

USDA COMMODITY REQUIREMENTS

**BFM1
BAKERY MIX PRODUCTS
FOR USE IN DOMESTIC PROGRAMS**

Effective Date: 09/01/05

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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 materials shall be manufactured and assembled in the United States. The components that make up the fabricating materials of the containers and packaging materials shall be of U.S. origin to the extent that they are commercially available. Questions concerning the availability of a material should be directed to:
 - USDA/FSA/DACO
 - Room 5755 – South Bldg, STOP 0551
 - 1400 Independence Avenue SW
 - Washington, DC 20250-0551
 - ATTN: Packaging
- B. Constructed to meet the requirements of the Food and Drug Administration (FDA) for safe contact with the packaged product.
- C. 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 requirements.

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

Container and packaging requirements are those used in the current commercial shipping practices and shall comply with:

- A. Domestic origin of containers and packaging materials in Section 2.2.
- B. Unitization requirement in Section 2.6.
- C. At contractor's option, a statement such as "Not for Retail Sale" may be printed on the principal display panel of the food label.
- D. The manufacturer's lot code/lot identification number shall be shown on the commercial bill of lading.
- E. 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.
- F. For identification upon receipt at delivery warehouses, all commercial-labeled product shipping documents shall specify "FOR USDA FOOD DISTRIBUTION PROGRAMS."

Part 3 MARKING REQUIREMENTS

Section 3.1 GENERAL REQUIREMENTS

Primary containers, corrugated fiberboard shipping containers, and paper balers shall be plainly marked in accordance with Exhibits A through D. All markings shall be of sufficient size to stand out prominently. The markings shall be arranged substantially as shown in the exhibits and shall be in direct proportion to the available printing surface. No markings are required on plastic balers.

Section 3.2 5- POUND AND 35-POUND CONTAINERS

- A. All lettering shall be in blue ink.
- B. The applicable nutritional information must be printed in the space provided.
- C. Directions which call for measured ingredients shall be shown in volume measurements (i.e., cups, tablespoons, and teaspoons).

Section 3.3 VENDOR CODE

A vendor code, furnished by the Government, shall appear on all primary containers, corrugated fiberboard shipping containers, and paper balers. The vendor code identifies the contractor but does not always identify the plant of origin. In addition to the vendor code, contractors have the option of printing the plant code on all containers.

Section 3.4 MONTH/YEAR OF PACK

- A. The month/year of pack shall appear on all primary containers having a net weight greater than ten (10) pounds and shall appear on all primary containers, regardless of net weight, when transparent plastic balers are utilized.
- B. The month/year of pack shall appear on all corrugated fiberboard shipping containers and paper balers.
- C. The month/year of pack shall be the month/year of shipment as required under the contract.
- D. A date fill code may be applied in addition to, but not in lieu of, the month/year of pack.

Section 3.5 LOT CODE

A lot code unique to each lot shall be legibly marked on all primary containers, corrugated fiberboard shipping containers, and paper balers. Contractors may use any type of lot coding system provided a unique code is used to identify each lot under a contract. Contractors shall provide the Government's audit personnel or the contracting officer with an explanation of the lot coding system utilized.

Section 3.6 NUTRITIONAL INFORMATION

Nutritional information shall be applied to all primary containers in accordance with the nutrition labeling regulations of the Food and Drug Administration (FDA) as specified in 21 CFR Part 101.

Section 3.7 SAFE STACKING INSTRUCTIONS

Corrugated fiberboard shipping containers shall be marked to show the maximum safe stacking height. This should be expressed as follows: "Do not stack above ___ tiers per pallet, ___pallets high." It is the responsibility of the contractor in cooperation with the shipping container manufacturers to determine the safe stacking height.

Section 3.8 CARRIER REGULATIONS

Containers may be marked with a certification or stamp to indicate compliance with the applicable freight classification or other carrier shipping requirements.

Section 3.9 RECYCLE SYMBOLS

- A. The contractor shall place the recycle symbol and the words "PLEASE RECYCLE" somewhere on the surface of each primary and shipping container which is widely recycled. By "widely recycled," it is meant recycled in most communities. The words "PLEASE RECYCLE" are to be placed under the recycle symbol. The following packaging materials are widely recycled and should be marked with the symbol and statement in accordance with Exhibit I.
- (1) Corrugated fiberboard (cardboard) boxes.
 - (2) Steel (tin) cans.
 - (3) High density polyethylene (e.g., vegetable oil and liquid shortening bottles)
- B. Packaging materials which are not required under the contract to be printed (e.g., certain plastic pouches, bags, and stretch films) need not be marked even though they can be recycled in many communities.

Section 3.10 OTHER MARKINGS

- A. The contractor's company name and/or the container manufacturer's name may be printed on each container as small as possible, yet legibly.
- B. On exhibits where U.S. RDA Percentages are required, it is acceptable for the contractor to place an asterisk beside the nutrient(s) and to footnote on the panel "* content less than 2% U.S. RDA of these nutrients."
- C. No markings other than those permitted under this contract shall appear on containers unless required or approved by the Government.

Section 3.11 CONTAINERS WITH INCORRECT MARKINGS

- A. Any labels, bags, cans, can lids, cases, or any other type of packaging (hereinafter referred to as "containers") displaying incorrect markings may be used under a Government contract provided that the incorrect markings are obliterated and correct markings are applied in a permanent manner with approval of the contracting officer.
- B. The appearance of containers in commercial or other channels either filled or unfilled bearing markings identifying the containers as part of a Government contract may cause the Government expense in determining whether commodities have been diverted from authorized use and in answering inquiries. The contractor shall take all necessary action to prevent the appearance in commercial or other channels of containers and container materials bearing any markings required under a Government contract, including those held by the contractor or others; e.g., overruns, misprints, etc. The contractor shall ensure that any

container from a Government contract that appears in commercial or other channels shall have all markings required under this contract permanently obliterated.

**BAKERY MIX
EXHIBIT A**

BAKERY MIX MARKING REQUIREMENTS FOR 5-LB. PRIMARY CONTAINERS

FRONT PANEL

SIDE PANEL

BAKERY MIX

Insert nutritional information in accordance with the nutrition labeling regulations of the Food and Drug Administration (FDA) as specified in 21 CFR Part 101.

^{1/}
BISCUIT TYPE

DISTRIBUTED BY USDA IN COOPERATION
WITH STATE AND LOCAL OR TRIBAL GOVERNMENTS
FOR DOMESTIC FOOD ASSISTANCE PROGRAMS

NOT TO BE SOLD OR EXCHANGED

NET WEIGHT – 5 POUNDS

Manufactured for the USDA by:

2/

This biscuit mix is the same as
commercially available:

3/

1/ Insert the words “LOW FAT” when applicable.

2/ Insert manufacturer’s name and address.

3/ Manufacturer should insert appropriate brand name.

**BAKERY MIX
EXHIBIT A-1**

BAKERY MIX MARKING REQUIREMENTS FOR 5-LB. PRIMARY CONTAINERS

BACK PANEL

SIDE PANEL

BISCUIT DIRECTIONS

PANCAKE DIRECTIONS

1/

3/

MUFFIN DIRECTIONS

2/

ALL LETTERING SHALL BE IN BLUE INK ONLY.

1/ Manufacturer shall insert directions for making biscuits using manufacturer's biscuit mix.

2/ Manufacturer shall insert directions for making muffins using manufacturer's biscuit mix.

3/ Manufacturer shall insert directions for making pancakes using manufacturer's biscuit mix.

The USDA symbol, Exhibit C, is to be underneath the markings on the side panel of the container and shall be of sufficient size to stand out prominently. The markings shall be arranged substantially as shown in this Exhibit. The markings shall be centered, and the spacing and size of the printing shall be such that each element stands out prominently.

**BAKERY MIX
EXHIBIT B**

BAKERY MIX MARKING REQUIREMENTS FOR 30-LB. SHIPPING CONTAINERS

FRONT PANEL

SIDE PANELS

BAKERY MIX

1/

BISCUIT TYPE

STORE IN A COOL DRY PLACE

DISTRIBUTED BY USDA IN COOPERATION

WITH STATE AND LOCAL OR TRIBAL GOVERNMENTS

FOR DOMESTIC FOOD ASSISTANCE PROGRAMS

NOT TO BE SOLD OR EXCHANGED

6/5 NET WEIGHT – 30-POUNDS

(MONTH/YEAR) 2/

USE NO HOOKS

(TO BE PRINTED ALONG THE
LENGTH OF THE CONTAINER)

BAKERY MIX

1/

BISCUIT TYPE

ALL LETTERING SHALL BE IN BLUE INK ONLY. For identification, insert in a conspicuous place, a company number which will be furnished by the Kansas City Commodity Office.

1/ Insert the words "**LOW FAT**" when applicable.

2/ The month and year of pack shall be the contract shipment month. (Date may be placed on the front or side panel.)

Spacing and size of the printing shall be such that the wording stands out prominently. Side panel markings should be easily read when shipping containers are stacked. The print size for the product name should be larger than the other required markings.

The USDA symbol, Exhibit C, is to be placed on the front or reverse side of the shipping container and shall be of sufficient size to stand out prominently. The markings shall be arranged substantially as shown in this Exhibit. The markings shall be centered, and the spacing and size of the printing shall be such that each element stands out prominently.

**BAKERY MIX
EXHIBIT B-1
BAKERY MIX MARKING REQUIREMENTS FOR 35-LB. CONTAINERS**

FRONT PANEL

SIDE PANELS

BAKERY MIX

1/

BISCUIT TYPE

STORE IN A COOL DRY PLACE

DISTRIBUTED BY USDA IN COOPERATION

WITH STATE AND LOCAL OR TRIBAL GOVERNMENTS

FOR DOMESTIC FOOD ASSISTANCE PROGRAMS

NOT TO BE SOLD OR EXCHANGED

NET WEIGHT 35 POUNDS

(MONTH/YEAR) 2/

BAKERY MIX

1/
BISCUIT TYPE

Insert nutritional information in accordance with the nutrition labeling regulations of the Food and Drug Administration (FDA) as specified in 21 CFR Part 101.

Manufactured for the USDA by:
3/

This biscuit mix is the same as commercially available:

4/

ALL LETTERING SHALL BE IN BLUE INK ONLY. For identification, insert in a conspicuous place, a company number which will be furnished by the Kansas City Commodity Office.

1/ Insert the words "**LOW FAT**" when applicable.

2/ The month and year of pack shall be the contract shipment month. (Date may be placed on the front or side panel.)

3/ Insert manufacturer's name and address.

4/ Manufacturer should insert appropriate brand name.

Spacing and size of the printing shall be such that the wording stands out prominently. Side panel markings should be easily read when shipping containers are stacked. The print size for the product name should be larger than the other required markings.

The markings shall be arranged substantially as shown in this Exhibit. The markings shall be centered, and the spacing and size of the printing shall be such that each element stands out prominently.

**BAKERY MIX
EXHIBIT B-2**

BAKERY MIX MARKING REQUIREMENTS FOR 35-LB. CONTAINERS

BACK PANEL

SIDE PANEL

BISCUIT DIRECTIONS

PANCAKE DIRECTIONS

1/

3/

MUFFIN DIRECTIONS

2/

ALL LETTERING SHALL BE IN BLUE INK ONLY.

1/ Manufacturer shall insert directions for making biscuits using manufacturer's biscuit mix.

2/ Manufacturer shall insert directions for making muffins using manufacturer's biscuit mix.

3/ Manufacturer shall insert directions for making pancakes using manufacturer's biscuit mix.

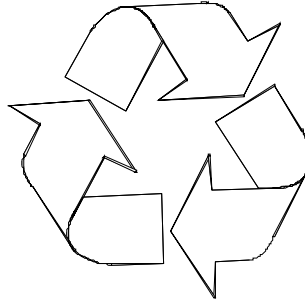
The USDA symbol, Exhibit C, is to be underneath the markings on the side panel of the container and shall be of sufficient size to stand out prominently. The markings shall be arranged substantially as shown in this Exhibit. The markings shall be centered, and the spacing and size of the printing shall be such that each element stands out prominently.

**BAKERY MIX
EXHIBIT C**

USDA SYMBOL



EXHIBIT D
RECYCLABLE SYMBOL





**PLEASE
RECYCLE**


PLASTIC MATERIALS CODE SYSTEM


CODE


MATERIAL


 ----- Poly-Ethylene Terephthalate (PET)
PETE


 ----- High Density Polyethylene
HDPE

 ----- Vinyl/Polyvinyl Chloride (PVC)
V

 ----- Low Density Polyethylene
LDPE

 ----- Polypropylene
PP

 ----- Polystyrene
PS

 ----- All Other Resins
OTHER