231.....	200 F	234E.....	200 I
204A.....	200 B	232.....	200 F	234F.....	200 I
204B.....	200 B	232A.....	200 F	234G.....	200 I
204C.....	200 B	232B.....	200 G	235.....	200 A
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206.....	200 C	232E.....	200 G	239.....	200 J
207.....	200 C	233.....	200 H	242.....	200 F
207A.....	200 C	233A.....	200 H	243.....	200 F
208.....	200 D	233B.....	200 H	244.....	200 F
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1234.....	200 N
1234A.....	200 N
1296.....	200 N
1296A.....	200 N
1297.....	200 N
1297A.....	200 N
1297B.....	200 N

TABLE 200 A

The following defects are applicable to **carcass** Item Nos. 200, 200A, 200B, 202, 203, 229, 229A, 230, 235, 236. Sample unit shall be 1 item.

101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.	108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.
201	The diaphragm, when present, not firmly attached and the membranous portion exceeding 0.25 inch (6 mm) from the lean at any point.	222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.
102	Trotter (lower foreshank) not properly removed. (Item No. 200B)	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
202	Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum average fat thickness exceeding that specified.
103	Cut separations not in accordance with item descriptions. (Item No. 200A, 200B)	142	Presence of the kidney, kidney knob, spleen, and/or hanging tender.
204	The internal fat covering the lumbar, sacral, pelvic, and tenderloin regions exceeding 0.5 inch (13 mm) in depth at any point.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
105	Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
107	A small amount or more of lean removed from major muscle(s).	296	Product not within specified weight range.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	297	Item not properly netted or tied when specified.
		298	Cut not practically free of bone dust.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 200 B

The following defects are applicable to **rack** Item Nos. 204, 204A, 204B, 204C, 204D, 204E. Sample unit shall be 1 item.

101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.	223	Fat over the inside surface of rib exceeding 0.2 inch (5 mm) in depth at any point.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	227	Presence of the diaphragm and fat on the ventral surface of the vertebrae exceeding 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	233	The underlying fat covering the longissimus dorsi and spinalis dorsi not trimmed to an uniform thickness for the entire seamed surface. (No more than 0.5 difference). (Item nos. 204C, 204D, 204E)
104	Unauthorized bone or cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
208	Unauthorized bone or cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum average fat thickness exceeding that specified.
105	Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
106	Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension. (Item Nos. 204C, 204D)	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
210	Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension. (Item Nos. 204C, 204D)	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	296	Product not within specified weight range.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	297	Item not properly netted or tied when specified.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	298	Cut not practically free of bone dust.
112	Chine bone not removed as specified. (Item Nos. 204A, 204B, 204C, 204D)	299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)
116	Presence of fat cover. (Item Nos. 204B, 204C, 204D, 204E)		

TABLE 200 C

The following defects are applicable to ***bone-in shoulder*** Item Nos. 206, 207, 207A. Sample unit shall be 1 item.

		140	Maximum fat thickness at any point exceeding that specified or required in the item description.
101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.		
202	Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum average fat thickness exceeding that specified.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
105	Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	296	Product not within specified weight range.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	297	Item not properly netted or tied when specified.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	298	Cut not practically free of bone dust.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 200 D

The following defects are applicable to **boneless shoulder** Item Nos. 208, 208A, 208B, 208C. Sample unit shall be 1 item.

101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.	220	Diameter of blood vessel when only a cross-section is exposed measuring 0.5 inch (13 mm) or more in any dimension or exposed blood vessel that measures 0.5 inch (13 mm) or more in length and 0.5 inch (13 mm) or more in diameter.
201	The diaphragm, when present, not firmly attached and the membranous portion exceeding 0.25 inch (6 mm) from the lean at any point.	107	A small amount or more of lean removed from major muscle(s).
202	Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.
207	The breast not separated from the foreshank through the natural seam.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
104	Bone or cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum average fat thickness exceeding that specified.
208	Bone or cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
105	Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
106	Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension. (Item Nos. 204C, 204D)	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
210	Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension. (Item Nos. 204C, 204D)	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
212	Presence of tendons on elbow end of the outside shoulder protruding more than 0.3 inch (8 mm) from the surface of the lean.	296	Product not within specified weight range.
218	Prescapular and/or any exposed lymph glands measuring 0.3 inch (8 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	297	Item not properly netted or tied when specified.
		298	Cut not practically free of bone dust.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 200 E

The following defects are applicable to **breast/rib/shank** Item Nos. 209, 209A, 209B, 210. Sample unit shall be 1 item.

<p>101 Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.</p> <p>201 The diaphragm, when present, not firmly attached and the membranous portion exceeding 0.25 inch (6 mm) from the lean at any point.</p> <p>102 Trotter (lower foreshank) not properly removed.</p> <p>202 Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>105 Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.</p> <p>205 Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.</p> <p>207 The brisket not separated from the foreshank through the natural seam.</p> <p>124 Rib number incorrect.</p> <p>140 Maximum fat thickness at any point exceeding that specified or required in the item description.</p> <p>141 Maximum average fat thickness exceeding that specified.</p> <p>243 Evidence of cartilaginous junctures of the rib and thoracic vertebrae.</p>	<p>248 Presence of diaphragm, and serous membrane (peritoneum) exceeding 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) in a second dimension.</p> <p>251 The latissimus dorsi and exterior fat cover not removed. (Item No. 209A)</p> <p>256 Ribs exceed specified width (distance between the dorsal and ventral sides) of the rib sections by 0.5 inch (13 mm). (Item No. 209A)</p> <p>182 Cross section of costal cartilages not evident.</p> <p>292 Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>293 Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>295 Presence of dehydrated surfaces measuring 1.0 square inch or more.</p> <p>296 Product not within specified weight range.</p> <p>298 Cut not practically free of bone dust.</p> <p>299 Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)</p>
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TABLE 200 F

The following defects are applicable to **bone-in loin** Item Nos. 231, 232, 232A, 242, 243, 244. Sample unit shall be 1 piece.

<p>101 Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.</p> <p>203 Presence of the kidney, kidney knob, spleen, and/or hanging tender.</p> <p>204 The internal fat covering the lumbar, sacral, pelvic, and tenderloin regions exceeding 0.5 inch (13 mm) in depth at any point.</p> <p>105 Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.</p> <p>205 Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.</p> <p>206 All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).</p> <p>107 A small amount or more of lean removed from major muscle(s).</p> <p>221 More than a slight amount, but less than a small amount, of lean removed from major muscle(s).</p> <p>108 Presence of adjacent cut(s) exceeding 4 percent of cut weight.</p> <p>222 Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.</p>	<p>140 Maximum fat thickness at any point exceeding that specified or required in the item description.</p> <p>141 Maximum average fat thickness exceeding that specified.</p> <p>273 Evidence of the spinal groove measuring 1.0 inch (25 mm) or more in any dimension.</p> <p>292 Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>293 Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>294 Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.</p> <p>295 Presence of dehydrated surfaces measuring 1.0 square inch or more.</p> <p>296 Product not within specified weight range.</p> <p>297 Item not properly netted or tied when specified.</p> <p>298 Cut not practically free of bone dust.</p> <p>299 Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)</p>
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TABLE 200 G

The following defects are applicable to **boneless loin** Item Nos. 232B, 232C, 232D, 232E, 246. Sample unit shall be 1 piece.

101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.	108	muscle(s). Presence of adjacent cut(s) exceeding 4 percent of cut weight.
203	Presence of kidney, kidney knob, spleen, and/or hanging tender.	222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.
204	The internal fat covering the lumbar, sacral, pelvic, and tenderloin regions exceeding 0.5 inch (13 mm) in depth at any point.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	141	Maximum average fat thickness exceeding that specified.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
104	Bone or cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
208	Bone or cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
105	Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
220	Diameter of blood vessel when only a cross-section is exposed measuring 0.5 inch (13 mm) or more in any dimension or exposed blood vessel that measures 0.5 inch (13 mm) or more in length and 0.5 inch (13 mm) or more in diameter.	296	Product not within specified weight range.
107	A small amount or more of lean removed from major muscle(s).	297	Item not properly netted or tied when specified.
221	More than a slight amount, but less than a small amount, of lean removed from major	298	Cut not practically free of bone dust.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 200 H

The following defects are applicable to ***bone-in leg*** Item Nos. 233, 233A, 233B, 233C, 233D, 233E, 233F, 233G. Sample unit shall be one piece.

101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.		that specified or required in the item description.
102	Trotter (lower foreshank) not properly removed.	141	Maximum average fat thickness exceeding that specified.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	257	Presence of gambrel cord protruding more than 0.3 inch (8 mm).
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	261	Presence of the obliquus internus abdominis and rectus abdominis (flank muscles).
104	Bone measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	265	Presence of the lean and fat that overlaid the aitch bone measuring 1.0 square inch. (Item 233G)
208	Bone or cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	268	The shank not removed as specified (at the stifle joint and by a cut through the natural seam between the heel (gastrocnemius) and superficial digital flexor.
105	Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	296	Product not within specified weight range.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	297	Item not properly netted or tied when specified.
140	Maximum fat thickness at any point exceeding	298	Cut not practically free of bone dust.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 200 I

The following defects are applicable to **boneless leg** Item Nos. 234, 234A, 234B, 234C, 234D, 234E, 234F, 234G, 245. Sample unit shall consist of 1 piece.

101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.	222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	141	Maximum average fat thickness exceeding that specified.
104	Bone and cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	257	Presence of gambrel cord protruding more than 0.3 inch (8 mm).
208	Bone and cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	261	Presence of the obliquus internus abdominis and rectus abdominis (flank muscles).
105	Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.	263	Presence of sacrosciatic ligament measuring 1.0 square inch or more.
211	Calcified (scratchy) periosteum measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	264	Presence of the thick opaque portion of the gracilis membrane measuring 1.0 square inches or more.
214	The tendinous ends of shanks, knuckles, and bottoms having a cross-sectional cut exposing less than 75 percent lean tissue.	265	Presence of the lean and fat that overlaid the aitch bone measuring 1.0 square inch.
218	Popliteal and/or any exposed lymph glands measuring 0.3 inch (8 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	268	The shank not removed as specified (at the stifle joint and by a cut through the natural seam between the heel (gastrocnemius) and superficial digital flexor.
220	Diameter of blood vessel when only a cross-section is exposed measuring 0.5 inch (13 mm) or more in any dimension or exposed blood vessel that measures 0.5 inch (13 mm) or more in length and 0.5 inch (13 mm) or more in diameter.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	296	Product not within specified weight range.
		297	Item not properly netted or tied when specified.
		298	Cut not practically free of bone dust.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 200 J^{1,2/}

The following defects are applicable to *lean trim/cubes/kabobs* Item Nos. 238, 239, 295, 295A. Lot and sample unit shall be 5 lbs. finished product.

101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.	228	Presence of two or more pieces that are less than 0.5 inch (13 mm) at any point. (Item No. 239)
104	Bone and cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	131	More than 10 percent, by weight, of sample unit consisting of dices which have any individual surface exceeding 2.5 inches (6.2 cm) in length and/or are not of a size equivalent to a 1.5 inches (3.8 cm) to 2.0 inches (5.0 cm) cube. (Item No. 295A)
208	Bone and cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	133	More than 10 percent, by weight, of sample unit consisting of dices that have exposed surface and/or seam fat exceeding 0.25 inch (6 mm) thickness at any point.
106	Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	134	More than 10 percent, by weight, of the sample unit consisting of pieces having surface area that is less than 6.0 square inches on one side. (Item No. 239)
210	Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension.	255	Presence of two dices having connective tissue measuring more than 0.2 inch (5 mm) in thickness (width) (score one defect per two dices).
218	Exposed lymph glands measuring 0.3 inch (8 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	258	Presence of 2 or more acceptable dice size pieces that consist entirely of fat (do not score if defect 133 is scored in same sample unit).
220	Diameter of blood vessel when only a cross-section is exposed measuring 0.5 inch (13 mm) or more in any dimension or exposed blood vessel that measures 0.5 inch (13 mm) or more in length and 0.5 inch (13 mm) or more in diameter.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
127	Evidence of callused meat.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
129	More than 15 percent, by weight, of sample unit consisting of dices which have any individual surface exceeding 2.5 inches (6.2 cm) in length and/or are not of a size equivalent to a 0.5 inch (13 mm) to 1.25 inch (3.1 cm) cube. (Item No. 295)	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
128	Less than 75 percent of lean exposed and remaining fat exceeds 0.25 inch (6 mm) depth at any point. (Item No. 239)	296	Product not within specified weight range.
		298	Cut not practically free of bone dust.

1/ Presence of shank and/or, unless otherwise specified, heel meat shall cause rejection of the lot.

2/ Presence of product having ground appearance shall cause rejection of the lot.

TABLE 200 K

The following defects are applicable to **ground lamb** Item Nos. 296, 296A. Fresh-chilled boneless lamb shall be examined prior to grinding. Sample unit shall consist of a minimum of 10 pounds of adjacent meat. Evidence of lamb after final grinding appearing abnormally light in color (i.e. light grayish pink) shall cause rejection of the lot.

101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.	219	Cod, udder, kidney, pelvic, or heart fat having a surface area measuring 2.0 square inches or more and 0.5 inch (13 mm) or more in depth at any point.
104	Bone or cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	220	Diameter of blood vessel when only a cross-section is exposed measuring 0.5 inch (13 mm) or more in any dimension or exposed blood vessel that measures 0.5 inch (13 mm) or more in length and 0.5 inch (13 mm) or more in diameter.
208	Bone or cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	253	Presence of 2 or more pieces of any size which more than 50 percent of its surface area is composed of heavy opaque connective tissue, bone, cartilage, or calcified periosteum (do not score if defects 104, 208, 212, 215, or 254 are scored for those pieces).
106	Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	254	Presence of heavy opaque connective tissue measuring 3.0 square inches or more.
210	Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
212	Presence of tendons on elbow end of the outside shoulder protruding more than 0.3 inch (8 mm) from the surface of the lean.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
214	The tendinous ends of shanks, knuckles, and bottoms having a cross-sectional cut exposing less than 75 percent lean tissue.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
215	The membranous covering from skirts, flanks, hanging tenders, and abdominal section of the breasts or the membranous portion of the diaphragm measuring 3.0 square inches or more.	296	Product not within specified weight range.
218	Popliteal, prescapular, prefemoral and/or any exposed lymph glands measuring 0.3 inch (8 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	298	Cut not practically free of bone dust.

TABLE 200 L^{1,2/}

The following defects are applicable to **cubed/braising steak** Item Nos. 1200, 1201, and 1202. Sample unit shall be 1 portion cut item. No individual defect shall be scored more than once per sample unit.

101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.	262	Score more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth.
104	Bone measuring 0.2 inch (5 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	266	Thickness of portion cut not within tolerance permitted.
109	Cartilage measuring 0.3 inch (8 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	267	Thickness uniformity of portion varies more than tolerance.
110	Backstrap measuring 0.2 inch (5 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	269	Surface and/or seam fat measuring 0.1 inch (2 mm) or more in thickness exceeding 50 percent of total circumference of the steak. (Item No. 1202)
118	Exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	270	Surface and/or seam fat exceeding 15 percent of total area on either side of the steak. (Item Nos. 1200, 1201)
127	Evidence of callused meat.	271	Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from outer edge.
140	Maximum fat thickness at any point exceeding that specified or required in the item description.	278	Knitting of two or more pieces together. (Item Nos. 1201, 1202)
141	Maximum average fat thickness exceeding that specified.	279	Specified dimension (e.g., diameter, length and width) of portion cut not within 0.5 inch (13 mm).
254	Presence of heavy opaque connective tissue.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
255	Presence of intermuscular heavy connective tissue measuring 0.2 inch (5 mm) or more in any dimension.	298	Cut not practically free of bone dust.
260	Weight of portion cut not within tolerance permitted.		

1/ The AMS agent shall determine the supervision necessary to assure proper specified origin of all raw materials used.
2/ Presence of shank and/or, unless otherwise specified, heel meat shall cause rejection of the lot.

TABLE 200 M^{1/}

The following defects are applicable to all ***bone-in portion cut*** items. Sample unit shall be one portion cut item. No individual defect shall be scored more than once per sample unit.

101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.	266	Thickness of portion cut not within tolerance permitted.
127	Evidence of callused meat.	267	Thickness uniformity of portion varies more than tolerance.
140	Maximum fat thickness at any point exceeding that specified or required in the item description.	271	Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from outer edge.
141	Maximum average fat thickness exceeding that specified.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
260	Weight of portion cut not within tolerance permitted.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
262	Score more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth.	294	Presence of any portion of the spinal cord.
163	Ventral edge of rib and loin items exceeding requirement by 0.2 inch (5 mm) or more.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
164	Presence of any portion of unauthorized muscles or bones exceeding 0.5 inch (13 mm) in any dimension on either side.	298	Cut not practically free of bone dust.

^{1/}No more than a small amount of suitable lean may be removed from properly prepared cuts prior to production of respective portion cut items (i.e. loin chops may not be produced only from the posterior portion of a loin or rib chops produced only from the anterior portion of a rack item). The AMS agent shall determine the supervision necessary to assure all suitable lean is used.

TABLE 200 N^{1,2/}

The following defects are applicable to all **boneless portion cut** items except for Item Nos. 1200, 1201, and 1202. Sample unit shall be 1 portion cut item. No individual defect shall be scored more than once per sample unit.

101	Fell membrane measures greater than 1.0 inch (25 mm) in any dimension.	266	Thickness of portion cut not within tolerance permitted.
118	Exposed lymph gland measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	267	Thickness uniformity of portion varies more than tolerance.
220	Presence of blood vessel measuring 0.5 inch (13 mm) or more in one dimension and 0.1 inch (2 mm) or more in a second dimension (when measured at right angle to each other).	271	Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from outer edge. (Not applicable to Item Nos. 1296, 1296A, 1297, 1297A, 1297B)
127	Evidence of callused meat.	291	Presence of tag ends measuring 0.5 inch (13 mm) or more in any dimension and will not support the weight of the chop when suspended.
140	Maximum fat thickness at any point exceeding that specified or required in the item description.	292	Bruise measuring 0.5 inch (13 mm) or more in any dimension.
141	Maximum average fat thickness exceeding that specified.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.1 inch (2 mm) in a second dimension (when measured at right angles to each other).
260	Weight of portion cut not within tolerance permitted.	294	Presence of any portion of the spinal cord.
262	Score into the lean more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
163	Ventral edge of rib and loin items exceeding requirement by 0.2 inch (5 mm) or more.	298	Cut not practically free of bone dust.

1/ No more than a small amount of suitable lean may be removed from properly prepared cuts prior to production of respective portion cut items (i.e. loin chops may not be produced only from the posterior portion of a loin or rib chops produced only from the anterior portion of a rack item). The AMS agent shall determine the supervision necessary to assure all suitable lean is used. Raw materials used for ground beef patties, flaked and formed steaks, and sliced and formed steaks shall be examined in accordance with items described in respective item description.

2/ Presence of shank and/or, unless otherwise specified, heel meat shall cause rejection of the lot.

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TABLE 300 A

The following defects are applicable to Item Nos. 300, 303, 304, 304A, 330, 330A, 334, 341. Sample unit shall be 1 item.

201	The diaphragm, when present, not firmly attached and the membranous portion exceeding 0.25 inch (6 mm) from the lean at any point.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
202	Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum average fat thickness exceeding that specified.
204	The internal fat covering the lumbar, sacral, pelvic, and tenderloin regions Item No. 341 not trimmed as specified.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
105	Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
211	Ragged edges exceeding 1.0 inch (25 mm) in length.	297	Item not properly netted or tied when specified.
107	A small amount or more of lean removed from major muscle(s).	299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).		
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.		
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.		

TABLE 300 B

The following defects are applicable to Item Nos. 306, 306A, 306B, 306C, 306D, 306E, 307, 307A. Sample unit shall be 1 item.

205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.
104	Unauthorized bone or cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	116	Presence of exterior fat cover (307, 307A).
208	Unauthorized bone or cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	227	Presence of the diaphragm and fat on the ventral surface of the vertebrae exceeding 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
105	Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
106	Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	141	Maximum average fat thickness exceeding that specified.
210	Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
211	Ragged edges exceeding 1.0 inch (25 mm) in length.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
		297	Item not properly netted or tied when specified.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 300 C

The following defects are applicable to Item Nos. 308, 308A, 309, 309A, 310D. Sample unit shall be 1 item.

202	Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	141	Maximum average fat thickness exceeding that specified.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
105	Evidence of callus measuring 0.5 inch (13 mm) or more in any direction.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
211	Ragged edges exceeding 1.0 inch (25 mm) in length.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	297	Item not properly netted or tied when specified.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.		

TABLE 300 D

The following defects are applicable to Item Nos. 309B, 309C, 309D, 309E, 309F, 309G, 310, 310A, 310B, 310C, 311, 311A, 311B, 311C. Sample unit shall be 1 item.

201	The diaphragm, when present, not firmly attached and the membranous portion exceeding 0.25 inch (6 mm) from the lean at any point.	107	0.2 inch (5 mm) or more in a second dimension.
202	Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in any dimension.	221	A small amount or more of lean removed from major muscle(s).
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	108	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	222	Presence of adjacent cut(s) exceeding 4 percent of cut weight.
207	The brisket not separated from the foreshank through the natural seam.	127	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.
104	Bone or cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	140	Evidence of callused meat.
208	Bone or cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum fat thickness at any point exceeding that specified or required in the item description.
106	Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	292	Maximum average fat thickness exceeding that specified.
210	Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension.	293	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
211	Ragged edges exceeding 1.0 inch (25 mm) in length.	294	Blood clot measuring 0.5 inch (13 mm) or more in any dimension.
213	Calcified (scratchy) periosteum measuring 1.0 inch (25 mm) or more in one dimension and	295	Presence of any portion of the spinal cord 0.5 inch (13 mm) or more in any dimension.
		296	Presence of dehydrated surfaces measuring 1.0 square inch or more.
		297	Product not within specified weight range.
		298	Item not properly netted or tied when specified.
			Cut not practically free of bone dust.

TABLE 300 E

The following defects are applicable to Item Nos. 312, 313, 314, 337. Sample unit shall be 1 item.

202	Heart fat or thymus glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
207	The brisket not separated from the foreshank through the natural seam.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
211	Ragged edges exceeding 1.0 inch (25 mm) in length.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
140	Maximum fat thickness at any point exceeding that specified or required in the item description.	296	Product not within specified weight range.
141	Maximum average fat thickness exceeding that specified.	298	Cut not practically free of bone dust.
248	Presence of diaphragm, and serous membrane (peritoneum) exceeding 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) in a second dimension on short ribs.		

TABLE 300 F

The following defects are applicable to Item Nos. 331, 332. Sample unit shall be 1 piece.

203	Presence of the kidney, kidney knob, and/or hanging tender.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
204	The internal fat covering the lumbar, sacral, pelvic, and tenderloin regions exceeding 0.5 inch (13 mm) in depth at any point.	141	Maximum average fat thickness exceeding that specified.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
211	Ragged edges exceeding 1.0 inch (25 mm) in length.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
107	A small amount or more of lean removed from major muscle(s).	296	Product not within specified weight range.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	297	Item not properly netted or tied when specified.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	298	Cut not practically free of bone dust.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)
127	Evidence of callused meat.		

TABLE 300 G

The following defects are applicable to Item Nos. 342, 344, 344A, 346, 346A, 347. Sample unit shall be 1 piece.

		127	Evidence of callused meat.
203	Presence of kidney, kidney knob, and/or hanging tender.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
204	The internal fat covering the lumbar, sacral, pelvic, and tenderloin regions exceeding 0.5 inch (13 mm) in depth at any point.	141	Maximum average fat thickness exceeding that specified.
205	Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
206	All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
104	Bone or cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
208	Bone or cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
211	Ragged edges exceeding 1.0 inch (25 mm) in length.	296	Product not within specified weight range.
213	Calcified (scratchy) periosteum measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	297	Item not properly netted or tied when specified.
107	A small amount or more of lean removed from major muscle(s).	298	Cut not practically free of bone dust.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.		
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.		

TABLE 300 H

The following defects are applicable to Item Nos. 335, 336, 349, 349A, 350, 351, 352, 352A, 363, 363A and 363B. Sample unit shall consist of 1 piece.

- 205 Presence of score more than 0.5 inch (13 mm) in depth at deepest point and when depth is multiplied by the length is equal to or greater than 2.
- 206 All cut separations not forming an approximate right angle with the skin surface (not applicable for cut separations through natural seams).
- 104 Bone and cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 208 Bone and cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 211 Ragged edges exceeding 1.0 inch (25 mm) in length.
- 213 Calcified (scratchy) periosteum measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 214 The tendinous ends of shanks, knuckles, and bottoms having a cross-sectional cut exposing less than 75 percent lean tissue.
- 218 Popliteal and/or any exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
- 220 Diameter of blood vessel when only a cross-section is exposed measuring 1.0 inch (25 mm) or more in any dimension or exposed blood vessel that measures 1.0 inch (25 mm) or more in length and 0.5 inch (13 mm) or more in diameter.
- 107 A small amount or more of lean removed from major muscle(s).
- 221 More than a slight amount, but less than a small amount, of lean removed from major muscle(s).
- 108 Presence of adjacent cut(s) exceeding 4 percent of cut weight.
- 222 Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.

127	Evidence of callused meat.	superficial digital flexor (Item No. 336) .
140	Maximum fat thickness at any point exceeding that specified or required in the item description.	292 Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
141	Maximum average fat thickness exceeding that specified.	293 Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
263	Presence of sacrosciatic ligament measuring 1.0 square inch or more (Item Nos. 335, 336, 350, 352, 352A).	295 Presence of dehydrated surfaces measuring 1.0 square inch or more.
264	Presence of the thick opaque portion of the gracilis membrane measuring 1.0 square inches or more (Item Nos. 349, 349A).	296 Product not within specified weight range.
265	Presence of the lean and fat that overlaid the aitch bone measuring 2.0 square inches or more and 0.5 inch (13 mm) or more in depth at any point (Item Nos. 335, 336).	297 Item not properly netted or tied when specified.
268	The shank not removed as specified (at the stifle joint and by a cut through the natural seam between the heel (gastrocnemius) and	298 Cut not practically free of bone dust.
		299 Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 300 I ^{1/2}

The following defects are applicable to Item Nos. 339, 395, 395A. Lot and sample unit shall be 5 lbs. finished product.

104	Bone and cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	131	More than 10 percent, by weight, of sample unit consisting of dices which have any individual surface exceeding 3.0 inches in length and/or are not of a size equivalent to a 1.5 inches (3.8 cm) to 2.0 inches (5.0 cm) cube. (Item no. 395A)
208	Bone and cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	133	More than 10 percent, by weight, of sample unit consisting of dices that have exposed surface and/or seam fat exceeding 1/8 inch (3 mm) thickness at any point.
106	Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	255	Presence of two dices having connective tissue measuring more than 0.2 inch (5 mm) in thickness (width) (score one defect per two dices).
210	Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension.	258	Presence of 2 or more acceptable dice size pieces that consist entirely of fat (do not score if defect 133 is scored in same sample unit).
213	Calcified (scratchy) periosteum measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	290	Presence of green/brown/gray areas 1.0 square inch or more.
218	Exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	293	Blood clot measuring 0.5 inch (13 mm) or more in any dimension.
220	Diameter of blood vessel measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
127	Evidence of callused meat.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
129	More than 25 percent, by weight, of sample unit consisting of dices which have any individual surface exceeding 2.5 inches in length and/or are not of a size equivalent to a 0.75 inch to 1.25 inch cube. (Item no. 395)		

1/ Presence of shank and/or heel meat (unless otherwise specified) shall cause rejection of the lot.

2/ Presence of product having ground appearance shall cause rejection of the lot.

TABLE 300 J

The following defects are applicable to the material requirements for Item Nos. 338, 396, 396A, 396B, 397, 397A. Fresh-chilled boneless veal shall be examined prior to grinding. Sample unit shall consist of a minimum of 10 pounds of adjacent meat.

104	Bone or cartilage measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	218	Popliteal, prescapular, prefemoral and/or any exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
208	Bone or cartilage measuring 0.2 inch (5 mm) or more but less than 0.5 inch (13 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	219	Cod, udder, kidney, pelvic, or heart fat having a surface area measuring 2.0 square inches or more and 0.5 inch (13 mm) or more in depth at any point.
106	Backstrap measuring 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	220	Diameter of blood vessel when only a cross-section is exposed measuring 1.0 inch (25 mm) or more in any dimension or exposed blood vessel that measures 1.0 inch (25 mm) or more in length and 0.5 inch (13 mm) or more in diameter.
210	Backstrap measuring 0.2 inch (5 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) or more in a second dimension.	253	Presence of 2 or more pieces of any size which more than 50 percent of its surface area is composed of heavy opaque connective tissue, bone, cartilage, or calcified periosteum (do not score if defects 104, 208, 211, 212, 215, or 254 are scored for those pieces).
211	Calcified (scratchy) periosteum measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	254	Presence of heavy opaque connective tissue measuring 3.0 square inches or more.
212	Presence of tendons on elbow end of clod of the shoulder clod protruding more than 0.3 inch (8 mm) from the surface of the lean.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
214	The tendinous ends of shanks, knuckles, and bottoms having a cross-sectional cut exposing less than 75 percent lean tissue.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
215	The membranous covering from skirts, flanks, hanging tenders, and abdominal section of short plates or the membranous portion of the diaphragm measuring 3.0 square inches or more.	294	Presence of any portion of the spinal cord measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.

TABLE 300 K ^{1/2}

The following defects are applicable to Item Nos. 1300, 1301, and 1302. Sample unit shall be 1 portion cut item. No individual defect shall be scored more than once per sample unit.

108	Bone measuring 0.2 inch (5 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	270	Surface and/or seam fat exceeding 15 percent of total area on either side of the steak. (Item Nos. 1300, 1301)
109	Cartilage measuring 0.3 inch (8 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	271	Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from outer edge.
110	Backstrap measuring 0.2 inch (5 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	278	Knitting of two or more pieces together. (Item Nos. 1301, 1302)
118	Exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	279	Specified dimension (e.g., diameter, length and width) of portion cut not within 0.5 inch (13 mm).
255	Presence of heavy connective tissue measuring 0.2 inch in thickness.	291	Presence of tag end measuring 1.0 inch or more in any dimension and will not support the weight of the portion cut when suspended.
260	Weight of portion cut not within tolerance permitted.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
262	Score more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
266	Thickness of portion cut not within tolerance permitted.	141	Maximum average fat thickness exceeding that specified.
267	Thickness uniformity of portion varies more than tolerance.	298	Cut not practically free of bone dust.
269	Surface and/or seam fat measuring 0.1 inch (2 mm) or more in thickness exceeding 50 percent of total circumference of the steak.		

1/ Presence of shank and/or heel meat shall cause rejection of the lot.

2/ The AMS agent shall determine the supervision necessary to assure proper specified origin of all raw materials used.

TABLE 300 L

The following defects are applicable to all bone in portion cut items. Sample unit shall be one portion cut item. No individual defect shall be scored more than once per sample unit.

127	Evidence of callused meat.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
260	Weight of portion cut not within tolerance permitted.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
262	Score more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth.	294	Presence of any portion of the spinal cord.
163	Ventral edge of rib and loin items exceeding requirement by 0.2 inch (5 mm) or more.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
263	Ventral portion of rib chops not frenched as described in item description or otherwise specified (Item Nos. 1306D, 1306E)	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
266	Thickness of portion cut not within tolerance permitted.	141	Maximum average fat thickness exceeding that specified.
267	Thickness uniformity of portion varies more than tolerance.	298	Cut not practically free of bone dust.
271	Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from outer edge.		

1/ No more than a small amount of suitable lean may be removed from properly prepared cuts prior to production of respective portion cut items (i.e. loin chops may not be produced only from the posterior portion of a loin or rib chops produced only from the anterior portion of a rack item). The AMS agent shall determine the supervision necessary to assure all suitable lean is used.

TABLE 300 M ^{1/}

The following defects are applicable to all boneless portion cut items except for Item Nos. 1300, 1301, and 1302. Sample unit shall be 1 portion cut item. No individual defect shall be scored more than once per sample unit.

108	Bone measuring 0.2 inch (5 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	267	Thickness uniformity of portion varies more than tolerance.
109	Cartilage measuring 0.3 inch (8 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	271	Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from outer edge. (Not applicable to Item Nos. 1396, 1396A, 1397, 1397A)
110	Backstrap measuring 0.2 inch (5 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.	291	Presence of tag end measuring 1.0 inch or more in any dimension and will not support the weight of the portion cut when suspended.
118	Exposed lymph gland measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	292	Bruise measuring 0.5 inch (13 mm) or more in any dimension.
220	Presence of blood vessel measuring 0.5 inch (13 mm) or more in one dimension and 0.1 inch (2 mm) or more in a second dimension (when measured at right angle to each other).	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.1 inch (2 mm) in a second dimension (when measured at right angles to each other).
127	Evidence of callused meat.	294	Presence of any portion of the spinal cord.
260	Weight of portion cut not within tolerance permitted.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
262	Score into the lean more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth.	140	Maximum fat thickness at any point exceeding that specified or required in the item description.
163	Ventral edge of rib and loin items exceeding requirement by 0.2 inch (5 mm) or more.	141	Maximum average fat thickness exceeding that specified.
266	Thickness of portion cut not within tolerance permitted.	298	Cut not practically free of bone dust.

^{1/} No more than a small amount of suitable lean may be removed from properly prepared cuts prior to production of respective portion cut items (i.e. loin chops may not be produced only from the posterior portion of a loin or rib chops produced only from the anterior portion of a rack item). The AMS agent shall determine the supervision necessary to assure all suitable lean is used. Raw materials used for ground beef patties, flaked and formed steaks, and sliced and formed steaks shall be examined in accordance with items described in respective item description.

^{2/} Presence of shank and/or heel (unless otherwise specified) meat shall cause rejection of the lot.

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TABLE 400 A

The following defects apply to carcass Item Nos. 400 and 400A. Sample unit shall be one carcass.

201	The diaphragm, when present, not firmly attached and/or the membranous portion exceeds 0.25 inch (6 mm) from the lean at any point.	127	Evidence of oily, dark, coarse-textured, or pale, soft, and exudative (PSE) pork.
204	The internal fat covering the lumbar, sacral, pelvic, and tenderloin regions exceeds 1.0 inch (25 mm) in depth at any point.	142	Presence of kidney, kidney knob, and hanging tender.
205	Presence of a score more than 0.5 inch (13 mm) in depth at the deepest point, and when depth is multiplied by the length, is equal to or greater than 2.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
111	The split surface of chine not exposing the spinal groove to be evident on at least 75 percent of the length of the side.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
119	Mutilated feet not removed at the hock or upper knee joint.	294	Presence of any portion of exposed spinal cord 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
120	Jowl removed more than 1.0 inch (25 mm) anterior to the innermost curvature of the ear dip (if removed).	296	Product not within specified weight range.
121	Presence of "stuck" shoulder.	299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 400 B

The following defects apply to bone-in leg Item Nos. 401, 401A, 401B, 401C, 402, 402A. Sample unit shall be one leg item.

205	Presence of score more than 0.5 inch (13 mm) in depth at the deepest point, and when depth is multiplied by the length, is equal to or greater than 2.	141	Maximum average fat thickness exceeds that specified. (Less than 75 percent lean exposed over the quadriceps femoris and pelvic area.)
206	All cut separations not forming an approximate right angle with the skin surface.	261	Presence of the rectus abdominis (flank muscle).
216	Skin and collar fat over the cushion not smoothed and rounded such that the innermost curvature of the skin is at least half the distance from the stifle joint to the posterior edge of the aitch bone.	265	Presence of the lean and fat that overlaid the aitch bone measuring 1.0 square inch (6.5 sq. cm). (Item No. 401C)
217	Skin not removed anterior to a line parallel to the ham face at least 25 percent of the distance from the stifle joint to the ham face. (Item Nos. 402 and 402A)	175	Presence of tail and/or vertebrae measuring 0.5 inch (13 mm) or more in any dimension.
218	Any exposed lymph gland measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	186	Foot or shank not removed as described in applicable item description.
107	A small amount or more of lean removed from major muscle(s).	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	293	Blood clot measuring 0.5 inch (13 mm) or more one dimension and 0.2 inch (5 mm) or more in a second dimension.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	296	Product not within specified weight range.
127	Evidence of oily, dark, coarse-textured, or pale, soft, and exudative (PSE) pork.	298	Cut not practically free from bone dust.
140	Maximum fat thickness at any point exceeds that specified or required in the item description. (Fat over the quadriceps femoris and pelvic area exceeding 0.25-inch (6 mm) depth at any point.)	299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 400 C

The following defects apply to boneless leg Item Nos. 402B, 402C, 402D, 402E, 402F, 402G, 402H. Sample unit shall be one roast or item as applicable.

<p>205 Presence of score more than 0.5 inch (13 mm) in depth at the deepest point, and when depth is multiplied by the length, is equal to or greater than 2.</p> <p>206 All cut separations not forming an approximate right angle with the skin surface.</p> <p>104 Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>208 Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>214 The tendinous ends of shanks to a point where a cross-sectional cut exposes less than 75 percent lean tissue.</p> <p>218 Any exposed lymph gland measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>107 A small amount or more of lean removed from a major muscle(s).</p> <p>221 More than a slight amount, but less than a small amount, of lean removed from major muscle(s).</p> <p>108 Presence of adjacent cut(s) exceeding 4 percent of cut weight.</p> <p>222 Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.</p> <p>114 Skin which measures 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>118 Presence of the popliteal lymph gland more than 0.2 inch (5 mm) in any dimension. (Item Nos. 402C, 402D, 402E, 402F)</p> <p>127 Evidence of oily, dark, coarse-textured, or pale, soft, and exudative (PSE) pork.</p> <p>140 Maximum fat thickness at any point exceeds that specified or required in the item description.</p>	<p>141 Maximum average fat thickness exceeds that specified or required in the item description.</p> <p>261 Presence of the rectus abdominis (flank muscle).</p> <p>264 Presence of the thick opaque portion of the gracilis membrane measuring 1.0 square inch (6.5 sq. cm) or more.</p> <p>265 Presence of the lean and fat that overlaid the aitch bone measuring 1.0 square inches (6.5 sq. cm) or more and 0.5 inch (13 mm) or more in depth at any point.</p> <p>268 Shank not removed as specified. (Item No. 402C)</p> <p>274 Presence of the "mouse" (flexor digitorum superficialis). (Item Nos. 402D, 402E)</p> <p>292 Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>293 Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>295 Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.</p> <p>296 Product not within specified weight range.</p> <p>297 Item not properly netted or tied when specified.</p> <p>298 Cut not practically free from bone dust.</p> <p>299 Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)</p>
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TABLE 400 D

The following defects apply to bone-in shoulder Item Nos. 403, 403A, 403B, 404, 405, 406. Sample unit shall be one shoulder item.

205	Presence of score more than 0.5 inch (13 mm) in depth at the deepest point, and when depth is multiplied by the length, is equal to or greater than 2.	235	Traces of false lean not exposed. (Item Nos. 404, 406)
206	All cut separations not forming an approximate right angle with the skin surface.	136	Picnic not removed by a straight cut dorsal to the shoulder joint. (Item No. 406)
104	Presence of neck, rib or sternum bones or cartilages that are 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	140	Maximum fat thickness at any point exceeds that specified or required in the item description.
208	Presence of neck, rib or sternum bones or cartilages that are 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum average fat thickness exceeds that specified or required in the item description.
216	Skin above a line, which is parallel to the dorsal side, does not exceed 25 percent of the distance from the elbow joint to the dorsal side. (Item No. 404)	240	Fat and skin not beveled at an approximate 45 degree angle to meet the lean on the dorsal side. (Item Nos. 403, 405)
218	Any exposed lymph gland measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	186	Foot or shank not removed as described in applicable item description.
107	A small amount or more of lean removed from major muscle(s).	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
120	Jowl or neck not removed as described in applicable item description or as specified.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.
127	Evidence of oily, dark, coarse-textured, or pale, soft, and exudative (PSE) pork.	296	Product not within specified weight range.
224	Breast flap not removed.	298	Cut not practically free from bone dust.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 400 E

The following defects apply to boneless shoulder Item Nos. 403C, 405A, 405B, 406A, 406B, 407. Sample unit shall be one cut.

104	Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	127	Evidence of oily, dark, coarse-textured, or pale, soft, and exudative (PSE) pork.
208	Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	140	Maximum fat thickness at any point exceeds that specified or required in the item description.
214	The tendinous ends of shanks removed to a point where a cross-sectional cut exposes less than 75 percent lean tissue.	141	Maximum average fat thickness exceeds that specified or required in the item description.
107	A small amount or more of lean removed from major muscle(s).	283	Presence of detached shanks.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.
114	Skin which is 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	296	Product not within specified weight range.
120	Jowl or neck not removed as described in applicable item description or as specified.	297	Item not properly netted or tied when specified.
235	Traces of false lean not exposed. (Item Nos. 406A, 407)	298	Cut not practically free from bone dust.

TABLE 400 F

The following defects apply to belly Item Nos. 408, 409, 409A, 409B. Sample unit shall be one belly.

203	Leaf fat exceeds a combined area of 4.0 square inches (25.8 sq. cm) or more and 0.5 inch (13 mm) in depth.	127	Evidence of oily, dark, coarse-textured, or pale, soft, and exudative (PSE) pork.
205	Presence of score more than 0.5 inch (13 mm) in depth at the deepest point, and when depth is multiplied by the length, is equal to or greater than 2. (Not applicable to scribe line.)	237	Scribe line more than 0.4 inch (10 mm) deep at any point.
104	Unauthorized bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	241	Fat back not removed by a straight cut and/or is more than the required distance from the outermost curvature of the scribe line.
208	Unauthorized bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	160	Any side of the belly is more than 2.0 inches (5.0 cm) longer than the opposing side.
107	A small amount or more of lean removed from major muscle(s).	161	Width of the flank muscle is not at least 25 percent the width of the belly on the ham end.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	162	Areas of exposed fat 6.0 square inches (38.7 sq. cm) or more located ventral to the scribe line.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	291	Not practically free of hair roots. (Item No. 409)
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
114	Skin which is 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. (Item No. 409)	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.
117	Presence of enlarged, soft, porous, dark, or seedy mammary tissue.	296	Product not within specified weight range.
		299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 400 G

The following defects apply to bone-in loin Item Nos. 410, 410A, 411, 412, 412A, 412C, 412D, 412G, 423. Sample size shall be one roast or item as applicable.

<p>205 Presence of score more than 0.5 inch (13 mm) in depth at the deepest point, and when depth is multiplied by the length is equal to or greater than 2.</p> <p>206 All cut separations not forming an approximate right angle with the skin surface.</p> <p>111 Spinal cord groove not evident on at least 75 percent of the vertebrae.</p> <p>112 Protruding edge of the chine bone and more than 75 percent of the ventral edge of the spinal groove are not removed. (Item Nos. 412A, 412D)</p> <p>113 Blade cartilage is 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension. (Item Nos. 411, 412, 412A, 412C, 412D)</p> <p>228 Blade cartilage is 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) and 0.2 inch (5 mm) or more in a second dimension. (Item Nos. 411, 412, 412A, 412C, 412D)</p> <p>220 Presence of exposed blood vessel that is 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>107 A small amount or more of lean removed from major muscle(s).</p> <p>221 More than a slight amount, but less than a small amount, of lean removed from major muscle(s).</p> <p>108 Presence of adjacent cut(s) exceeding 4 percent of cut weight.</p> <p>222 Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.</p> <p>127 Evidence of oily, dark, coarse-textured, or pale, soft, and exudative (PSE) pork.</p>	<p>227 Presence of diaphragm and hanging tender exceeding 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) in a second dimension.</p> <p>234 Protruding edge of chine bone not removed as specified. (Item No. 423)</p> <p>235 Less than 2.0 inches (5.0 cm) of false lean exposed. (Item Nos. 410, 411)</p> <p>239 False lean (trapezius or latissimus dorsi) not removed as specified</p> <p>140 Maximum fat thickness at any point exceeds that specified or required in the item description.</p> <p>141 Maximum average fat thickness exceeds that specified or required in the item description.</p> <p>292 Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>293 Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.</p> <p>294 Presence of any portion of exposed spinal cord 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.</p> <p>295 Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.</p> <p>296 Product not within specified weight range.</p> <p>298 Cut not practically free from bone dust.</p> <p>299 Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)</p>
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TABLE 400 H

The following defects apply to boneless loin Item Nos. 412B, 412E, 412F, 413, 413A, 413B, 414, 414A, 415, 415A. Sample unit shall be one roast or item as applicable.

205	Presence of score more than 0.5 inch (13 mm) in depth at the deepest point, and when depth is multiplied by the length, is equal to or greater than 2.	127	Evidence of oily, dark, coarse-textured, or pale, soft, and exudative (PSE) pork.
206	All cut separations not forming an approximate right angle with the skin surface.	239	False lean (trapezius or latissimus dorsi) not removed as specified
104	Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	140	Maximum fat thickness at any point exceeds that specified or required in the item description.
208	Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum average fat thickness exceeds that specified or required in the item description.
220	Presence of a blood vessel that is 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	296	Product not within specified weight range.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	297	Item not properly netted or tied when specified.
229	Item not properly cut in half and/or ends not reversed when specified.	298	Cut not practically free from bone dust.
114	Skin which is 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	299	Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than 1.0 inch (25 mm) from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 400 I

The following defects apply to spareribs/breast bone/backrib Item Nos. 416, 416A, 416B, 416C, 416D, 422, 424. Sample unit shall be one sparerib or backrib item.

201	The diaphragm, when present, not firmly attached and/or the membranous portion exceeds 0.25 inch (6 mm) from the lean at any point.	248	Presence of diaphragm, and serous membrane (peritoneum) exceeding 1.0 inch (25 mm) in one dimension and 0.5 inch (13 mm) in a second dimension on spareribs (scored only if removal is specified). (Item No. 416A)
203	Leaf fat measuring 1.0 inch (25 mm) or more in one dimension and 0.3 inch (8 mm) or more in a second dimension.	256	Back ribs exceed specified width (distance between the dorsal and ventral sides) of the rib sections by 0.5 inch (13 mm).
122	Rib bone(s) which are broken or shattered to the extent that the surrounding meat is affected.	182	Presence of sternum measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension. (Item Nos. 416A, 416C)
223	Sparerib having fat on the inside surface of ribs (heart fat) exceeding an average of 0.25 inch (6 mm). (Not applicable to Item No. 416B)	184	The lean extends more than 2.0 inches (5.0 cm) past the curvature of the last rib and costal cartilage. (Item Nos. 416, 416A, 416C)
124	Spareribs have less than 11 ribs. (Item Nos. 416, 416A, 416C)	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
125	Back ribs do not have at least 8 ribs and related intercostal meat from the loin.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.
236	Back ribs have evidence of cartilaginous junctures of the rib and thoracic vertebrae 1.0 inch (25 mm) or more in any dimension.	296	Product not within specified weight range.
238	Riblet having less than 4 transverse processes, not held intact by associated lean, or includes more than 2 rib bones.	298	Cut not practically free from bone dust.
144	Presence of the ventral (curved) portions of three or more costal cartilages. (Item No. 416A)		

TABLE 400 J

The following defects apply to hocks/pigs feet/neckbones Item Nos. 417, 417A, 420, 420A, 421. Sample unit shall be one item.

186	Foot or shank not removed as described in applicable item description.	292	Bruise measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
284	Ham or shoulder hock less than 2.0 inches (5.0 cm) in length.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
286	Neck bones do not have at least 2 cervical vertebrae.	296	Product not within specified weight range.
287	Neck bones have less than 1 or more than 4 thoracic vertebrae adjoining ribs and intercostal lean.	298	Cut not practically free from bone dust.
291	Not practically free of hair and hair roots. (Item Nos. 420, 420A)		

TABLE 400 K

The following defects apply to trimmings/ground pork Item Nos. 418, 419, 496, 496A, 496B, 496C, and 1495. Sample unit shall be a minimum of 10 pounds.

104	Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	219	Internal (kidney, pelvic, or heart) fat having a surface area measuring 2.0 square inches (12.9 sq. cm) or more and 0.5 inch (13 mm) or more in depth at any point.
208	Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	220	Presence of a blood vessel that is 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
114	Skin which is 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	253	Presence of 2 or more pieces of any size with more than 50 percent of the surface area composed of heavy opaque connective tissue, bone, cartilage, or calcified periosteum (do not score if defects 104 or 208 are scored for those pieces).
117	Presence of enlarged, soft, porous, dark, or seedy mammary tissue.	254	Presence of heavy (opaque) connective tissue that measures 1.0 inch (25 mm) or more in one dimension and 0.5 inch (13 mm) or more in a second dimension.
127	Evidence of oily, dark, coarse-textured, or pale, soft, and exudative (PSE) pork.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
140	Maximum fat thickness at any point exceeds 0.25 inch (6 mm) (score only once per sample unit.) (Item No. 1495)	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
214	The tendinous ends of shanks cut to a point where a cross-sectional cut exposes less than 75 percent lean tissue.	194	Presence of spinal cord 0.5 inch (13 mm) in any dimension.
218	Popliteal, prescapular, or prefemoral lymph glands, and/or any exposed lymph gland 0.5 inch (13 mm) or more in one dimension and 0.2 (5 mm) or more in a second dimension.		

TABLE 400 L ^{1/2/}

The following defects apply to diced pork/kabobs Item Nos. 435, 435A, and 435B. Sample unit shall be 5 lbs. finished product.

104	Bone or cartilage measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.		consisting of dices which have any individual surface exceeding 3.0 inches (7.5 cm) in length and/or are not of a size equivalent to a 1.0 inch (25 mm) to 1.5 inches (3.8 cm) cube. (Item No. 435B)
208	Bone or cartilage measuring 0.3 inch (8 mm) or more but less than 1.0 inch (25 mm) in one dimension and 0.2 inch (5 mm) or more in a second dimension.	132	More than 10 percent, by weight, of sample unit consisting of dices that have exposed surface and/or seam fat exceeding specified fat thickness at any point. (Item Nos. 435, 435A, 435B)
117	Presence of enlarged, soft, porous, dark, or seedy mammary tissue.		
218	Any exposed lymph gland measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	255	Presence of two dices having connective tissue measuring more than 0.2 inch (5 mm) in thickness (width) (score one defect per two dices). (Do not score more than once per cube.)
220	Diameter of blood vessel is 0.5 inch (13 mm) or more in one dimension and 0.1 inch (2 mm) or more in a second dimension.	258	Presence of 2 or more acceptable cube size pieces that consist entirely of fat (do not score if defect 132 is scored in sample unit).
127	Evidence of oily, dark, coarse-textured, or pale, soft, and exudative (PSE) pork.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
129	More than 25 percent, by weight, of sample unit consists of dices which have any individual surface exceeding 2.5 inches (6.3 cm) in length and/or are not of a size equivalent to a 0.75 inch (19 mm) to 1.5 inches (3.8 cm) cube. (Item No. 435)	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
130	More than 15 percent, by weight, of sample unit consisting of dices which have any individual surface exceeding 2.5 inches (6.3 cm) in length and/or are not of a size equivalent to a 0.75 inch (19 mm) to 1.5 inches (3.8 cm) cube. (Item No. 435A)	194	Presence of any portion of the spinal cord.
131	More than 10 percent, by weight, of sample unit	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.

^{1/} Presence of shank and/or, unless otherwise specified, inner shank (heel) meat shall cause rejection of the lot.

^{2/} Presence of product having ground appearance shall cause rejection of the lot.

TABLE 400 M ^{1/}

The following defects apply to bone-in portion Item Nos. 1406, 1410, 1410A, 1410B, 1411, 1412, 1412A. Sample unit shall be one portion-cut item. No individual defect shall be scored more than once per sample unit.

118	Any exposed lymph gland measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	165	Evidence of less than one rib. (Item No. 1410A)
220	Presence of blood vessel that is 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	266	Thickness of portion cut not within tolerance.
127	Evidence of oily, dark, coarse-textured, or pale, soft, and exudative (PSE) pork.	267	Thickness uniformity of portion varies more than tolerance.
140	Maximum fat thickness at any point exceeds that specified or required in the item description.	271	Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from the outer edge.
141	Maximum average fat thickness exceeds that specified or required in the item description.	281	Presence of tag end measuring 1.0 inch (25 mm) or more in any dimension and will not support the weight of the steak when suspended.
260	Weight of portion cut not within tolerance permitted.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
262	Score into muscle more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
163	Ventral edge of rib and loin items exceeds requirement by 0.2 inch (5 mm) or more.	194	Presence of any portion of the spinal cord.
164	Presence of unauthorized muscles or bone 0.5 inch (13 mm) in any dimension on either side of portion cut.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.
		298	Cut not practically free of bone dust.

^{1/} No more than a small amount of suitable lean may be removed from properly prepared cuts prior to production of the portion cut items (i.e., chops may not be produced only from the anterior portion of a loin.) The AMS agent shall determine the supervision necessary to assure all suitable lean is used.

TABLE 400 N ^{1/}

The following defects apply to boneless portion cut Item Nos. 1407, 1412B, 1412E, 1413, 1413B, 1438, 1438A, 1438B, 1496, 1496A, 1496B, 1496C. Sample unit shall be one portion-cut item. No individual defect shall be scored more than once per sample unit.

102	Bone measuring 0.2 inch (5 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	164	Presence of any portion of unauthorized muscles or bone exceeding 0.5 inch (13 mm) in any dimension on either side.
109	Cartilage measuring 0.3 inch (8 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	266	Thickness of portion cut not within tolerance.
118	Any exposed lymph gland measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	267	Thickness uniformity of portion varies more than tolerance.
127	Evidence of oily, dark, coarse-textured, or pale soft, and exudative (PSE) pork.	271	Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from the outer edge. (Not applicable to Item Nos. 1496, 1496A)
140	Maximum fat thickness at any point exceeds that specified or required in the item description.	276	Crevice extends 0.75 inch (19 mm) or more toward the center of the chop.
141	Maximum average fat thickness exceeds that specified or required in the item description.	277	Folds in steaks resulting in overlap on more than 20 percent of the surface area. (Item No. 1438A)
220	Presence of blood vessel that is 0.5 inch (13 mm) or more in one dimension and 0.1 inch (2 mm) in a second dimension.	279	Specified dimension (e.g., diameter, length and width) of portion cut not within 0.5 inch (13 mm).
252	Presence of unauthorized heavy connective tissue measuring 1.0 inch (25 mm) or more in one dimension and 0.1 inch (2 mm) or more in a second dimension.	281	Presence of tag end measuring 1.0 inch (25 mm) or more in any dimension and will not support the weight of the steak when suspended.
260	Weight of portion cut not within tolerance permitted.	290	Presence of green/brown/gray areas 1.0 square inch (6.5 sq. cm) or more. (Item No. 1438A)
262	Score into muscle more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
163	Ventral edge of rib and loin items exceeds requirement by 0.2 inch (5 mm) or more.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
		294	Presence of any portion of the spinal cord.
		295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.
		298	Cut not practically free of bone dust.

^{1/} No more than a small amount of suitable lean may be removed from properly prepared cuts prior to production of respective portion-cut items (i.e., chops may not be produced only from the anterior portion of a loin). The AMS agent

shall determine the supervision necessary to assure all suitable lean is used.

TABLE 400 O ^{1/}

The following defects are applicable to Item Nos. 1400, 1401, 1402, 1402G. Sample unit shall be 1 portion cut item. No individual defect shall be scored more than once per sample unit.

102	Bone or cartilage measuring 0.2 inch (5 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	141	Maximum average fat thickness exceeding that specified or required in the item description.
109	Cartilage measuring 0.3 inch (8 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	269	Surface and/or seam fat measuring 0.1 inch (2 mm) or more in thickness exceeding 50 percent of total circumference of the steak. (Item No. 1402)
118	Exposed lymph glands measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.	270	Surface and/or seam fat exceeding 15 percent of total area on either side of the steak. (Item Nos. 1400, 1401)
127	Evidence of oily, dark, coarse-textured, or pale soft, and exudative (PSE) pork.	271	Item breaks completely apart when suspended from a point no less than 0.5 inch (13 mm) from the outer edge.
220	Presence of blood vessel measuring 0.5 inch (13 mm) or more in one dimension and 0.1 inch (2 mm) or more a second dimension.	178	Knitting of two or more pieces together.
252	Presence of heavy opaque connective tissue on the outer edge of steaks measuring 1.0 inch (25 mm) or more in one dimension and 0.1 inch (2 mm) or more in a second dimension.	279	Specified dimensions (e.g., diameter, length and width) of portion cut not within 0.5 inch (13 mm).
255	Presence of intermuscular heavy connective tissue measuring 0.2 inch (5 mm) or more in thickness.	281	Presence of tag end measuring 1.0 inch (25 mm) or more in any dimension and will not support the weight of the steak when suspended.
260	Weight of portion cut not within tolerance permitted.	292	Bruise measuring 1.0 inch (25 mm) or more in one dimension and 0.2 inch (5 mm) or more in a second dimension.
262	Score more than 1.0 inch (25 mm) in length and more than 1/2 the thickness of the portion cut in depth.	293	Blood clot measuring 0.5 inch (13 mm) or more in one dimension and 0.2 inch (5 mm) in a second dimension.
266	Thickness of portion cut not within tolerance permitted.	194	Presence of any portion of the spinal cord.
267	Thickness uniformity of portion varies more than tolerance.	295	Presence of dehydrated surfaces measuring 1.0 square inch (6.5 sq. cm) or more.
140	Maximum fat thickness at any point exceeding that specified or required in the item description.	298	Cut not practically free of bone dust.

^{1/} The AMS agent shall determine the supervision necessary to assure proper specified origin of all raw materials used.

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AND FULLY-COOKED PORK PRODUCTS - SERIES 500**

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TABLE 500 A

The following defects apply to Item Nos. 500, 501, 502, 503, 504, 510. Sample unit shall be 1 ham item.

104.	Aitch bone and overlying flesh and/or shank bones not removed as specified. (Item 504)	127.	Evidence of oily, dark and/or coarse-textured pork.
205	Presence of score more than 0.5 inch in depth at deepest point, and when depth is multiplied by the length, is equal to or greater than 2.	128.	Uncured or unsmoked areas 1.0 sq. inch or more.
206	All cut separations not forming an approximate right angle with the skin surface.	134.	Presence of tail and/or vertebrae measuring 0.5 inch or more in any dimension.
107.	A small amount or more of lean removed from major muscle(s).	137.	More than a slight two-toned color.
108.	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	140.	Maximum fat thickness at any point exceeds that specified or required in the item description. (Fat over the quadriceps femoris and pelvic area exceeding 0.2-inch depth at any point).
216	Skin and collar fat over the cushion not smoothed and rounded such that the innermost curvature of the skin is at least half the distance from the stifle joint to the posterior edge of the aitch bone. (Item Nos. 500, 501)	141.	Maximum average fat thickness exceeds that specified. (Less than 75 percent lean exposed over the quadriceps femoris and pelvic area).
114.	Foot or shank not removed as described in applicable item description.	261	Presence of the rectus abdominis (flank muscle) and/or cutaneous trunci.
117.	Presence of skin measuring 1.0 inch or more in one dimension and .5 inch or more in a second dimension (measured at right angles to each other). (Item No. 504)	292	Bruise is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension.
200	Slices are not firmly attached to the bone. (Item No. 510)	293	Blood clot is 0.5 inch or more one dimension and 0.2 inch or more in a second dimension.
217	Skin not removed within 1 inch posterior to the stifle joint. (Item Nos. 502 and 503)	295	Presence of dehydrated surfaces and/or opaque gracilis membrane measuring 1.0 square inch or more.
218	Prefemoral and/or any exposed lymph gland measuring 0.3 inch or more in one dimension and 0.1 inch or more in a second dimension.	296	Product not within specified weight range.
219	Splits or holes in casing/package material more than 0.5 inch long or when a required vacuum has been lost.	297	Item not properly netted or tied when specified.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	298	Cut not practically free from bone dust.
223	Fat and skin not beveled at approximate 45-degree angle to meet the lean as described in the applicable item description.	299	Cut not free from ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut).
		196.	Not practically free from smokehouse residue, encrusted salt or gelatinous material.
		199.	Exhibiting more than a slight amount of dripping or exudation of moisture on the cut surface.

TABLE 500 B

The following defects apply to Item Nos. 505, 505A, 508, 509, 511, 511A. Sample unit shall be one boneless ham.

101	Skin measuring 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	261	Presence of the rectus abdominis (flank muscle).
205	Presence of score more than 0.5 inch in depth at deepest point, and when depth is multiplied by the length, is equal to or greater than 2.	136	Cross section appearance not as specified. (Item No. 511, 511A)
206	All cut separations not forming an approximate right angle with the skin surface.	137	Two tone color variation of the cross section or the number of muscle systems higher than that specified in the item description. (Item 509)
104	Bone measures 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	138	Area of seam fat which exceeds 1.0 inch in length and 0.25 inch in width for the full distance. (508, 509, 511, 511A)
208	Bone is 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	140	Maximum fat thickness at any point exceeds that specified or required in the item description. (For all items specified or required to be practically free, fat exceeding 0.25-inch depth at any point).
105	Cartilage is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	141	Maximum average fat thickness exceeds that specified. (For items specified or required to be practically free, less than 75 percent of lean exposed).
107	A small amount or more of lean removed from a major muscle(s).	151	<i>Cavity on the exterior surfaces measuring 0.5 inch (12.7 mm) or more in width by 1.0 inch (2.5 cm) or more in length by 0.5 inch (12.7 mm) or more in depth. (Canned hams only)</i>
209	Cartilage is 0.3 inch or more but less than 1.0 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	152	<i>Sliced surfaces area which is composed of 5% or more air and/or gelatin pockets. (Canned hams only)</i>
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	153	<i>Sliced surface area which is composed of 5% or more fat.</i>
212	Shank not removed as specified.	292	Bruise is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension.
218	Prefemoral and/or any exposed lymph gland measuring more than 0.3 inch in one dimension and 0.1 inch in a second dimension.	293	Blood clot is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension.
219	Splits or holes in casing/package material more than 0.5 inch long or when a required vacuum has been lost.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
222	Presence of adjacent cut(s) exceeding 2 percent, but not more than 4 percent of cut weight.	296	Product not within specified weight range.
118	Presence of the popliteal lymph gland more than 0.2 inch in any dimension.	297	Item not properly netted or tied when specified.
127	Evidence of oily, dark, and/or coarse-textured, pork.	298	Cut not practically free from bone dust.
128	Uncured or Unsmoked areas 1.0 sq. inch or more.	299	Cut not free from ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut).
255	Presence of exposed heavy (opaque) connective tissue that measures 1.0 inch or more in one dimension and 0.5 inch or more in a second dimension (when measured at right angles to each other).	190	Muscle fibers of the ham not running parallel (lengthwise) to the casing.
		196	Not practically free from smokehouse residue, encrusted salt or gelatinous material.

199

Exhibiting more than a slight amount of dripping
or exudation of moisture on the cut surface.

** June 23, 1992 changes are in italics.*

TABLE 500 C

The following defects apply to Item Nos. 515, 516, 517, 518, 525, 526. Sample unit shall be one bone-in shoulder item.

205	Presence of score more than 0.5 inch in depth at deepest point, and when depth is multiplied by the length, is equal to or greater than 2.	114	Foot or shank not removed as described in applicable item description.
206	All cut separations not forming an approximate right angle with the skin surface.	115	Jowl not removed as described in applicable item description.
104	Presence of neck, rib, or sternum bone that are 0.5 inch or more in one dimension and 0.2 inch or more in second dimension (when measured at right angles to each other).	127	Evidence of oily, dark and/or coarse-textured, pork.
208	Presence of neck, rib, or sternum bone that are 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	128	Uncured or Unsmoked areas 1.0 sq. inch or more.
105	Presence of neck, rib, or sternum associated cartilage that is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	137	More than a slight two-toned color.
209	Presence of neck, rib, or sternum associated cartilage that is 0.3 inch or more but less than 1.0 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	140	Maximum fat thickness at any point exceeds that specified or required in the item description. (For all items specified or required to be practically free, fat exceeding 0.25 inch depth at any point).
216	Skin above a line which is parallel to the dorsal side, does not exceed 25 percent of the distance from the elbow joint to the dorsal side. (Item No. 517, 518)	141	Maximum average fat thickness exceeds that specified. (For all items specified or required to be practically free, less than 75 percent of lean exposed).
107	A small amount or more of lean removed from major muscle(s).	228	Breast flap not removed.
218	Any exposed lymph gland measuring 0.3 inch or more in one dimension and 0.1 or more in a second dimension.	235	Traces of false lean not exposed. (Item No. 517, 518,)
219	Splits or holes in casing/packaging material more than 0.5 inch long or when a required vacuum has been lost.	292	Bruise is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	293	Blood clot is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension.
109	Picnic not removed by a straight cut dorsal to the shoulder joint (when specified).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
223	Fat and skin not beveled at approximate 45 degree angle to meet the lean on the dorsal side (Item No. 515, 516, 517, 518 525 and 526)	296	Product not within specified weight range.
		297	Item not properly netted or tied when specified.
		298	Cut not practically free from bone dust.
		299	Cut not free from ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut).
		196	Not practically free from smokehouse residue, encrusted salt, gelatinous material.

199

Exhibiting more than a slight amount of dripping or exudation of moisture on the cut surface.

TABLE 500 D

The following defects apply to Item No. 527, 530, 531. Sample unit shall be 1 cut.

101 ..	Skin which is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.
104 ..	Bone is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	229	False lean not removed (Item No. 531)
206	All cut separations not forming an approximate right angle with the skin surface.	235	Traces of false lean not exposed. (Item No. 530)
208	Bone is 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	127 ..	Evidence of oily, dark, and/or coarse-textured, pork.
105 ..	Cartilage is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	128 ..	Uncured or Unsmoked areas 1.0 sq. inch or more.
209	Cartilage is 0.3 inch or more but less than 1.0 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	137 ..	More than a slight two-toned color.
214	The tendinous ends of shanks to a point where a cross-sectional cut exposes less than 75 percent lean tissue.	140 ..	Maximum fat thickness at any point exceeds that specified or required in the item description. (For items specified or required to be practically free, fat exceeding 0.25 inch depth at any point).
107 ..	A small amount or more of lean removed from major muscle(s).	141 ..	Maximum average fat thickness exceeds that specified. (For items specified or required to be practically free, less than 75 percent of lean exposed).
108 ..	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	292	Bruise is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension.
115 ..	Jowl not removed as described in applicable item description.	293	Blood clot is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension.
216	Presence of detached shanks.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
218	Any exposed lymph gland measuring 0.3 inch or more in one dimension and 0.1 or more in a second dimension.	296	Product not within specified weight range.
219	Splits or holes in casing/packaging material more than 0.5 inch long or when a required vacuum has been lost.	297	Item not properly netted or tied when specified.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	298	Cut not practically free from bone dust.
		196 ..	Not practically free from smokehouse residue, encrusted salt or gelatinous material.
		199 ..	Exhibiting more than a slight amount of dripping or exudation of moisture on the cut surface.

TABLE 500 E

The following defects apply to Item Nos. 535, 536, 537, and 538. Sample unit shall be one 1 belly.

101	Skin which is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other). (Item No. 537, 538)	128	Uncured or Unsmoked areas 1.0 sq. inch or more.
205	Presence of score more than 0.5 inch in depth at deepest point, and when depth is multiplied by the length, is equal to or greater than 2. (not applicable to scribe line).	230	Leaf fat measuring 1.0 inch or more in one dimension and 0.3 inch or more in a second dimension (when measured at right angles to each other).
206	All cut separations not forming an approximate right angle with the skin surface.	231	Fat back not removed by a straight cut dorsal to the outermost curvature of the scribe line as specified.
104	Bone is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	233	Scribe line more than 0.4 inch deep at any point.
208	Bone is 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	234	Not practically free of hair roots. (Item No. 535, 536).
105	Cartilage is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	245	Fat back not removed as specified.
209	Cartilage is 0.3 inch or more but less than 1.0 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	292	Bruise is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	296	Product not within specified weight range.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	299	Cut not free from ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut).
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	159	Fat backside of the belly is more than 2.0 inches longer than the ventral side.
123	Belly not formed as specified. (Item No. 536, 537, 538)	160	Width of the flank muscle is not at least 25 percent the width of the belly on the ham end.
127	Evidence of oily, dark, and/or coarse-textured, pork.	162	Areas of exposed fat located ventral to the scribe line, which exceeds specification requirements.
225	Evidence of teat line. (Item No. 538)	163	Presence of enlarged, soft, porous, dark, or seedy mammary tissue.
		164	Pizzle recess requiring trimming of more than 1/2 inch to remove.
		196	Not practically free from moisture pockets, smokehouse residue, encrusted salt or gelatinous material.

TABLE 500 F

The following defects apply to Item Nos. 545, 546, 547, 548. Sample size shall be 1 loin.

205	Presence of score more than 0.5 inch in depth at deepest point, and when depth is multiplied by the length is equal to or greater than 2.	141	Maximum average fat thickness exceeds that specified. (For all items specified or required to be practically free, less than 75 percent of lean exposed).
206	Cut separations not forming an approximate right angle with the skin surface.	170	Spinal cord groove not evident on at least 75 percent of the vertebrae.
105	Blade cartilage is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other). (Item No. 546)	235	Less than 2.0 inches of false lean exposed. (Item Nos. 545, 546)
209	Blade cartilage is 0.3 inch or more but less than 1.0 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other). (Item No. 546)	248	Presence of diaphragm and/or hanging tender exceeding 1.0 inch in one dimension and 0.5 inch in a second dimension when measured at right angles to each other.
220	Presence of exposed blood vessel that is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension. (When measured at right angles to each other)	292	Bruise is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension.
107	A small amount or more of lean removed from major muscle(s).	293	Blood clot is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension.
219	Splits or holes in casing/package material more than 0.5 inch long or when a required vacuum has been lost.	294	Presence of any portion of exposed spinal cord 0.5 inch or more in one dimension and 0.2 inch in a second dimension.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	296	Product not within specified weight range.
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	297	Item not properly netted or tied when specified.
127	Evidence of oily, dark and/or coarse-textured, pork.	298	Cut not practically free from bone dust.
128	Uncured or Unsmoked areas 1.0 sq. inch or more.	299	Cut not free from ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut).
137	More than a slight two-toned color.	175	Diameter of the longissimus dorsi is less than 1 inch across. (Item No. 546)
140	Maximum fat thickness at any point exceeds that specified or required in the item description. (For all items specified or required to be practically free, fat exceeding 0.25-inch depth at any point).	196	Not practically free from smokehouse residue, encrusted salt or gelatinous material.
		199	Exhibiting more than a slight amount of dripping or exudation of moisture on the cut surface.

TABLE 500 G

The following defects apply to Item Nos. 547A, 548A, 550. Sample unit shall be 1 boneless loin.

205	Presence of score more than 0.5 inch in depth at deepest point, and when depth is multiplied by the length, is equal to or greater than 2.	127	Evidence of oily, dark, and/or coarse-textured, pork.
206	Cut separations not forming an approximate right angle with the skin surface.	128	Uncured or Unsmoked areas 1.0 sq. inch or more.
104	Bone is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	137	More than a slight two-toned color.
208	Bone is 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	140	Maximum fat thickness at any point exceeds that specified or required in the item description. (For all items specified or required to be practically free, fat exceeding 0.25-inch depth at any point).
105	Cartilage is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	141	Maximum average fat thickness exceeds that specified (For all items specified or required to be practically free, less than 75 percent of lean exposed).
209	Cartilage is 0.3 inch or more but less than 1.0 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	292	Bruise is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension.
210	Tenderloin not removed.	293	Blood clot 0.5 inch or more in one dimension and 0.2 inch in a second dimension.
219	Splits or holes in casing/package material more than 0.5 inch long or when a required vacuum has been lost.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
220	Presence of blood vessel that is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension. (When measured at right angles to each other)	296	Product not within specified weight range.
107	A small amount or more of lean removed from major muscle(s).	297	Item not properly netted or tied when specified.
221	More than a slight amount, but less than a small amount, of lean removed from major muscle(s).	298	Cut not practically free from bone dust.
108	Presence of adjacent cut(s) exceeding 4 percent of cut weight.	299	Cut not free from ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut).
222	Presence of adjacent cut(s) exceeding 2 percent but not more than 4 percent of cut weight.	175	Diameter of the longissimus dorsi is less than specified in the item description. (Item Nos. 547A, 548A, 550)
		196	Not practically free from smokehouse residue, encrusted salt or gelatinous material.
		199	Exhibiting more than a slight amount of dripping or exudation of moisture on the cut surface.

TABLE 500 H

The following defects apply to Item Nos. 558, 559, 559A, 559B. Sample unit shall be 1 pork sparerib item.

104	Rib bone(s) which are broken or shattered to the extent that the surrounding meat is affected.	182	Presence of sternum measuring 0.5 inch or more in one dimension and 0.2 inch in a second dimension. (Item Nos. 559A, 559B).
124	Spareribs contain less than 11 ribs.	183	Presence of the ventral (curved) portions of three or more costal cartilages (Item No. 559A, 559B).
201	The diaphragm, when present, not firmly attached and/or the membranous portion exceeds 0.3 inch from the lean at any point.	184	The lean extends more than 2.0 inches past the curvature of the last rib and costal cartilage. (Item Nos. 558, 559)
248	Presence of diaphragm, and serous membrane (peritoneum) exceeding 1.0 inch in one dimension and 0.5 inch in a second dimension on spareribs (scored only if removal is specified Item No. 559A, 559B)	293	Blood clot is 0.5 inch or more in one dimension and 0.2 inch in a second dimension.
128	Uncured or Unsmoked areas 1.0 sq. inch or more.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
139	Fat over diaphragm and transverse abdominal not trimmed practically free. (less than 75 percent lean exposed).	296	Product not within specified weight range.
141	Sparerib having fat on the inside surface of ribs (heart fat) exceeding an average of 0.25 inch.	298	Cut not practically free from bone dust.
		196	Not practically free of moisture pockets, smokehouse residue, encrusted salt, gelatinous material.

TABLE 500 I

The following defects apply to Item Nos. 560, 561, and 563. Sample unit shall be 1 pork item.

128	Uncured or Unsmoked areas 1.0 sq. inch or more.	293	Blood clot is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension.
187	Shoulder hocks not separated from the front feet at or above the upper knee joint.	296	Product not within specified weight range.
189	Ham hock not separated from hind feet at or above the hock joint.	298	Cut not practically free from bone dust.
237	Ham or shoulder hock less than 2.0 inches in length.	299	Not practically free of hair and hair roots.
292	Bruise is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension.	192	Front feet not removed at or above the upper knee joint of the front legs.
		196	Not practically free from moisture pockets, smokehouse residue, encrusted salt or gelatinous material.

TABLE 500 J

The following defects apply to Item Nos. 512, 512A, 514. Sample unit shall be 5 lbs.

104	Bone is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	218	Popliteal, prescapular, or prefemoral lymph glands, and/or any exposed lymph gland 0.3 inch or more in one dimension and 0.1 or more in a second dimension.
208	Bone is 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	219	Splits or holes in casing/packaging material more than 0.5 inch long or when a required vacuum has been lost.
105	Cartilage is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	220	Presence of exposed blood vessels 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (measured at right angle to each other).
209	Cartilage is 0.3 inch or more but less than 1.0 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	223	Presence of 2 or more pieces of any size with more than 50 percent of the surface area composed of heavy opaque connective tissue, bone, cartilage, or calcified periosteum (do not score if defects 104, 208, 105, 209, or 211 are scored for those pieces).
211	Calcified (scratchy) periosteum is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	258	Presence of 2 or more acceptable cube size pieces that consist entirely of fat (Do not score if defect 132 is scored in sample unit).
127	Evidence of oily, dark and/or coarse-textured, pork.	292	Bruise is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension.
128	Uncured or Unsmoked areas 1.0 sq. inch or more.	293	Blood clot is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension.
129	More than 10 percent, by weight, of the sample unit fails to meet the cube size requirement specified by the purchaser.	163	Presence of enlarged, soft, porous, dark, or seedy mammary tissue.
132	More than 10 percent, by weight, of sample unit consists of diced pieces that have exposed surface and/or seam fat exceeding 0.3 inch thickness at any point.	194	Presence of spinal cord 0.5 inch in any dimension.
		196	Not practically free from moisture pockets, smokehouse residue, encrusted salt, gelatinous material.

TABLE 500 K

The following defects apply to Item No. 555, 556, 562. Sample unit shall be 5 lbs. finished product.

104	Bone is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	255	Presence of heavy (opaque) connective tissue that measures 1.0 inch or more in one dimension and 0.5 inch or more (at any point) in a second dimension (when measured at right angles to each other).
206	All cut separations not forming an approximate right angle with the skin surface.	292	Bruise is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension.
208	Bone is 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	293	Blood clot is 0.5 inch or more in one dimension and 0.2 inch in a second dimension.
105	Cartilage is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
209	Cartilage is 0.3 inch or more but less than 1.0 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	127	Evidence of oily, dark and/or coarse-textured pork.
220	Presence of exposed blood vessel 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	128	Uncured or unsmoked areas 1.0 sq. inch or more.
		196	Not practically free from moisture pockets, smokehouse residue, encrusted salt or gelatinous material.

TABLE 500 L 1/ 2/

The following defects apply to items 1513, 1531, 1545, 1548, 1596. Sample unit shall be 1 steak, chop, or patty. No individual defect shall be scored more than once per sample unit.

104	Bone is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	264	Presence of unauthorized muscles or bone 0.5 inch x 0.2 inch or more on either side of portion cut.
208	Bone is 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	265	Thickness uniformity of portion varies more than tolerance.
105	Cartilage is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	266	Thickness of portion cut not within tolerance.
209	Cartilage is 0.3 inch or more but less than 1.0 in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	292	Bruise is 0.5 inches or more in one dimension and 0.2 inch or more in a second dimension.
218	Any exposed lymph gland measuring 0.3 inch or more in one dimension and 0.1 inch or more in a second dimension.	293	Blood clot is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension.
220	Presence of blood vessel that is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	291	Presence of tag that is 1.0 inch or more in any dimension and will not support the weight of the steak/chop when suspended.
260	Weight of portion cut not within tolerance permitted.	295	Presence of dehydrated surfaces measuring 1.0 square inch or more.
261	Ventral edge of rib and loin items exceeds requirement by 0.2 inch or more.	140	Maximum fat thickness at any point exceeds that specified or required in the item description.(For all items specified or required to be practically free, fat exceeding 0.25 inch depth at any point).
262	Score into muscle more than 1.0 inch in length and more than 1/2 the thickness of the portion cut in depth (at any point).	141	Maximum average fat thickness exceeds that specified. (For all items specified or required to be practically free, less than 75 percent of lean exposed on edge of chop).
127	Evidence of oily, dark and/or coarse-textured pork.	161	Item breaks completely apart when suspended from a point no less than 0.5 inch from outer edge. (Not applicable to Item Nos. 1513, 1596)
128	Uncured or unsmoked areas 1.0 sq. inch or more.	196	Not practically free from moisture pockets, smokehouse residue, encrusted salt or gelatinous material.
263	Ventral edge of rib and loin items exceeds requirement by 0.2 inch or more.	198	Evidence of under or over cooking. (Item Nos. 1513, 1596)

1/ No more than a small amount of suitable lean may be removed from properly prepared cuts prior to production of the portion cut items (i.e., chops may not be produced only from the anterior portion of a loin.) The AMS agent shall determine the supervision necessary to assure all suitable lean is used.

2/ For Item No. 1596, the examination for defect 260 shall be as described in the item description.

TABLE 500 M

The following defects apply to Item No. 538A, 539, 541, 550A. Sample unit shall be 1 pound of adjacent slices.

101	Skin which measures 0.5 inch or more in one dimension and 0.2 inch in a second dimension (measured at right angles to each other) on 3 or more slices.	210	Three or more slices exceed the length requirement by 1 inch or more.
104	Bone measuring 0.5 inch or more in any dimension on 3 or more adjacent slices.	211	Three or more slices failing to meet the minimum length requirement by 1 inch or more.
204	Bone measuring 0.3 inch or more in any dimension on 2 or more adjacent slices.	212	Two or more slices containing a bruise measuring more than 0.3 inch in any dimension.
105	Cartilage measuring 0.5 inch or more in any dimension on 3 or more adjacent slices.	213	Slice folded over or under adjacent slices for a distance of 3 or more slices.
205	Cartilage measuring 0.3 inch or more in any dimension on 2 or more adjacent slices.	214	Presence of uncured area on 2 or more slices measuring more than 0.5 inch in any dimension. (Score 1 per sample unit)
116	Slice count not as specified.	215	Three or more slices exceed the width requirement by 0.25 inch or more.
118	Two or more slices containing dark, seedy mammary tissue more than 0.3 inch in any dimension.	216	Three or more slices which fail to meet the minimum width requirement by 0.25 inch or more.
119	Diameter of the Longissimus dorsi less than 2 inches. (Item No. 550A)	219	Splits or holes in casing/package material more than 0.5 inch long or when a required vacuum has been lost.
121	Three or more adjacent slices failing to show the specified percentage of lean muscle on the face side (opposite of skin side) of the slice.	225	Evidence of teat line. (Item No. 538, 538A)
208	Separation of more than half the length of 3 or more adjacent slices.	244	Break more than one half the width of the slice on three or more adjacent slices.
209	Presence of comb hanger marks on 2 or more slices.		

TABLE 500 N

The following defects apply to item Nos. 1513 and 1596 prior to grinding and further processing into the end item. Sample unit shall be a minimum of 10 pounds.

- | | | | |
|-----|---|-----|---|
| 104 | Bone is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other). | 218 | Popliteal, prescapular, or prefemoral lymph glands, and/or any exposed lymph gland 0.3 inch or more in one dimension and 0.1 or more in a second dimension. |
| 208 | Bone is 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other). | 219 | Kidney, pelvic, or heart fat having a surface area measuring 2.0 square inches or more and 0.5 inch or more in depth at any point. |
| 105 | Cartilage is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other). | 220 | Diameter of blood vessel when only a cross-section is exposed is 1.0 inch or more in any dimension or exposed blood vessel is 1.0 inch or more in length and 0.5 inch or more in diameter. |
| 209 | Cartilage is 0.3 inch or more but less than 1.0 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other). | 223 | Presence of 2 or more pieces of any size with more than 50 percent of the surface area composed of heavy opaque connective tissue, bone, cartilage, or calcified periosteum (do not score if defects 104, 208, 105, 209, or 211 are scored for those pieces). |
| 163 | Presence of enlarged, soft, porous, dark, or seedy mammary tissue. | 292 | Bruise is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension. |
| 211 | Calcified (scratchy) periosteum is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other). | 293 | Blood clot is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension. |
| 214 | The tendinous ends of shanks cut to a point where a cross-sectional cut exposes less than 75 percent lean tissue. | 194 | Presence of spinal cord 0.5 inch in any dimension. |

GLOSSARY
IMPS SERIES 500 GUIDE TO DEFECT APPLICATION
GUIDE TO THE MOST COMMONLY ASKED DEFECT QUESTIONS

DEFECT

107 A small amount or more of lean removed from major muscle(s).

A small amount of lean is considered to be at least 4 percent of the weight of the item being evaluated. This defect shall be applied when a subjective determination assesses that at least 4 percent of the weight of the item has been removed from major muscle(s).

199 Exhibiting more than a slight amount of dripping or exudation of moisture on the cut surface.

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

205 Presence of score more than 0.5 inch in depth at deepest point, and when depth is multiplied by the length, is equal to or greater than 2.

Scores affect the slicing of the item and shall be recorded as a defect when the measurement taken at the single deepest point exceeding 0.5 inches deep is multiplied by the total length of the score and the result equals 2 or more. The score need not exceed 0.5 inches for the full length to be recorded as a defect.

219 Splits or holes in casing/packaging material more than 0.5 inch long or when a required vacuum has been lost.

This defect is applicable to items which when required to be vacuum packaged, have lost their vacuum, regardless of the size of the hole. Defect shall be scored only once per sample unit.

221 More than a slight amount, but less than a small amount, of lean removed from major muscle(s).

A small amount of lean is considered to be at least 4 percent and a slight amount is considered to be 2 percent of the weight of the item being evaluated. This defect shall be applied when a subjective determination assesses that at least 2 percent but not more than 4 percent of the weight of the item has been removed from major muscle(s).

GLOSSARY

127 Evidence of oily, dark and/or coarse-textured, pork.

This defect shall be scored when any one of the characteristics listed above are evident.

297 Item not properly netted or tied when specified.

When netted, the item shall be fully enclosed within the net with no protruding ends. This defect shall be scored when any portion of the item extends beyond the end of the netting material.

118 Two or more slices containing dark, seedy mammary tissue more than 0.3 inch in any dimension.

"Seedy Mammary Tissue" is a condition which comes from a lactating female which has absorbed soil and dirt particles through the teat opening. The "seedy" condition will be evident in the fat surrounding and dorsal to the teat itself and will reveal small to large clusters of small dark flecks.

291 Presence of tag that is 1.0 inch or more in any dimension and will not support the weight of the steak/chop when suspended.

A "tag" is a loose piece of meat 1 inch or longer which is attached at one end to a steak or chop. Shall be scored as a defect if the "tag" will not support the weight of the item when suspended by the unattached end.

137 More than a slight two-toned color.

Two-Toned color is defined as a color variation between two or more different muscle groups as identified on the cut surface of an item. Unless otherwise specified, a "slight" two-toned color is acceptable.

128 Uncured or Unsmoked areas 1.0 sq. inch or more.

This condition will be most evident on the cut surface of the item, however the condition may also exist on the exterior surface. Uncured or unsmoked areas will appear as a pale, lighter colored area as compared to the surrounding muscles and will vary in size depending on the severity. The area affected will have the appearance more indicative of raw fresh meat and should be a clearly evident condition before being recorded as a defect.

196 Not practically free from smokehouse residue, encrusted salt or gelatinous material.

Shall be scored as a defect if more than a very slight amount is in evidence.

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**INDEX FOR CURED, DRIED, SMOKED,
AND FULLY-COOKED BEEF PRODUCTS - SERIES 600**

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601.....	600A	618.....	600C
602.....	600A	619.....	600C
603.....	600A	620.....	600C
604.....	600A	621.....	600A
605.....	600A	622.....	600C
606.....	600A	623.....	600A
606A.....	600A	623A.....	600A
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608.....	600A	625.....	600A
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611.....	600D	627.....	600A
612.....	600D	628.....	600A
613.....	600B	629.....	600A
614.....	600B	630.....	600A
		631.....	600E

TABLE 600 A

The following defects apply to Item Nos. 600, 601, 602, 603, 604, 605, 606, 606A, 607, 608, 609, 611, 621, 623, 623A, 624, 625, 626, 627, 628, and 630. (Sample Unit shall be one item or one pound of slices as applicable)

101	Uncured/uncooked (as applicable) area(s) 1.0 square inch or more in size.	134	Semitendinosus severed more than a minor amount on either end. (Item No. 608)
201	Uncured/uncooked (as applicable) area(s) less than 1.0 square inch in size.		
102	Maximum surface fat at any point exceeding the depth specified.		
103	Average surface fat exceeding the depth specified.		
104	Not practically free of fat on the inside surface of the deep pectoral muscle.		
105	Item not practically free of surface and seam fat. (Item Nos. 624, 625)		
106	Fat between superficial pectoral and the deep pectoral muscles exceeding 0.25 inch in thickness at any point. (Item No. 601A)		
107	Evidence of dark cutting or callused beef.		
108	A small amount or more of lean removed from major muscle(s).		
109	Presence of adjacent cut(s) exceeding 4 percent of cut weight.		
110	The weight of the deep pectoral muscle is less than 55 percent of the weight of the sample unit. (Item No. 601A)		
111	Sample unit does not hold together as an intact unit when removed from the can. (Item No. 600)		
112	Bone, cartilage or scratchy periosteum measuring 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension.		
203	Bone, cartilage or scratchy periosteum measuring 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension.		
131	Sacrosiatic ligament measuring 1.0 inch or more one dimension and 0.2 inch or more in a second dimension.		
132	Prepubic tendon measuring 1.0 inch or more length.		
133	Backstrap measuring 1.0 inch or more one dimension and 0.2 inch or more in a second dimension.		

- 196 Not practically free from smokehouse residue, encrusted salt and/or rendered fat.
- 202 Presence of score more than 0.5 inch in depth at deepest point and when depth multiplied by the length is equal to or greater than 2.
- 204 Texture not as specified. (Item. No's 600, 617, 621)
- 206 All cut separations not forming an approximate right angle with the skin surface.
- 212 The thin tissue edge of the web muscle (Superficial Pectoral) not trimmed to expose the lean meat. (Item. No's 601, 601A)
- 218 Popliteal and/or any exposed lymph gland measuring 0.3 inch or more in one dimension and 0.1 inch or more in a second dimension.
- 219 Splits or holes in casing/packaging material more than 0.5 inch long or when a required vacuum has been lost.
- 224 Tendinous ends surrounding the patella not removed to expose at least 75% lean.
- 292 Bruise measuring 1.0 inch or more in one dimension and 0.2 inch in a second dimension.
- 293 Blood clot measuring 1.0 inch or more in one dimension and 0.2 inch in a second dimension.
- 294 Item not netted or tied as specified.
- 295 Presence of dehydrated surfaces and/or any (opaque) heavy connective tissue measuring 1.0 square inch or more.
- 296 Product not within specified weight range.
- 298 Cut not practically free from bone dust, hook marks, air holes and/or pockets of moisture.
- 299 Cut not free of ragged edges. (Defect is scored when combined weight of the portion(s) of the ragged edges extending more than one inch from point of attachment exceeds 1.0 percent of the weight of the cut.)

TABLE 600 B

The following defects apply to Item No.'s 613, 614. (Sample Unit shall be one item.)

113	Trachea extends more than 0.5 inch in length.	202	Presence of score more than 0.5 inch in depth at deepest point and when depth multiplied by the length is equal to or greater than 2.
114	Hyoid bone and/or epiglottis not removed. (Item No. 615)	290	More than a slight amount of discoloration other than natural pigmentation.
133	More than a small amount of the tip end of the tongue removed.	291	Tongue not predominately white to light grey.
134	More than a slight amount of the tongue root remaining.	292	Bruise measuring 1.0 inch or more in one dimension and 0.2 inch in a second dimension.
196	Not practically free from smokehouse residue or encrusted salt.	293	Blood clot measuring 1.0 inch or more in one dimension and 0.2 inch in a second dimension.
200	Not practically free of glandular tissue.		

TABLE 600 C

The following defects apply to Item No.'s 617, 618, 619, 620, 622. (Sample Unit shall be one item or one pound of slices as applicable.)

101	Uncured/uncooked (as applicable) area(s) 1.0 square inch or more in size.	206	Slices per inch less than specified. (Not applicable to Item No. 620)
201	Uncured/uncooked (as applicable) area(s) less than 1.0 square inch in size.	207	More than 3 slices showing string or hanger marks. (Not applicable to Item No. 620)
104	Not practically free of fat.	210	Percentage of full intact slices within a sample unit (by weight) is less than that specified. (Not applicable to Item No. 620)
112	Bone or cartilage measuring 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension.	219	Splits or holes in casing/packaging material more than 0.5 inch long or when a required vacuum has been lost.
203	Bone or cartilage measuring 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension.	292	Bruise measuring 1.0 inch or more in one dimension and 0.2 inch in a second dimension.
196	Not practically free of encrusted salt, smokehouse, or other product residue.	293	Blood clot measuring 1.0 inch or more in one dimension and 0.2 inch in a second dimension.
204	Texture not as specified.	296	Weight range not as specified.
205	Sample unit contains more than a small amount of shredded or machine scrap pieces. (Not applicable to Item No. 620)		

TABLE 600 D

The following defects apply to Item Nos. 611 and 612. Sample unit shall be 5 lbs.

101	Uncured or Unsmoked areas 1.0 sq. inch or more.	130	More than 10 percent, by weight, of the sample unit fails to meet the area and/or thickness requirement. (Item No. 611)
104	More than 10 percent, by weight, of sample unit consists of pieces that are not practically free of fat.	196	Not practically free from smokehouse residue, encrusted salt.
105	More than 10 percent, by weight, of sample unit consists of pieces that have more than a small amount of inter and/or intramuscular fat.	218	Popliteal, prescapular, or prefemoral lymphglands, and/or any exposed lymph gland 0.3 inch or more in one dimension and 0.1 or more in a second dimension.
112	Bone is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	220	Presence of exposed blood vessels 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension (measured at right angle to each other).
203	Bone is 0.2 inch or more but less than 0.5 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	223	Presence of two or more pieces of any size with more than 50 percent of the surface area composed of heavy (opaque) connective tissue. (Do not score if defect 211 is scored.)
211	Calcified (scratchy) periosteum is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	258	Presence of two or more acceptable size pieces that consist entirely of fat (Do not score if defect 104 is scored in sample unit).
115	Cartilage is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	292	Bruise is 1.0 inch or more in one dimension and 0.2 inch or more in a second dimension.
215	Cartilage is 0.3 inch or more but less than 1.0 inch in one dimension and 0.2 inch or more in a second dimension (when measured at right angles to each other).	293	Blood clot is 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension.
129	More than 25 percent, by weight, of the sample unit fails to meet the piece size requirement specified by the purchaser. (Item No. 612)		

TABLE 600 E

IMPS Item No. 631 - CHARBROILED BEEF PATTIES

Sample units shall consist of 10 patties each.

Defects

101 Evidence of undercooking or overcooking. 1/

102 Sample unit weighing outside a ∇ 5.0 percent weight tolerance range. 1/ 2/

103 Shape of patties not round or oval and uniform in thickness. 1/

104 Presence of broken, cracked, or folded patty.

1/ Shall not be scored more than once per sample unit.

2/ To determine weight range tolerance, the grader shall multiply the declared patty weight by 10 (based on 10 patties per sample unit). The value for 10 declared patty weights shall be multiplied by 0.05 (5 percent). Five percent of the value of 10 declared patty weights shall be subtracted to provide for the lower limit and added to provide for the maximum limit (i.e., if declared cooked patty weight is 2.5 oz. then the acceptable range for 10 patties will be 23.75 oz. to 26.25 oz.).

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TABLE 700 A

The following defects are applicable to variety meats and edible by-products except Item No. 731 and 732. A sample unit shall be one cut or portion item as applicable. For sliced liver Items No. 702, 705, and 708, a sample unit shall be 10 pounds. For Item No. 723, and 724 the sample size shall be 0.5 pound.

100	Liver slice not practically free of sawdust.	210	Dark internal lining exceeds an area more than 1 sq. inch. (Item No. 715, 715A, 729)
101	Bone or cartilage measuring 0.5 inch or more in any dimension.	211	Heavy connective tissue exceeding an area of 1.0 sq. inch.
201	Bone or cartilage measuring less than 0.5 inch but more than 0.3 inch in any dimension.	212	Capsule membrane surrounding the kidney exceeding an area of 1.0 sq. inch.
103	Presence of broken slice. (Two or more separate pieces.)	213	Pizzle cord and/or ureter exceeding 0.5 inch or more from the surface of the kidney.
104	Color not as specified.	214	Posterior end of the tail not "tipped" to remove two to three coccygeal vertebrae. (Item No. 721)
105	Item exceeds specified fat requirement.	215	Evidence of more than a minor amount of "heart-cap" remaining (auricles, arteries, and gristly material.) (Item No. 720)
106	Heart has been excessively scored affecting slicing.	216	More than a minor amount of glandular material or tongue root remaining. (Item No. 716 and 717)
107	Cheek meat and head meat not practically free of lip material, lymph nodes, and salivary glands. (Score only once per sample unit)	217	Trachea (windpipe) measuring 0.5 inch or more in length.
202	Bruise 1.0 inch or more in any dimension.	218	Lymph nodes and ducts lying along the liver wall not trimmed even with the surface.
203	Bloodclot 1.0 inch or more in any dimension.	219	More than a minor amount of the tip end of the tongue or liver has been removed.
204	Item fails to meet specified weight range.	220	More than 0.5 sq. inch of dehydration or freezer burn.
205	Weight of <u>portion cut</u> not within tolerance permitted. (Item No. 703)	221	Presence of score more than 0.5 inch in depth at deepest point, and when depth is multiplied by the length, is greater than 2. (Applicable only to liver, tongue, and kidney items.)
206	Liver skin greater than 1.0 inch in one dimension and 0.2 inch in a second dimension. (When measured at right angles to each other.) (Item 703)	222	Spinal cord extends more than 0.5 inch posterior to pons. (Item No. 725)
207	Thickness uniformity of portion cut not within tolerance.	223	Base muscle of the tongue not smoothly removed. (Item No. 717)
208	Thickness of portion cut varies more than tolerance.	224	Item not practically free of holes or hook marks.
209	Presence of blood vessel measuring 0.5 inch or more in one dimension and 0.2 inch or more in a second dimension. (When measured at right angles to each other.)		

Unless otherwise specified by the purchaser, the AQL's in TABLE I shall be used for all of the items listed except sliced or portion items. The accept (AC) and reject (RE) criteria for the respective AQL's are within TABLE I-A. TABLE I-B shall be used for examination items which have been rejected and reworked. Unless otherwise specified by the purchaser, the AQL in TABLE II shall be used for sliced and portion cut items. The accept (AC) and reject (RE) criteria for the respective AQL are within TABLE II-A. TABLE II-B shall be used for examination of sliced or portion cut items which have been rejected and reworked.

**QUALITY ASSURANCE PROVISIONS
INDEX FOR IMPS SAUSAGE PRODUCTS SERIES - 800**

ITEM NUMBER	PRODUCT NAME	DEFECT TABLE
800	FRANKFURTERS	800B - LINK
801	BOLOGNA	800A - STICK 800E - SLICED
802	PORK SAUSAGE	800B - LINK 800D - BULK
802A	PORK SAUSAGE, PATTIES	800E - PATTY
802B	PORK SAUSAGE, COOKED	800E - PATTY 800F - COOKED CRUMBLES
802C	WHOLE HOG PORK SAUSAGE	800B - LINK 800D - BULK 800E - PATTY 800F - COOKED CRUMBLES
803	LIVER SAUSAGE	800A - STICK
804	COOKED SALAMI	800A - STICK 800E - SLICED
805	MINCED LUNCHEON MEAT	800A - STICK 800E - SLICED
806	LEBANON BOLOGNA	800A - STICK 800E - SLICED
807	THURINGER	800A - STICK 800E - SLICED
808	DRY SALAMI	800A - STICK 800E - SLICED
809	CERVELAT	800A - STICK 800E - SLICED
810	BREAKFAST SAUSAGE	800B - LINK 800D - BULK
811	SMOKED SAUSAGE	800B - LINK
812	NEW ENGLAND BRAND SAUSAGE	800A - STICK
813	POLISH SAUSAGE	800B - LINK
814	MEAT LOAVES	800C - LOAF
815	MEAT FOOD PRODUCT LOAVES	800C - LOAF
816	KNOCKWURST	800B - LINK
817	BREAKFAST SAUSAGE, COOKED	800B - LINK
818	ITALIAN SAUSAGE	800B - LINK
819	HAM LINKS	800B - LINK
820	HEAD CHEESE	800C - LOAF
821	PEPPERONI	800A - STICK
822	BRATWURST	800B - LINK
822A	BRATWURST PATTY	800E - PATTY
824	PORK RIB SHAPE PATTY	800E - PATTY
825	CANNED LUNCHEON MEAT	800D
826	SCRAPPLE	800G

NOTE - Any defect application question pertaining to the defects listed on Tables 800A through 800G should refer to the "Defect **Application Guide**" beginning on page 12 of this document.

TABLE 800A - STICK ITEMS

The following defects are applicable to items 801, 803, 804, 805, 806, 807, 808, 809, 812, 821. Sample unit shall be 1 stick.

External Product Characteristics <u>1/</u>		
100	Lacks good resiliency typical of the product. (Not applicable to Item No. 803, 808, 809, 821)	153 Diameter not within range specified. (Measure no closer than 2.5 inches from the end of the stick)
101	Casing has a rupture or split 1 inch or more in length.	154 Diameter uniformity not as specified.
102	More than a slight amount of dry surface mold present. (Item No. 806, 807, 808, 809, 821)	155 Bone particle measuring 0.3 inch or more in one dimension and more than 0.1 inch in a second dimension.
103	Weight not within range specified.	156 Color not as specified.
104	Casing not compactly stuffed with product.	157 Aroma not typical of the product.
204	Casing having a rupture or split measuring 0.3 inch or more but less than 1 inch in length.	158 Flavor not typical of the product. (Applicable to fully cooked product only)
205	Casing end extending more than 1.0 inch beyond fastening.	159 One or more pieces of material, other than bone, measuring 0.5 inch or more in any dimension which will not break up or disintegrate when subjected to pressure from the flat side of a knife or spatula.
206	Exterior fat streak exceeding 1.5 inches in length and 0.5 inch in width for the full length.	252 Any individual cut surface having more than 3 pockets of fat, gelatin, and/or air that individually measures 0.3 inch or more but less than 0.5 inch in length and 0.3 inch or more but less than 0.5 inches in width. (Fat defect not applicable to Item No. 808)
207	More than a slight amount of smokehouse residue and/or greasy buildup on the exterior of the casing.	253 Fat particles not evenly distributed.
208	Fat cap at either end, deeper than 0.5 inch.	254 Fat particles which are yellow in color. (Item No. 808)
209	Gelatin cap at either end, deeper than 0.5 inch. <u>2/</u>	255 One or more pieces of material, other than bone, measuring 0.3 inch or more but less than 0.5 inch in any dimension, which will not break up or disintegrate when subjected to the pressure from the flat side of a knife or spatula.
Internal Product Characteristics <u>1/</u>		
250	Peppercorns not in evidence on either cut surface. (Item No. 804)	256 Bone particle measuring less than 0.3 inch in any dimension.
150	Lacks good cohesion typical of the product.	
151	Texture not as specified.	
152	Any individual cut surface having more than 1 pocket of fat, gelatin, and/or air measuring 0.5 inch or more in length and 0.5 inch or more in width.	

1/ Acceptability of product with respect to the presence of foreign material shall be determined by the involved AMS agent except that, for product produced in a plant operating under the Regulations Governing the Meat Inspection of the USDA, this determination shall be made by a USDA Meat Inspection Program Employee.

2/Not applicable to Items 808, 809, and 803.

TABLE 800B - LINK ITEMS

The following defects are applicable to link items: 800, 802, 802C, 810, 811, 813, 816, 817, 818, 819, 822. Sample unit shall be 1 pound.

Characteristics ^{1/}		External Product	156	Color not as specified.
100	Lacks good resiliency typical of the product.		157	Aroma not typical of the product.
101	Link has a split or rupture measuring more than 0.3 inch long.		158	Flavor not typical of the product. (Applicable to fully cooked product only)
103	Specified number of links per pound weighs less than .95 pound.		159	One or more pieces of material, other than bone, measuring 0.3 inch or more in any dimension which will not break up or disintegrate when subjected to pressure from the flat side of a knife or spatula.
103A	Specified number of links per pound weighs more than 1.05 pounds.		164	Uniformity of length not as specified. (An additional \pm 0.5 inch length tolerance above that already specified shall be allowed when natural hog or sheep casings have been specified by the purchaser).
107	Link is abnormally wrinkled or shaped.			
108	Link is broken or cut.			
205	Casing material extends 0.5 inch or more beyond the end of product.	165		Length not as specified. (An additional \pm 0.5 inch length tolerance shall be allowed when natural hog or sheep casings have been specified by the purchaser).
206	Exterior fat streak exceeding 0.5 inch in length and 0.5 inch in width.			
208	Link has a fat or gelatin cap.		252	Any individual cut surface has more than 3 pockets of fat, gelatin, and/or air, that individually measures 0.2 inch or more but less than 0.4 inch in any dimension. (Not applicable to Item No. 810, 818 or 822)
210	Presence of casing material 0.5 inch or more in any dimension when the item is specified to be skinless.			
	Internal Product Characteristics ^{1/}		253	Uneven distribution of fat particles.
150	Lacks good cohesion typical of the product.		255	One or more pieces of material, other than bone, measuring less than 0.3 inch in any dimension which will not break up or disintegrate when subjected to pressure from the flat surface of a knife or spatula.
151	Texture of the link not as specified.			
152	Any individual cut surface has more than 1 pocket of fat, gelatin and/or air measuring 0.4 inch or more in any dimension.		256	Bone particle measuring less than 0.3 inch in any dimension.
154	Uniformity of diameter not as specified.			
155	Bone particle measuring 0.3 inch or more in any dimension.			

^{1/} Acceptability of product with respect to the presence of foreign material shall be determined by the involved AMS agent except that, for product produced in a plant operating under the Regulations Governing the Meat Inspection of the USDA, this determination shall be made by a USDA Meat Inspection Program employee.

TABLE 800C - LOAF ITEMS

The following defects are applicable to items: 814, 815, 820. Sample unit shall be 1 loaf.

	External Product Characteristics <u>1/</u>	155	Bone particle measuring 0.3 inch or more in one dimension and more than 0.1 inch in a second dimension.
100	Lacks good resiliency typical of the product.		
101	Loaf not encased or wrapped.	156	Color not as specified.
103	Weight of the item is not within range specified.	157	Aroma not typical of the product.
107	Unduly distorted loaves affecting their usability.	158	Flavor not typical of the product. (Applicable to fully cooked product only)
108	Loaf has a broken corner or surface break measuring 2 inches or more in length and 0.3 inch or more in depth.	159	One or more pieces of material, other than bone, measuring 0.5 inch or more in any dimension which will not break up or disintegrate when subjected to pressure from the flat side of a knife or spatula.
109	Blackened and/or blistered surface area measuring 2 square inches or more.		
110	Loaf shape not as specified.	163	Piece size of component ingredients (pickle, olive, etc.,) not easily distinguishable when viewed from the cut surface. (Item No. 815)
204	Loaf has a broken corner or surface break measuring 1 inch or more but less than 2 inches in length and 0.3 inch or more in depth.	252	Any individual cut surface having more than 4 pockets of fat, gelatin, and/or air that individually measures 0.3 inch or more but less than 0.5 inch in any dimension. <u>2/</u>
207	More than a slight amount of a greasy buildup (rendered fat) on the surface of the loaf.		
211	Blackened and/or blistered surface area measures at least 1 but less than 2 square inches.	253	Uneven distribution of fat particles.
		255	One or more pieces of material, other than bone, measuring 0.1 inch or more but less than 0.3 inch in any dimension which will not break up or disintegrate when subjected to the pressure from the flat side of a knife or spatula.
	Internal Product Characteristics <u>1/</u>		
150	Lacks good cohesion typical of the product.		
151	Texture not as specified.	256	Bone particle measuring less than 0.3 inch in any dimension.
152	Any individual cut surface has more than 1 pocket of fat, gelatin, and/or air measuring 0.5 inch or more in any dimension. <u>1/</u>	257	Uneven distribution of components. (Item 815)
154	Diameter uniformity not as specified. (Measurement should be taken no closer than 2.5 nches from the end of the loaf)		

1/ Acceptability of product with respect to the presence of foreign material shall be determined by the involved AMS agent except that, for product produced in a plant operating under the Regulations Governing the Meat Inspection of the USDA, this determination shall be made by a USDA Meat Inspection Program employee.

2/ Not applicable to Item No. 820.

TABLE 800D - PORK SAUSAGE, BULK OR CANNED LUNCHEON MEAT

The following defects are applicable to canned or bulk packed Items 802, 802C, 810, 825. Sample unit shall be 1 can, roll or bag.

External Product Characteristics <u>1/</u>		255	Two or more pieces of material, other than bone, measuring 0.3 inch or more but less than 0.5 inch which will not break up or disintegrate when subjected to pressure from the flat side of a knife or spatula.
204	Casing (when specified) has a rupture or split measuring 0.3 inch or more but less than 1 inch in length.		
205	Casing (when specified) end more than 1.0 inch in length beyond clip.	256	Bone particle measuring less than 0.3 inch in any dimension.
101	Casing (when specified) has a rupture or split 1 inch or more in length.	151	Texture not as specified.
103	Weight not within in range specified.	152	Any individual cut surface has more than 3 pockets of fat, gelatin and/or air measuring 0.4 inch or more in any dimension. (Item No. 825)
104	Casing (when specified) not compactly stuffed with product.	153	Diameter not as specified.
111	Presence of string.	155	Bone particle measuring 0.3 inch or more in one and more than 0.1 inch in a second dimension.
112	Product, when removed from can, does not come out as intact core. (Item 825)	156	Color not as specified.
113	Presence of fat covering more than 10 percent of the outer core surface. (Item 825)	157	Aroma not typical of the product.
114	Can size not as specified. (Item No. 825)	159	One or more pieces of material, other than bone, measuring 0.5 inch or more in any dimension which will not break up or disintegrate when subjected to pressure from the flat side of a knife or spatula.
Internal Product Characteristics <u>1/</u>			
252	Any individual sliced surface has more than 3 areas of fat, gelatin, and/or air that individually measures 0.3 inch or more but less than 0.5 inch in length and 0.3 inch or more but less than 0.5 in width. (Item No. 825)	160	Product does not yield an intact 0.2 inch thick slice (e.g., crumbling or separation). Determined only once per sample unit. (Item No. 825)

1/ Acceptability of product with respect to the presence of foreign material shall be determined by the involved AMS agent except that, for product produced in a plant operating under the Regulations Governing the Meat Inspection of the USDA, this determination shall be made by a USDA Meat Inspection Program employee.

TABLE 800E - PORK SAUSAGE PATTY OR SLICED ITEMS

The following defects are applicable to items; 802A, 802B, 822A or any sliced items. Sample unit shall be 1 patty or 1 pound of adjacent slices, as applicable.

External and Internal Product Characteristics ^{1/}	Item No.	Description
103	162	Portion weight, not within range specified. (Item No. 802A, 802B, 822A, 824)
Slices per pound not as specified. (\pm 1 slice tolerance)		
110	163	Piece size of component ingredients (pickle, olive, etc.) not easily distinguishable when viewed from the cut surface. (Item No. 815)
Patty shape not as specified. (Item No. 802A, 802B, 822A, 824)		
111		
Presence of string.		
150	166	Broken patty. (Item No. 802A, 802B, 822A, 824)
Lacks good cohesion typical of the product. (Not applicable to Item No. 802A, 802B, 822)		
151	167	Evidence of over or under cooking. (Item No. 802B)
Texture not as specified.		
152	210	Casing material 0.5 inch or longer in any dimension.
Any individual surface has more than 1 area of fat, gelatin, and/or air measuring 0.5 inch or more in length and 0.5 inch or more in width. (Not applicable to Item No. 820)		
	212	Portion thickness uniformity not as specified. (Item No. 802A, 802B, 822A)
153	250	Peppercorns not in evidence on either cut surface. (Item No. 804)
Diameter of sliced item not as specified.		
154	252	Any individual sliced surface having more than 3 areas of fat, gelatin, and/or air that individually measures 0.3 inch or more but less than 0.5 inch in length and 0.3 inch or more but less than 0.5 in width. (Not applicable to Item No. 808, 820, 802A, 802B)
Diameter uniformity not as specified.		
155		
Bone particle measuring 0.3 inch or more in any dimension.		
156		
Color not as specified.		
157		
Aroma not typical of the product.		
158	253	Uneven distribution of fat particles.
Flavor not typical of the product. (Applicable to fully cooked product only)		
	254	Fat particles which are yellow in color. (Item No. 808)
159	255	One or more pieces of material, other than bone, measuring less than 0.3 inch in any dimension which will not break up or disintegrate when subjected to the pressure from the flat side of a knife or spatula.
One or more pieces of material, other than bone, measuring 0.3 inch or more in any dimension which will not break up or disintegrate when subjected to pressure from the flat side of a knife or spatula.		
	256	Bone particle measuring less than 0.3 inch in any dimension.
161	257	Uneven distribution of components. (Item No. 815)
Diameter of patty not as specified. (\pm 0.5 inch tolerance) (Item No. 802A, 822A)		

^{1/} Acceptability of product with respect to the presence of foreign material shall be determined by the involved AMS agent except that, for product produced in a plant operating under the Regulations Governing the Meat Inspection of the USDA, this determination shall be made by a USDA Meat Inspection Program employee.

TABLE 800F - PORK SAUSAGE, COOKED CRUMBLES

The following defects are applicable to Item 802B, 802C (crumbles). Sample unit shall be 1 pound.

External and Internal Characteristics ^{1/}			
		154	Crumbles not relatively uniform in piece size.
204	Casing (when specified) has a rupture or split 1 inch or more in length.	155	Bone particle measuring 0.3 inch or more in any dimension.
103	Weight not within in range specified.	157	Aroma not typical of the product.
104	Casing (when specified) not compactly stuffed with product.	158	Flavor not typical of the product. (Applicable to fully cooked product only)
111	Presence of string.	159	One or more pieces of material, other than bone, measuring 0.5 inch or more in any dimension which will not break or disintegrate when subjected to pressure from the flat side of a knife or spatula.
255	Two or more pieces of material, other than bone, measuring 0.3 inch or more but less than 0.5 inch which will not break up or disintegrate when subjected to pressure from the flat side of a knife or spatula.	167	Evidence of over or under cooking.
256	Bone particle measuring less than 0.3 inch in any dimension.		

^{1/} Acceptability of product with respect to the presence of foreign material shall be determined by the involved AMS agent except that, for product produced in a plant operating under the Regulations Governing the Meat Inspection of the USDA, this determination shall be made by a USDA Meat Inspection Program employee.

TABLE 800G - SCRAPPLE

The following defects are applicable to Item 826. Sample unit shall be 1 pound.

External and Internal Characteristics ^{1/}

100	Lacks good resiliency typical of the product.	155	Bone particle measuring less than 0.3 inch in any dimension.
103	Weight not within in range specified.	156	Color not as specified.
150	Lacks good cohesion typical of the product.	159	One or more pieces of material, other than bone, measuring 0.5 inch or more in any dimension which will not break up or disintegrate when subjected to pressure from the flat side of a knife or spatula.
	151 Texture not as specified.		
152	Any individual cut surface has more than 1 pocket of fat, gelatin, and/or air measuring 0.5 inch or more in any dimension.	160	Product does not yield an intact 0.2 inch thick slice.

^{1/} Acceptability of product with respect to the presence of foreign material shall be determined by the involved AMS agent except that, for product produced in a plant operating under the Regulations Governing the Meat Inspection of the USDA, this determination shall be made by a USDA Meat Inspection Program employee.

IMPS SERIES 800 DEFECT APPLICATION GUIDE

GUIDE TO THE MOST COMMONLY ASKED DEFECT QUESTIONS

TABLE 800A - STICK ITEMS

- 1. DEFECT 102 - More than a slight amount of dry surface mold.** A slight amount of dry surface mold is considered natural and may be present on IMPS dry or semi-dry sausage Items No's. 806, 807, 808, 809, and 821. The finding of "dry mold" on any other item within the IMPS 800 Series, or the presence of "wet mold" on any item within the IMPS 800 Series, shall be cause for rejection of the entire lot per the material section requirements.
- 2. DEFECT 205 - Casing end extending more than 1.0 inch beyond fastening.** - Defect is scored when excess packaging or casing material is present. The measurement for this defect begins at the outer edge of the closing device and extends to the end of the casing or bag.
- 3. DEFECT 206 - Exterior fat streak exceeding 1.5 inches in length and 0.5 inch in width for the full length.** - The exterior fat defect must be a minimum of 0.5 inch wide for the full distance of 1.5 inches. This defect may be scored more than 1 time per sample.
- 4. DEFECT 207 - More than a slight amount of smokehouse residue and/or greasy buildup on the exterior of the casing.** - "Greasy buildup" is a more descriptive term that equates to rendered fat on the casing material. Not related to fat cap.
- 5. DEFECT 250 - Peppercorns not in evidence on either cut surface. (Item No. 804)** - For this defect only, observe both the right hand and left hand cut surface for the presence of peppercorns. If any peppercorns are seen at all when viewing either cut surface, this requirement shall be considered satisfied.
- 6. DEFECT 150 - Lacks good cohesion typical of the product.** - The evaluation for this defect is made by making a slice 0.3 inch thick and suspending this slice 0.5 inch from the edge. Any separation (product which breaks into two or more pieces) or crumbling of the edges, shall be scored as a defect once per sample unit.
- 7. DEFECT 154 - Diameter uniformity not as specified.** - The diameter uniformity requirement for stick and loaf items is the comparison between the largest and narrowest diameter (measured on the cut surface) of the randomly selected sample units. The sample units shall not exceed ± 0.5 inch (13 mm) in diameter variance between the largest and narrowest measurement. Diameter measurements shall not be made closer than 2.5 inches from the end of the item. Any defect noted shall be scored only once per production lot.
- 8. DEFECT 253 - Fat particles not evenly distributed.** - This defect should only be recorded when the condition is obvious and should not be associated with a fat cap. A defect shall be scored when the overall appearance of the cut surface shows that a proper mix or blend of lean and fat has not been achieved during formulation.

IMPS SERIES 800 DEFECT APPLICATION GUIDE CONT.

TABLE 800B - LINK ITEMS

1. **DEFECT 101 - Link has a split or rupture measuring more than 0.3 inch long.** - To facilitate the removal of the casing from the link using a skinning machine, a slight lengthwise score is permitted and shall not be scored as a defect.

2. **DEFECT 103 - Specified number of links per pound weighs less than 0.95 pound.**
OR

DEFECT 103A - Specified number of links per pound weighs more than 1.05 pounds.

These defects are applicable only to items that have a specified number of links per pound requirement. EXAMPLE 1: A sample unit of frankfurters which are produced to meet a 6 link per pound weight range shall not weigh more than 1.05 pounds OR less than 0.95 pound.

EXAMPLE 2: A sample unit of cooked breakfast sausages which are produced to meet a 19 to 21 links per pound weight range shall not weigh more than 1.05 pounds OR less than 0.95 pound. If 19 links weighs more than 0.95 pound and does not exceed 1.05 pounds the sample will comply with this requirement. If 19 links weighs less than 0.95 pound add one more link. If 20 links weighs more than 0.95 pound and does not exceed 1.05 pounds the sample will comply with this requirement. If 20 links weighs less than 0.95 pound add one more link, etc.

3. **DEFECT 108 - Link which is broken or cut.** - Links shall not be cut in order to make a length requirement.

4. **DEFECT 206 - Exterior fat streak exceeding 0.5 inch in length and 0.5 inch in width.** - Defect is applied when the exterior fat measures 0.5 long x 0.5 wide at any point. This defect shall not apply to link items in which the purchaser has specified artificially colored casings are to be used. Do not score if defect 208 has been scored.

5. **DEFECT 150 - Lacks good cohesion typical of the product.** - This defect is applied when the interior surface of the link is crumbly, adheres to the knife when slicing, or fails to hold together as a stable intact unit when held by one end of the link.

6. **DEFECT 154 - Uniformity of diameter not as specified.** - This is a subjective evaluation that is scored when the diameter uniformity within a single link is not reasonably maintained from end to end. This subjective determination should take into consideration the type of product being manufactured. EXAMPLE: Items manufactured with a natural casing are expected to have more of a diameter variance than a skinless frankfurter.

IMPS SERIES 800 DEFECT APPLICATION GUIDE CONT.

TABLE 800B - LINK ITEMS CONTINUED

7. DEFECT 164 - Uniformity of length not as specified. (An additional ± 0.5 inch length tolerance above that already specified shall be allowed when natural hog or sheep casings have been specified by the purchaser). - Even if no length requirement is specified, the product description still requires the link to be uniform or moderately uniform in length. The length uniformity requirement is the comparison made between the longest and shortest length measurement of the 2 randomly selected links designated from the 1 pound sample unit. The sample unit which is specified in the item description to be "**uniform**" in length shall not exceed ± 0.5 inch (13 mm) in length variance between the longest and shortest measurement taken. Defect shall be scored only 1 time per sample unit. Do not confuse length uniformity with the specified length requirement.

Example: If the manufacturer produces frankfurters that are 5-6 inches long, the comparison between the longest and the shortest of the 2 sample frankfurters taken from the 1 pound sample unit may not vary more than 0.5 inch in length even though both links may be within 5-6 inches specified.

When the product description requires that the item be "**moderately uniform**" in length, the 2 randomly selected links designated from the 1 pound sample unit shall not exceed more than ± 1.0 inch (25 mm) in length variance between the longest and shortest link.

Example: Item No. 810 may be produced as a link item, and the size is expressed as links per pound. The comparison between the 2 randomly selected links designated from the 1 pound sample unit may not vary more than 1.0 inch in length, even though no length is specified. An additional 0.5 inch variance (1.5 inches total) between the longest and shortest link measured shall be permitted on items that utilize a natural hog or sheep casing.

8. DEFECT 165 - Length not as specified. (A ± 0.5 inch length tolerance shall be allowed when natural hog or sheep casings have been specified by the purchaser). - When a length has been specified within the item description, or by the purchaser, a defect shall be scored when either of the 2 randomly selected links from the 1 pound sample unit exceeds the specified length requirement. An exception to this shall be made to allow a ± 0.5 inch tolerance when natural hog or sheep casings have been specified by the purchaser.

EXAMPLE: Item No. 813, Polish Sausage, has a length requirement of 3 to 5 inches. If this item is produced with a natural hog or sheep casing, the length shall include an additional ± 0.5 inch tolerance. NOTE: The samples are still expected to fall within the "Moderately Uniform" length requirement.

9. DEFECT 253 - Uneven distribution of fat particles. - This defect should only be recorded when the condition is an obvious one. However, this defect is not to be associated with a fat cap defect. The defect shall be scored when the overall appearance of the cut surface shows that a proper mix or blend of lean and fat has not been achieved during formulation.

IMPS SERIES 800 DEFECT APPLICATION GUIDE CONT.

TABLE 800C - LOAF ITEMS

- 1. DEFECT 108 - Loaf has a broken corner or surface break measuring 2 inches or more in length and 0.3 inch or more in depth.** - The depth of 0.3 inch or more shall be for the full length of 2 inches before scoring as a defect.
- 2. DEFECT 150 - Lacks good cohesion typical of the product.** - An examination for this defect is made by making a slice 0.3 inch thick and suspending this slice 0.5 inches from the edge. Any separation (product which breaks into two or more pieces) or crumbling of the edges shall be scored as a defect once per sample unit.
- 3. DEFECT 154 - Diameter uniformity not as specified. (Measure no closer than 2.5 inches from the end of the loaf)** - The diameter uniformity requirement for loaf items is the comparison between the widest and narrowest diameter of all samples selected and any defect noted shall be scored 1 time only per lot. The sample unit shall not exceed ± 0.5 inch (13 mm) in diameter variance between the widest and narrowest measurement. Diameter measurements on loaf items shall not be made closer than 2.5 inches from the end of the loaf.
- 4. DEFECT 163 - Piece size of component ingredients (pickle, olive, etc.) not easily distinguishable when viewed from the cut surface. (Item No. 815).** - In items such as meat product loaves, component ingredients (pickle, pimento, olive, etc.) must be of a piece size large enough to be easily seen from the cut surface. The AMS Agent need not identify a piece of green fruit as pickle or olive, etc., since the exact identity of the ingredients shall be controlled by FSIS, MPIO. This defect shall be scored, if the size of the pieces of olive, pickle, etc., are so small as not to be easily and clearly distinguishable as fruit when viewed from the cut surface.
- 5. DEFECT 253 - Uneven distribution of fat particles.** - This defect should only be recorded when the condition is obvious. This defect is to be scored when the appearance of the cut surface shows that a proper mix or blend of lean and fat has not been achieved during formulation.
- 6. DEFECT 257 - Uneven distribution of components.** - An item shall be considered to have the ingredients such as pickle, pimento, olive, etc., "well distributed", if no single area larger than 25 percent, visible from the cut surface, is found to be totally devoid of the required ingredients.

IMPS SERIES 800 DEFECT APPLICATION GUIDE CONT.

TABLE 800D - PORK SAUSAGE BULK, ROLL OR CANNED LUNCHEON MEAT

- 1. DEFECT 112 - Product, when removed from can, does not come out as intact core. (Item 825)** - This defect is meant to measure product cohesiveness so care should be taken when removing the product from the can. The luncheon meat should be removed from the can by opening both ends and pushing the product out.
- 2. DEFECT 113 - Presence of fat covering more than 10 percent of the outer core surface. (Item 825)** - This defect is to be applied as a total of all exterior surface areas.
- 3. DEFECT 160 - Product does not yield an intact 0.2 inch thick slice. Determined only once per sample unit. (Item No. 825)** - An examination for this defect is made by making a slice 0.2 inch thick, and suspending this slice 0.5 inches from the edge. Any crumbling of edges or separation (product which breaks into two or more pieces) shall be scored as a defect once per sample unit.

TABLE 800E - PORK SAUSAGE PATTY OR SLICED ITEMS

- 1. DEFECT 103 - Slices per pound not as specified. (± 1 slice tolerance).** - The number of slices specified per pound, (1 sample unit) shall weigh 1.0 pound ± 1 slice tolerance.
- 2. DEFECT 150 - Lacks good cohesion typical of the product. (Not applicable to Item No. 802A, 802B, 822)** - An examination for this defect is made by suspending a slice 0.5 inch from the edge. Any separation, (product which breaks into two or more pieces) or crumbling of the edges, shall be scored as a defect. May be scored once per slice.

SEE DEFECT APPLICATION GUIDE FOR STICK OR LOAF ITEMS (AS APPLICABLE) FOR FURTHER EXPLANATION OF DEFECTS LISTED FOR SLICED SAUSAGE ITEMS.

TABLE 800F - PORK SAUSAGE, COOKED CRUMBLES

DEFECT 154 - Crumbles not relatively uniform in piece size. - This subjective defect should only be recorded when the piece sizes within the entire one pound sample unit vary more than a minor amount.

TABLE 800G - SCRAPPLE

- 1. DEFECT 160 - Product does not yield an intact 0.2 inch thick slice. Determined only once per sample unit.** - An examination for this defect is made by making a slice 0.2 inch thick, and suspending this slice 0.5 inches from the edge. Any undue separation (product which breaks into two or more pieces) shall be scored as a defect once per sample unit.

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