

USDA COMMODITY REQUIREMENTS

**BFM3
BAKERY MIX PRODUCTS
FOR USE IN DOMESTIC PROGRAMS**

Effective Date: 02/01/2008

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Part 1 COMMODITY SPECIFICATIONS

Section 1.1 COMMODITIES

A. Quality of Bakery Mix.

- (1) All wheat shall be tested for vomitoxin in accordance with procedures approved by Federal Grain Inspection Service (FGIS). Any wheat testing higher than 2 parts per million (p.p.m.) shall not be used in production of the commodity. The final product shall not contain more than 1 p.p.m. of vomitoxin.
- (2) Unless otherwise specified in the solicitation, bakery mix shall meet the requirements specified in the CID A-A-20181A (December 16, 1996) for bakery (biscuit) mix available at <http://www.ams.usda.gov/fqa/aa20181a.htm>, except for the following:
 - (a) Maximum moisture level allowed is increased to 11.5 percent.
 - (b) Shortening shall be a hydrogenated vegetable shortening (excluding palm oil, palm kernel oil, and coconut oil).
 - (c) Specific volume shall be not less than 2.6.
 - (d) Low-fat bakery mix shall meet the nutritional criteria of the Federal Food, Drug, and Cosmetic Act applicable for a low-fat product.
 - (e) Buttermilk or whey may be used in place of nonfat dry milk. If whey is used, it shall be whey protein concentrate as defined in 21 CFR, Part 184.1979c and meet the following requirements:

Whey Protein Concentrate

Item	Requirements	
	Minimum	Maximum
Protein	---	29.0%
Moisture	---	4.0%
Fat	---	3.0%
Maximum ash	---	12.0%
A standard plate count of 50,000 per gram		
A maximum coliform count of 10 per gram		
A negative salmonella per 100 grams		
A maximum scorched particles of 10 per milligram		
A minimum 6.6 ph (1:9 dilution at 20° centigrade)		
The whey shall be a free flowing powder, cream to light yellow in color, and bland in flavor		

Section 1.2 WARRANTY

The bakery mix shall have a shelf life of at least nine (9) months from date of manufacturer. Product shall not be manufactured more than 30 days prior to shipping.

Section 1.3 QUALITY ASSURANCE

- A. The contractor shall perform the product testing and quality analysis to ensure that the product meets the commodity specifications. The results shall be evidenced by a Certificate of Analysis (COA).
- B. Contractors shall notify the Government immediately of lots that fail to meet contract requirements.

Part 2 CONTAINER AND PACKAGING REQUIREMENTS

Section 2.1 GENERAL

This part provides the container specifications and packaging materials requirements used under this contract.

Section 2.2 CONTAINERS AND MATERIALS

- A. **All containers and packaging shall be constructed to meet the requirements of the Food and Drug Administration (FDA) for safe contact with the packaged product. The contractor shall obtain and maintain documentation from the container or packaging material manufacturer to verify that the containers and packaging materials used in this contract were in compliance with the Government’s regulatory requirements for safe contact with food products as required in the Master Solicitation, Part 3, Section A, Number 3.**
- B. **Questions concerning the containers and materials should be directed to:
USDA/FSA/DACO
Room 5755 – South Bldg, STOP 0551
1400 Independence Avenue SW
Washington, DC 20250-0551
ATTN: Packaging**
- C. **If the contractor purchases packaging and container ingredients from a foreign country and/or the package and container is manufactured in a foreign country, the package and container SHALL NOT display country of origin labeling. Phrases similar to but not inclusive of, “Made in [Name of Foreign Country.]” or “Product of [Name of Foreign Country.]” are strictly prohibited.**

Section 2.3 5-POUND CONTAINERS

Five (5) pounds of bakery mix shall be packed in containers of a type normally used in commercial channels and shall meet the following requirements:

- A. Containers shall be constructed with a barrier material (coating, sheet, or ply) to prevent wicking or staining of the primary containers from the shortening in the product. The barrier material shall also prevent the shortening from delaminating adhesives used in the construction of the container.
- B. The container closure shall be secured to prevent the product from leaking out of the containers during distribution.
- C. Closure by means of gummed tape is not acceptable.

Section 2.4 35-POUND BAGS

Thirty-five (35) pounds of product shall be packed into a bag-in-a-box container normally used in commercial channels and shall meet the following requirements:

- A. The bag shall be constructed of three (3) mil low density polyethylene film. After filling, the bag shall be closed with a twist tie or similar closure device which allows re-closure after use.
- B. Each bag shall be packed into a corrugated fiberboard shipping container which conforms to Rule 41, as amended, of the Uniform Freight Classification (UFC) Rules and Regulations and shall be constructed of a minimum 48-pound Edge Crush Test (ECT) double wall corrugated fiberboard.
- C. The shipping containers must be regular slotted containers sized to minimize the headspace between the top of the filled bag and the closed box flaps.

Section 2.5 BALERS

Six (6) 5-pound primary containers shall be packed in baler or corrugated fiberboard shipping containers as follows:

- A. Balers.
 - (1) Balers (paper or plastic) shall provide a compact, solid, and securely held unit to prevent shifting of the bags within the baler during handling, stacking, and shipment.
 - (2) Plastic balers may have holes in the seal area only. These holes are not acceptable if they allow the bags to become loose or fall from the baler.
 - (3) Markings are not required on the plastic baler.
- B. Corrugated Fiberboard Shipping Containers.
 - (1) Shipping containers shall conform to Rule 41, as amended, of the UFC and shall be constructed of a minimum 32-pound ECT corrugated fiberboard. The shipping containers shall be regular slotted containers.
 - (2) Inserts shall be provided for the packaging of primary containers constructed of flexible materials, i.e., bags or pouches. The inserts shall have a height exceeding the box depth by 1/8 to 3/8 inch.

- (3) The closure and sealing of outer flaps must be in accordance with UFC Rule 41, Section 9, as amended. The inner and outer flaps shall be drawn together as closely as possible to ensure a compact and tight pack.

Section 2.6 UNITIZATION REQUIREMENT

Shipments shall comply with the following unitization requirements:

- A. Unless otherwise specified by the Government, all shipments of packaged products shall be unitized (palletized and stretch wrapped).
- B. Pallets shall be:
 - (1) Constructed to facilitate the safe handling and transportation of the packaged product, as a unit, without loss or damage.
 - (2) A Number 2, four-way, reversible flush stringer with no broken runners or slats.
 - (3) Suitable for use in the shipment of food products.
- C. Plastic stretch wrap shall be:
 - (1) Constructed of a plastic film which is to be stretched a minimum of 50 percent beyond its original length when stretched around the pallet load.
 - (2) Applied as tightly as possible around all tiers of the palletized shipping containers. The shipping containers shall be held firmly in place by the stretch wrap.
- D. Pallet loads shall be:
 - (1) Stacked in such a way as to minimize the amount that shipping containers overhang the edges of pallets.
 - (2) Blocked and braced or otherwise loaded into the conveyance in a manner that prevents shifting during transit.

Section 2.7 COMMERCIAL PACKAGING REQUIREMENTS

- A. **Contractors shall supply commercial brand products only and shall certify at the time of submission of an offer that the commercial product being delivered has a history of successful distribution and use in domestic commercial channels and is sold on the commercial market with an established level of customer acceptance.**
- B. **Container and packaging requirements are those used in the current commercial shipping practices and shall comply with:**
 - (1) **Unitization requirement in Section 2.6.**
 - (2) **At contractor's option, a statement such as "Not for Retail Sale" may be printed on the principal display panel of the food label.**

- (3) The manufacturer's lot code/lot identification number shall be shown on the commercial bill of lading.**
- (4) Shipping containers shall be marked to show the maximum safe stacking height. It is the responsibility of the contractor in cooperation with the shipping container manufacturers to determine the safe stacking height.**
- (5) For identification upon receipt at delivery warehouses, all commercial-labeled product shipping documents shall specify "FOR USDA FOOD DISTRIBUTION PROGRAMS."**

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