

August 4, 2022

SECTION 32 SPECIFICATION for WHOLE SHELLED ALMONDS

COMMODITY SPECIFICATION for SHELLED TREE NUTS – April 2020

This specification is for Section 32 Purchases only, unless otherwise stated in the Solicitation/IFB.

The purpose of this document is to revise the specification for Shelled Tree Nuts and replace Amendment 1.

New/revised text is in **blue**.

INDIVIDUAL COMMODITY SPECIFICATIONS

Whole Shelled Almonds

Inspection and Certification for grade must be performed prior to processing and must meet all of the requirements listed below, as well as the current issuances of the Commodity Specification for Shelled Tree Nuts and the Master Solicitation for Commodity Procurement – Domestic Programs (MSCP-D).

- 1. Process Types: The Whole Almonds may be either Natural (Pasteurized) **or** Roasted. The Natural and Roasted process types may not be intermingled within a truckload.**
- 2. Grade: U.S. No. 1**
 - a. All Mission type almonds must meet all the requirements of U.S. No. 1 grade except for an additional 10 percent chip and scratch allowance (20% total) prior to processing.**
- 3. Style - Whole**
- 4. Types (Classification): Nonpareil, California, and Mission.**

All varieties which are classified under the Types Nonpareil, California, and Mission shall be acceptable for purchase by the USDA and are adapted from The Almond Board of California Technical Kit 2015 (abc_technical_kit_2015_0.pdf (almonds.com)).

- 5. Size: Whole style: The following count ranges per ounce are permissible: 18/20, 20/22, 23/25, 25/27, 27/30, 30/32, 32/34, 34/36, 36/40, 34/40, 40/50.**
 - a. When a range in count is specified, the whole kernels shall be fairly uniform in size, and the average count per ounce shall be within the range specified. Doubles and broken kernels shall not be used in determining counts.**

b. Sizes designations may not be intermingled within a truckload.

6. Final Package size: 12/2 lb. For shipments of almonds between the supplier and final packaging point, the bulk containers may be of any size which is mutually agreeable between both parties.

7. Treatment/Fumigation/Pasteurization/Roasting:

The process types Whole Natural (pasteurized) or Roasted almonds shall be so treated as to achieve a 4-log reduction of *Salmonella* bacteria by at least one of the following means: Propylene Oxide (PPO), steam treatment, or heat treatment, such as roasting, drying, pasteurization, or other validated methods as near as possible, but not to exceed 45 calendar days prior to final packaging. Verification that such treatment has been performed must be provided to the SCI Federal or Federal/State inspector.

8. Aflatoxin Requirements and Methods:

Samples for Aflatoxin testing must be drawn by the SCI Federal or Federal-State Inspection Service and certified by the USDA National Science Laboratories or an approved USDA laboratory (see link below). A Certificate of Conformance must be furnished to the Federal or Federal-State Inspector and is valid for 45 calendar days. Samples for Aflatoxin testing must be drawn prior to processing, and must meet the following requirements:

Analysis for:	Requirement	Method
Aflatoxins	<15 ppb	AOAC 991.31 or equivalent

Link for USDA approved laboratories or for USDA laboratory approval for Aflatoxin:

<https://www.ams.usda.gov/services/lab-testing/aflatoxin>

National Science Laboratories, Laboratory Approval and Testing Division
Science & Technology Program
801 Summit Crossing Place, Suite B
Gastonia, NC 28054
Phone: (704) 867-3873 (Main)
Phone: (704) 833-1525 (Direct)
Fax: (855) 296-1230

9. Analytical and Microbiological Requirements and Methods:

Samples for all Analytical and Microbiological testing must be drawn by the SCI Federal or Federal-State Inspection Service and certified by the USDA National Science Laboratories or Safe Food Alliance. A Certificate of Conformance must be furnished to the Federal or Federal-State Inspector is valid for 45 calendar days. Samples for analytical and microbiological testing must be drawn after roasting or fumigation. All samples must meet the following requirements:

Analysis for:	Requirement	Method
Moisture	Roasted - $\leq 3.5\%$ Natural (Pasteurized) - $\leq 6.5\%$	AOAC 925.40 or equivalent method

Free Fatty Acids (FFA)	≤ 1.5% free fatty acid (as oleic)	AOAC 940.28 or equivalent method
Peroxide value (PV)	≤ 5.0 meq peroxide/kg oil	AOAC 965.33 or equivalent method
<i>Aerobic Plate Count</i>	< 10,000 CFU/g	AOAC 996.23 or equivalent
<i>Salmonella spp. (375g)</i>	Negative	BAM Ch 5; AOAC 2013.09 or equivalent
<i>Listeria spp.(375g)</i>	Negative	AOAC 2016.08, 2013.10 or equivalent
<i>Staphylococcus aureus</i>	< 10 CFU/g or less than 3/g using MPN technique	BAM Ch 12; AOAC 2003.07 or equivalent
<i>Escherichia coli</i>	Negative	BAM Ch 4; AOAC 991.14 or equivalent
Yeast & Mold	< 1,000 CFU/g	BAM Ch 18; Pour Plate, AOAC 997.02 or equivalent

Link to Safe Food Alliance: <https://safefoodalliance.com/>

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10. Roasted can be nitrogen flushed or vacuum packed.

11. Shipping, Storage, and Case markings:

- a. The packaged almonds must be shipped and held at an air temperature not to exceed 50 degrees F.
- b. At final destination, the almonds must be stored under refrigeration at 35 to 40 degrees F. and if possible, 40% to 60% relative humidity. This is to ensure an adequate shelf-life. The case markings must read: “STORE UNDER REFRIGERATION 35 TO 40 DEGREES F.”

Bulk product inspected at shipping point destined for packaging into final primary containers (12/2lb bags), must have a “Positive Lot Identified” (PLI) sticker and be received intact by a USDA representative at the receiving facility. The USDA representative will be onsite during final packaging and perform inspection on the finished product to ensure the remainder of the commodity specification requirements are met. The product must be packaged into the 12/2 lb. bags within 45 calendar days of the quality inspection. Both facilities are required to have current SCI Plant Surveys and Food Defense System Safety audits.

12. Truckload case count: 1,540 per truckload.

13. Material Codes and UPC numbers

Shelled Tree Nuts	WBSCM Material	Primary Container	Secondary Container
Almonds Roasted Whole Shelled (12/2 lb.)	100393	7 15001 00393 5	1 07 15001 00393 2

Almonds Natural Whole Shelled (12/2 lb.)	100907	7 15001 00907 4	1 07 15001 00907 1
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All other terms and conditions remain unchanged.